

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCR-000889
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 09-Nov-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0851

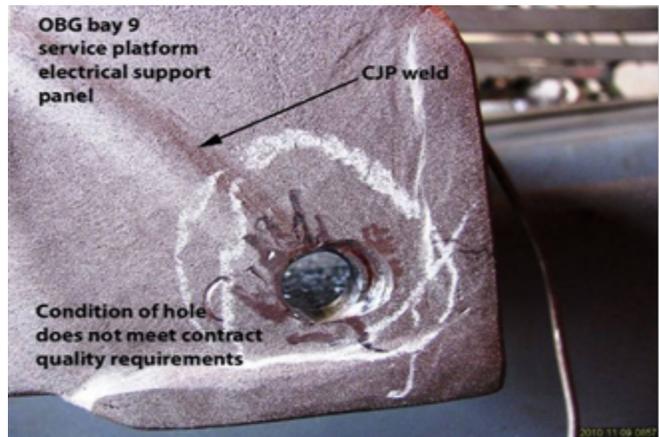
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Service Platform Electrical Panel Support
Procedural	Procedural	Description:	

Reference Description: QA found non-approved drilled holes on the service platform electrical panel support SP6.

Description of Non-Conformance:

- During Quality Assurance (QA) random visual inspection after grit blasting of OBG Service Platform Electrical Panel Support, this Caltrans QA Inspector observed the following issues:
- ZPMC has drilled approximately 15 to 20 holes which were not specified on the approved shop drawings.
 - The additional holes were drilled in a service platform electrical panel support SP6.
 - These holes were added without the Engineer’s approval.
 - Additionally, The holes do not appear to meet the quality requirements of the contract documents.
 - A number of the holes have been drilled into fillet and CJP welds.
 - The approved shop drawings are identified as SPEP1-A.
 - OBG Service Platform Electrical Panel Support components are located at bay#9.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

The Approved Shop Drawing: SPEP1-A

Standard Specifications Section 55-3.01 QUALITY OF WORKMANSHIP

- Workmanship and finish shall be equal to the best general practice in modern bridge shops.

Standard Specifications Section 55-3.12 FINISH

- Portions of the work exposed to view shall be finished neatly...All sharp corners and edges, and edges that are marred, cut or roughened in handling or erection, shall be slightly rounded by grinding or other suitable means.

Standard Specifications Section 55-3.14A

- The finished holes shall be cylindrical and perpendicular...Holes shall be clean cut, without torn or ragged edges.

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 16:00 hours, 11/09/10, Email

Name of Caltrans Engineer notified: Laraine Woo, Ching Chao, Chris Havel

Time and method of notification: 07:15 hours, 11/10/10, Verbal

QC Inspector's Name: Che Shi Gang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Reviewed By: Devey,Jim

SMR

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000846

Subject: NCR No. ZPMC-0851

Dated: 29-Nov-2010

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000849 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the misdrilled holes which overlap with existing welds. Attached is the repair report as well as the NDT performed after to show that it is acceptable.

ZPMC has repaired the misdrilled holes which overlap with existing welds. Attached is the repair report as well as the NDT performed after to show that it is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000849R00;

Caltrans' comments:

Status: CLO

Date: 30-Nov-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Date: 30-Nov-2010

Attachment(s):



No. B-937

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-11-25

REGARDING: NCR-000889(ZPMC-0851)

ZPMC has repaired this missed drilled holes according to the response of TC-RFI as attached. ZPMC is providing the welding repair report and NDT record to engineer to review. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000889(ZPMC-0851)

TC-RFI RESPONSE

B-WR16908

B787-MT-33038

A handwritten signature in black ink, appearing to be "J. W.", is located on the left side of the page.

11/25/2010

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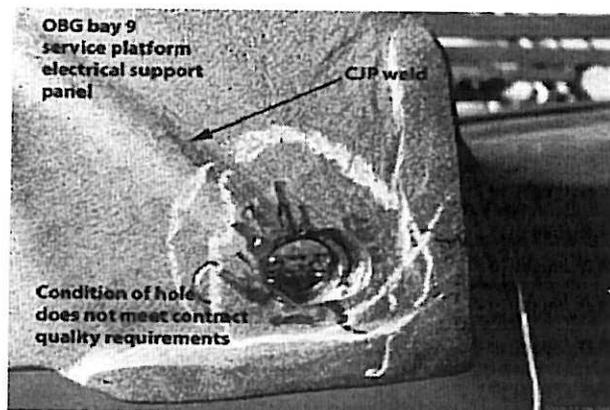
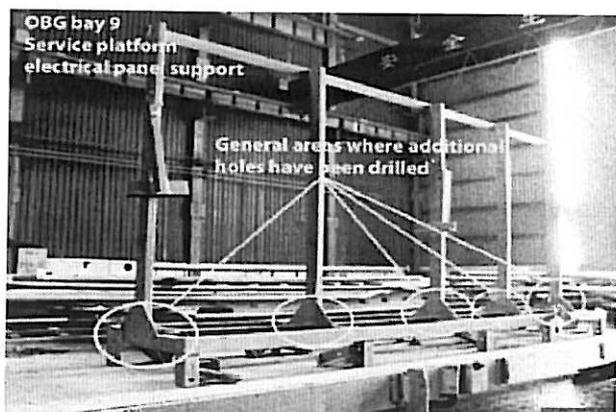
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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000889**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0851**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: OBG Service Platform Electrical Panel SupportProcedural Procedural Description:**Reference Description:** QA found non-approved drilled holes on the service platform electrical panel support SP6.**Description of Non-Conformance:**

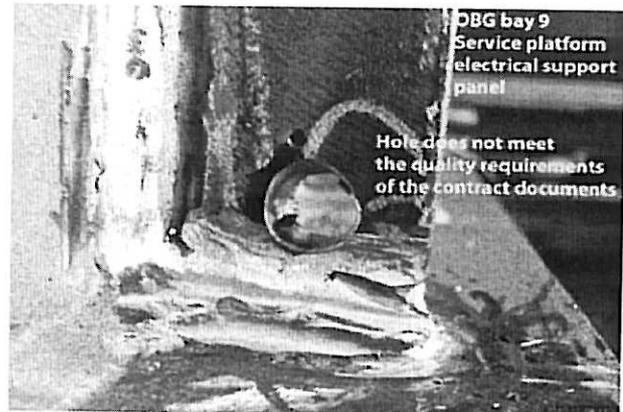
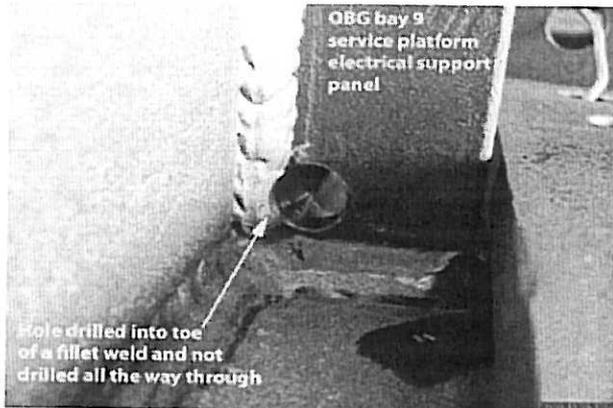
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Inspected By: Tsang, Eric

SMR

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Reviewed By: Devey, Jim

SMR

FW: TC RFI - misdrilled holes on electrical panel support

发件人: Joshua Ishibashi <jishibashi@cn.abfjv.com>

收件人: Zhang Wei <zhangwei_zj@zpmc.net>, Lay Tao <taolei@zpmc.com>

日期: 2010-11-23 9:03:56

附件: NCR 851.pdf

See the response from Gang/CT, this work will need to be complete to close ZPMC-0851

Best Regards,

Joshua Ishibashi

American Bridge/Fluor, A Joint Venture

jishibashi@cn.abfjv.com

Office: 86.21.5685.6666 x564042

China Mobile: 138.1651.3190

From: Roman Granados [mailto:roman_granados@dot.ca.gov]

Sent: Monday, November 22, 2010 1:55 PM

To: Gang Jiao

Cc: Chris Havel; Gene Rosamilia; Joshua Ishibashi; Stanley Ku; Sean Wichman; zhu yin; etsang@sasbridge.com; Tom.Ho@tylin.com; ATakata@moffattnichol.com

Subject: Re: TC RFI - misdrilled holes on electrical panel support

Gang,

Just closing this out as formality, the proposal is acceptable. (please see my previous e-mail response attached below)

Ashley,

Please include this in the TCRFI's.

Thanks,

Roman M. Granados

(510) 622-5193 - office

(510) 714-7049 - cell

158-2142-3943 - China cell

"Gang Jiao"

<gjiao@cn.abfjv.c

om>

To

""Roman Granados""

11/12/2010 03:22

<roman_granados@dot.ca.gov>

PM

cc

""Chris Havel""

<chris_havel@dot.ca.gov>, ""Stanley

Ku"" <stanley_ku@dot.ca.gov>,

""Sean Wichman""

<swichman@cn.abfjv.com>, ""Gene

Rosamilia""

<grosamilia@cn.abfjv.com>, ""zhu

yin"" <zyin@cn.abfjv.com>, ""Joshua

Ishibashi""

<jishibashi@cn.abfjv.com>

Subject

TC RFI - misdrilled holes on
electrical panel support

Roman,

ZPMC drilled weep holes (approx. 12mm diameter) on several electrical panel supports used on service platforms for galvanizing. These weep holes are not shown on shop drawings. Please confirm if the following proposals are acceptable:

For weep holes not overlapping with existing welds, leave the weep holes as it is.

For weep holes overlapping with existing welds, fill the misdrilled holes by welding, and perform 100% VT and MT.

Thanks.

Gang Jiao
Deputy Fabrication Manager

666 Feng Bin Road
Changxin Island
Shanghai, China 201913
Email: gjiao@abfjv.com
Tel; +86-21-56856666x564011
Fax: +86-21-56853675
Mobile: +86-13641811974

Roman
Granados/D04/Caltrans/CAGov
To
"Gang Jiao" <gjiao@cn.abfjv.com>
11/12/2010 03:34
cc
PM
jishibashi@cn.abfjv.com,
jdevey@sasbridge.com,
jsimonis@sasbridge.com,
etsang@sasbridge.com, Chris
Havel/D04/Caltrans/CAGov@DOT, Aaron
Prchlik/D04/Caltrans/CAGov@DOT,
Laraine Woo/D04/Caltrans/CAGov@DOT,
cchao@sasoverseasteam.com@DOT
Subject
Drilled Holes in Service Platform
Electrical Panel Support

Gang,

As agreed with you yesterday, holes drilled into the fillet and CJP welds of the service platforms' electrical panel frames shall be repaired per an approved procedure with 100% VT and 100% MT performed on the repairs, and any damaged galvanizing shall be repaired in conformance with the Contract requirements.

As for holes not drilled into the welds, these holes are acceptable to remain, provided they can be brought into conformance with the Contract requirements as identified in the NCR and the damaged galvanizing repair requirements.

Please submit your NPR reflecting this agreement and any other necessary paperwork required to close this NCR (#851).

Roman M. Granados
(510) 622-5193 - office
(510) 714-7049 - cell
158-2142-3943 - China cell

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If you have received this email in error please notify the originator of the mess
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焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBR	部件图号 Drawing No	SPEP1-A	报告编号 Report No.	B-WR16908
合同号 Contract No.:	04-0120F4	部件名称 Items Name	6#服务平台电器支架	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述: (母材损伤修补)

Description of welding discontinuity:

经检查发现: 施工队在对电器支架角钢开漏锌孔时, 将孔开在了焊缝处, 共计8处。

After inspection, we found they have added extra holes to the Service Platform cable supports on the welding area. The total number is 8.

检验员 (Inspector): Chen Shigang 日期 (Date): 2010.11.12

Chen Shigang

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

Caused:

工人操作失误, 导致母材损伤。

Worker operator error caused base metal gouged.

车间负责人(Foreman): *Li Haijie* 日期(Date): *2010.11.13*

处理意见

Disposition :

1. 按照焊接返修工艺规程 (WPS) 打磨缺陷区域至光滑;
2. 准备一个正确的接头形式, 具体参见返修的WPS;
3. 对返修区域作100%MT和100%VT检查;
4. 如果仍发现有缺陷, 通过打磨的方法去除所有缺陷以确认缺陷完全被清除, 并重复第三步以确认缺陷完全被清除;
5. 将杂物以及MT检测遗留的残留物清理干净;
6. 根据批准的焊接返修工艺规程 (WPS) 进行预热及焊接;
7. 将焊接区域打磨至与母材平齐;
8. 对返修区域作NDT检查。

1. Grind the repair area to a smooth finish according to the approved repair WPS.
2. Prepare the joint according to the approved WPS.
3. Perform 100%MT and 100%VT of the repair area.
4. Remove all defects by grinding to ensure all defects are completely removed if defects still exist, and repeat "step 4" to assure complete removal of all defects if necessary.
5. Clean the repair area of all loose debris including MT powder.
6. Preheat and weld according to the approved WPS.
7. Grind the weld flush after welding.
8. Perform NDT of the repair area.

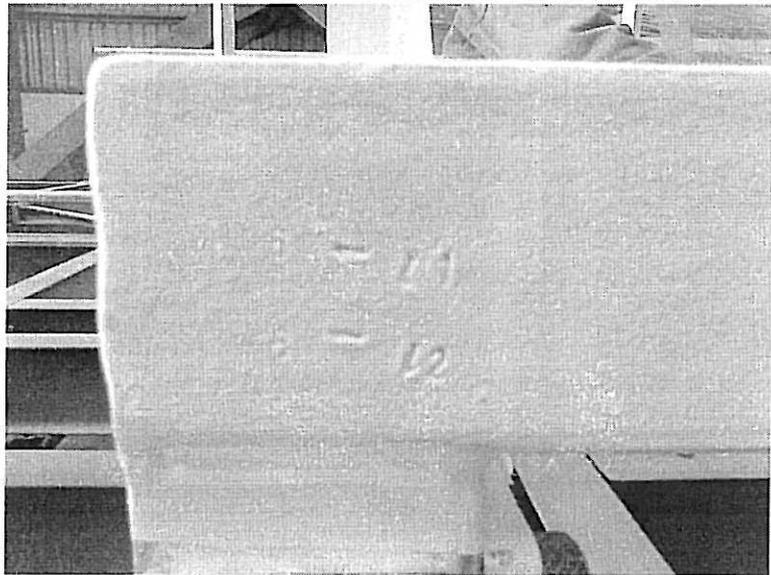
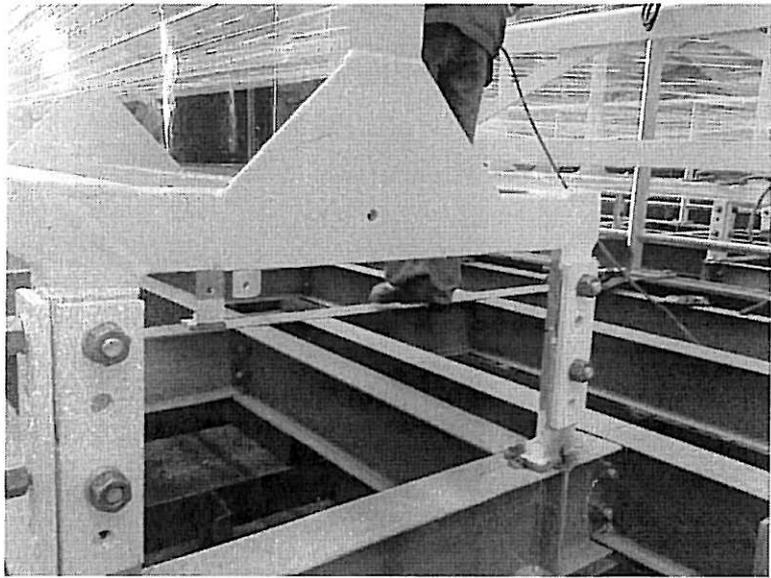
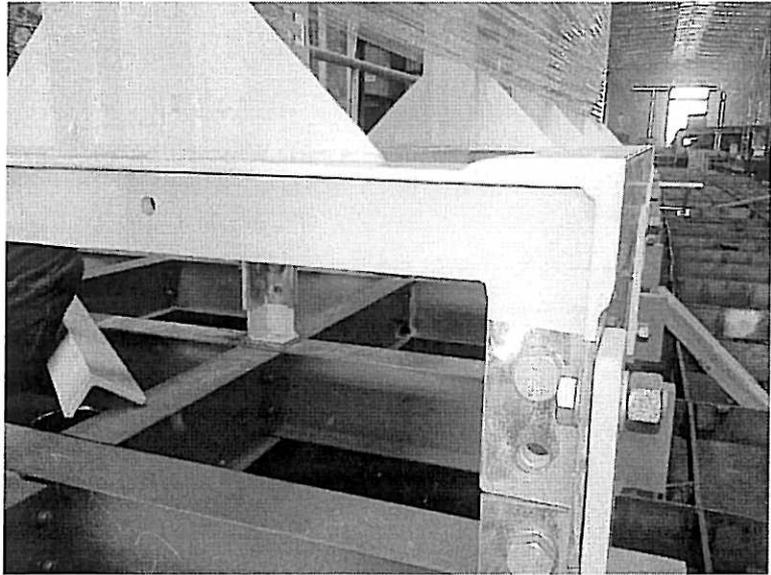
工艺:
Technical engineer

Xu Donghai
2010.11.13

审核:
Approved by

日期
Date

		焊缝返修报告 Welding Repair Report			版本 Rev. No.	
					0	
项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	SPEP1-A	报告编号 Report No.	B-WR11364	
合同号 Contract No.:	04-0120F4	部件名称 Items Name	服务平台电器支架	NDT报告编号 Report No. of NDT	NA	
项目编号 Project No.:	ZP06-787					
纠正措施: Correction action to prevent re occurrence: 培训和教育操作工, 提高操作水平。 Train and educate operator to improve operation skill. 车间负责人(Foreman): _____ 日期(Date): _____						
参照的WPS编号 Repair WPS No.	<input type="checkbox"/> WPS-345-SMAW-1G(1F)- Repair <input checked="" type="checkbox"/> WPS-345-FCAW-1G(1F)- Repair-1 <input type="checkbox"/> WPS-345-SMAW-2G(2F)-Repair <input type="checkbox"/> WPS-345-FCAW-2G(2F)-Repair-1 <input type="checkbox"/> WPS-345-SMAW-3G(3F)- Repair <input type="checkbox"/> WPS-345-SMAW-4G(4F)- Repair <input type="checkbox"/> WPS-345-SMAW-1G(1F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-2G(2F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-3G(3F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-4G(4F)-FCM-Repair		工艺员 technologist	<i>Xu Donghai</i> <i>2010.11.13</i>		
返修(碳刨)前预热温度 Preheat temperature before gouging	NA	返修的缺陷 Description of discontinuity	<i>母材裂纹</i>			
焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat temperature before welding	125			
最大碳刨深度 Max. depth of gouging	NA	碳刨总长 Total length of gouging	NA			
焊工 welder	203805	焊接类型 welding type	FCAW	焊接位置 position	1G	
焊接电流 Current	282	焊接电压 Voltage	29.1	焊接速度 Speed	511	
返修后检查 Inspection After repairing:						
外观检查 VT result	Acc	检验员 Inspector	Guo Jia Fei	日期 Date	2010.11.15	
NDT复检 NDT result	MT Acc	探伤员 NDT person	Fu Zhongqiang	日期 Date	2010.11.17	
见证: Witness/Review:						
备注: Remark:						



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000840**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0851**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 09-Nov-2010**Description of Non-Conformance:**

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Contractor's proposal to correct the problem:

ZPMC to repair the mis-drilled holes which overlap the existing welds. Perform the NDT to prove the weld is acceptable.

Corrective action taken:

The mis-drilled holes have been repaired. NDT report submitted showed that the repair is acceptable.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?** Yes No**Comments:**

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Inspected By: Ng, Michael

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Reviewed By: Wahbeh,Mazen

QA Reviewer