

**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 #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, China**Report No:** NCR-000931**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0892**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Hinge A Bulkheads PP127-128.3, L14 East/West
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** CCO#077 - Quality Assurance Green Tagging Procedure Not Followed**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG Lift 14 in Bay # 14, this Caltrans QA Inspector observed the following on Hinge A Pipe Sleeve Bulkheads:

- Floorbeam FB3272A and Sub Assembly SA3324A were observed to be erected/assembled prior to completion of inspection and testing on 12/7/10.
- Floorbeam FB3286A was observed to be erected/ assembled prior completion of inspection and testing on 12/8/10.
- Floorbeams FB3327A, FB3328A and Sub Assemblies SA3409A, SA3410A were observed to be erected/ assembled prior completion of inspection and testing on 12/8/10.
- The inspection requirements for these components were not fulfilled as per contract documents.
- The Green Tag has been not issued for this component for further assembly/ erection.
- The Hinge Plates are located between PP127 and 128.3
- Hinge Plates were observed tacked to Bottom Plates in Bay #14 for Lifts 14 East and West

See attached photographs for additional detail.

# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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## Applicable reference:

CCO#077 – Quality Assurance Green Tagging: Quality Assurance shall be improved with a physical tagging procedure (green tagging procedure) for fabricated assemblies. The tagging procedure, in conjunction with the database system, establishes a process that tracks, verifies, and documents incremental progress for fabricated sub-assemblies and assembly stages.

CCO#077 – Quality Assurance Green Tagging: Section 3.3 The QA Approval form shall include the weld joint number (s) requesting approval, subassembly number, assembly number, grade and date. The QA Approval form shall be issued for the following subassemblies: 1) OBG, f: Floor beams before segment assembly. Applicable to FL-1, FL-2, FL-3, and whole unit assemblies.

AWS D 1.5, Section 6.1.1.1: As a minimum, the Contractor shall perform inspection and testing prior to assembly, during assembly, during welding and after welding as described in this section and additionally as necessary to assure that materials and workmanship conform to the requirements of the contract documents.

AWS D 1.5, Section 6.1.5 The Inspector shall be notified in advance of the start of fabrication/erection operations subject to inspection and verification.

**Who discovered the problem:** Shrikant Utekar

**Name of individual from Contractor notified:** Mankit

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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**Time and method of notification:** 12/8/10, 08:00 hrs, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 12/9/10, 13:45 hrs, Email

**QC Inspector's Name:** Wang Lu (Testino)

**Was QC Inspector aware of the problem:** Yes No

**Contractor's proposal to correct the problem:**

NA

**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,(818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Devey,Jim	SMR
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<b>Reviewed By:</b>	Wahbeh,Mazen	SMR
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## NCR PROPOSED RESOLUTION

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

**Attention:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000888

**Subject:** NCR No. ZPMC-0892

**Dated:** 11-Jan-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000901 **Rev:** 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** The sub assemblies referenced in the NCR have been inspected by the Department and found to be acceptable, signature of the green tag form is pending closure of this NCR.

The sub assemblies referenced in the NCR have been inspected by the Department and found to be acceptable, signature of the green tag form is pending closure of this NCR. Whenever possible subassemblies will be complete green tagged prior to movement in the future. Based on this, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000901R00

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**Caltrans' comments:**

**Status:** CLO

**Date:** 11-Jan-2011

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0892 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 11-Jan-2011

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**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**


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**Location:** Changxing Island, Shanghai, China**Report No:** NCS-000943**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0892**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Date the Non-Conformance Report was written:** 08-Dec-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG Lift 14 in Bay # 14, this Caltrans QA Inspector observed the following on Hinge A Pipe Sleeve Bulkheads:

- Floorbeam FB3272A and Sub Assembly SA3324A were observed to be erected/assembled prior to completion of inspection and testing on 12/7/10.
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- The Green Tag has been not issued for this component for further assembly/ erection.
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- Hinge Plates were observed tacked to Bottom Plates in Bay #14 for Lifts 14 East and West

See attached photographs for additional detail.

**Contractor's proposal to correct the problem:**

Contractor will request for Department's QA inspection of the sub-assemblies. The green tag form will be signed off subject to closure of this NCR. In future, where practicable sub-assemblies will be inspected, green tagged prior to movement.

**Corrective action taken:**

Contractor requested for QA inspection, inspection subsequently completed. Green tag application submitted and signing off of Green Tag pending closure of this NCR.

**Did corrective action require Engineer's approval?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**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

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**Reviewed By:**    Wahbeh,Mazen

QA Reviewer