

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, China **Report No:** NCR-000945
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 14-Dec-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0904

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 13CE Deck Panel, DP3100A
Procedural	Procedural	Description:	

Reference Description: Missed MT Crack Discovered by Quality Assurance on Lift 13CE Deck Panel

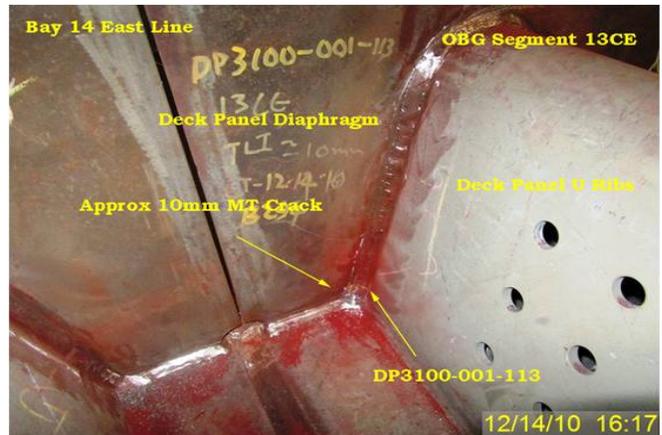
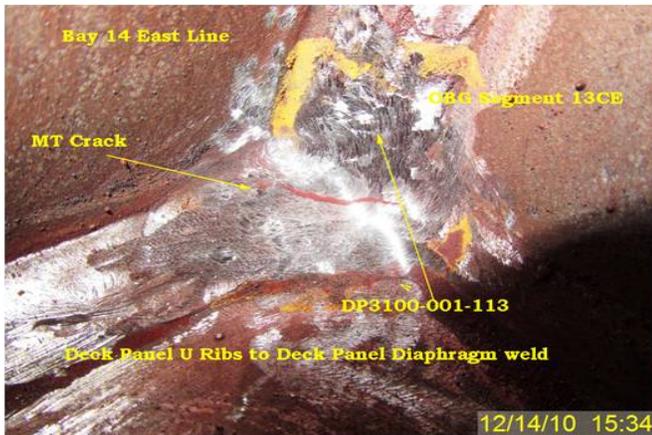
Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 13CE, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse crack measuring approximately 10mm in length.
- The weld is identified as: DP3100-001-113.
- The weld is an 8mm fillet weld joining the Deck Panel U-Rib to Deck Panel Diaphragm.
- The weld is designated as a Seismic Performance Critical Member (SPCM).
- The indication is clearly marked on the material near the weld.
- OBG segment 13CE is located South Side of Bay 14 area.

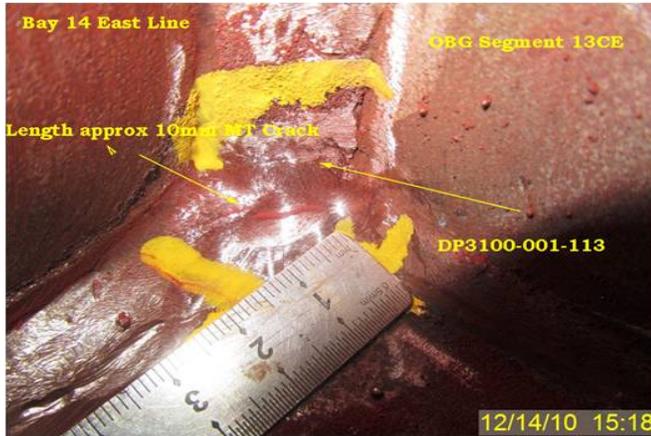
The Notice of Witness Inspection Number (NWIT) is 07772. The Indication is located within an area that has been previously tested by ZPMC Quality Control (QC) personnel. As per contract documents ZPMC is required to perform 100% Magnetic particle Testing (MT) of this weld.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Vibin Kumar. S

Name of individual from Contractor notified: Lee Mankit

Time and method of notification: 15.30 hours, 12/14/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 13.00 hours, 12/15/10, Email

QC Inspector's Name: Mr. Wang Lu

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.

Inspected By:	Devey,Jim	SMR
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Reviewed By:	Wahbeh,Mazen	SMR
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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 15-Dec-2010

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Document No: 05.03.06-000901

Subject: NCR No. ZPMC-0904

Reference Description: Missed MT Crack Discovered by Quality Assurance on Lift 13CE Deck Panel

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG **Lift:** 13

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 13CE, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse crack measuring approximately 10mm in length.
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For further information, please see the attached pictures in the NCR.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.,A response for the resolution of this issue is expected within 7 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0904

cc: Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Laraine Woo, Bill Casey

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000901

Subject: NCR No. ZPMC-0904

Dated: 11-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000902 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC has repaired the indication in accordance with an approved CWR and performed NDT after to show that the weld is acceptable. ZPMC has written an internal NCR and ABFJV has noted which inspector missed the indication so that the inspector can receive additional training if he shows a pattern of missed indications. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000902R00;

Caltrans' comments:

Status: CLO

Date: 11-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0904 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 11-Jan-2011



No. B-955

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-12-31

REGARDING: NCR-000945(ZPMC-0904)

ZPMC acknowledged this problem and has issued an internal NCR. This indication has been removed, repaired and re-tested to be acceptable. ZPMC is providing the NDT record and is requesting closure of this NCR.

ATTACHMENT:

NCR-000945(ZPMC-0904)

B787-MT-33839 R1

Zhangwei
12/31/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

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Contract No: 04-0120F4
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Location: Changxing Island, Shanghai, China

Report No: NCR-000945

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Dec-2010

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0904

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Lift 13CE Deck Panel, DP3100A

Reference Description: Missed MT Crack Discovered by Quality Assurance on Lift 13CE Deck Panel

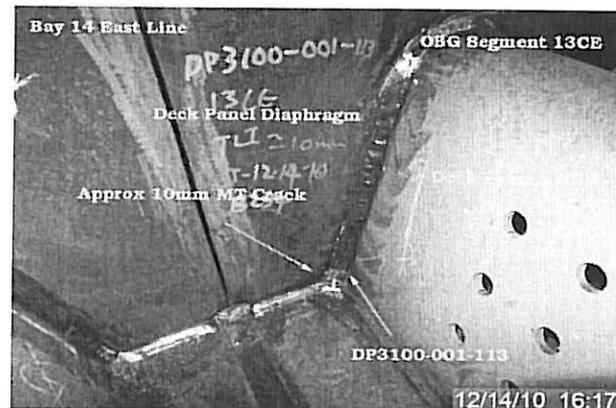
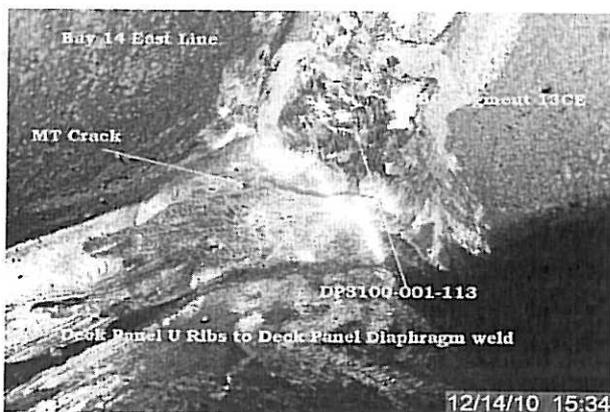
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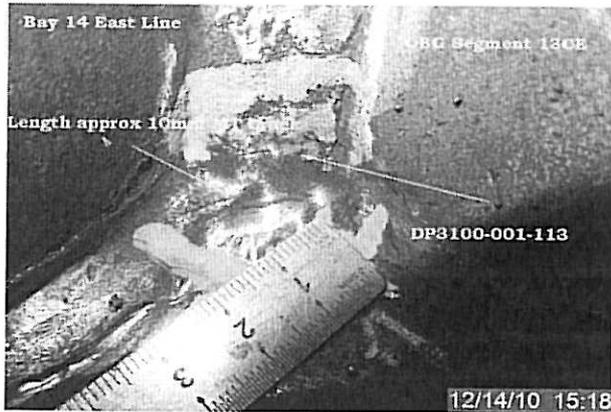
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Comments:

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Inspected By:	Devey,Jim	SMR
Reviewed By:	Wahbeh,Mazen	SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-33839R1 DATE日期 2010.12.28 PAGE OF 页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787 CONTRACTOR: 用户: CALTRANS

DRAWING NO. 图号: DP3100 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
13CE DECK PLATE

REFERENCING CODE 参考规范编码: AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002 PROCEDURE NO. 程序编号: ZPQC-MT-01 CALIBRATION DUE DATE 仪器校正有效期: Dec. 28ST, 2010

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: KOREA MODEL NO. 样式编号: MP-A2L SERIAL NO. 连续编号: MP104

MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法 CURRENT 电流: AC

PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉 YOKE SPACING 磁轭间距: 70~150mm

MATERIAL TO BE EXAMINED 检测材料: WELDING 焊接件 Material & thickness 母材,厚度: A709M-345T2-X
 CASTING 铸件 12/14mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
DP3100-001-113	1R1			ACC.		100%MT

AFTER B-CWR2477REV0

BLANK

EXAMINED BY 主探: Gu Yunwu <i>Gu Yun Wu</i>	REVIEWED BY 审核: Wang wei <i>Wang wei</i>
LEVEL-II SIGN 签名 / DATE 日期: <i>2010.12.28</i>	LEVEL-II SIGN / DATE 日期: <i>2010.12.28</i>
质量经理 / QCM: <i>Lujiambua</i>	用户 CUSTOMER:
签字 SIGN / 日期 DATE: <i>2010.12.28</i>	签字 SIGN / 日期 DATE:

DEPARTMENT OF TRANSPORTATION

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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, China**Report No:** NCS-000941**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0904**Type of problem:**

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

Date the Non-Conformance Report was written: 14-Dec-2010**Description of Non-Conformance:**

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For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will perform the repair according Critical Welding Repair CWR, and the NDT report will be submitted to prove the weld is acceptable. ZPMC will identify the inspector involved, issue an internal NCR and will monitor his performance. Disciplinary action will be taken if the inspector misses the indications continuously.

Corrective action taken:

Contractor repaired the weld and provided the NDT documentation to prove the weld is acceptable. The inspector involved has been identified, and his performance being monitored.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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Inspected By:	Ng,Michael	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
