

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-000953

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Dec-2010

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

NCR #: ZPMC-0912

Type of problem:

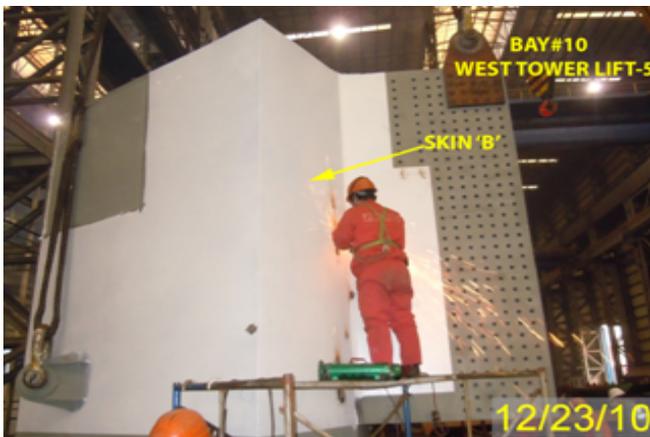
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 5 West Skin B
Procedural	Procedural	Description:	

Reference Description: Lift 5 West Skin B- Weld repair without paint removal

Description of Non-Conformance:

During the Caltrans Quality Assurance (QA) in-process observation on West Tower Lift-5, this QA Inspector discovered the following issue:

- ZPMC personnel performing base metal repair welding without removing the paint on West Shaft Skin 'B'.
- Location observed to be approximately 1700 mm from the top of the Shaft.
- This member is Non-Seismic Performance Critical Member (SPCM).
- This component located at fabrication Bay#10.



Applicable reference:

AWS D1.5-2002, Section 3.2.1: "...Surfaces to be welded and surfaces adjacent to a weld shall also be free from loose or thick scale, slag, rust moisture, grease, and other foreign material that would prevent proper welding or produce objectionable fumes."

Standard Specifications-1999, Section 55-3.16: "... Surfaces of metal in contact shall be thoroughly cleaned of

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

rust, mill scale, dirt, grease, paint or other material foreign to the metal before assembly.”

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Mr. Liu Cheng

Time and method of notification: 1630 hours, 12/23/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1115 hours, 12/24/10, Email

QC Inspector's Name: Mr. Ken Zhang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



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: 27-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: 05.03.06-000909

Subject: NCR No. ZPMC-0912

Reference Description: Lift 5 West Skin B- Weld repair without paint removal

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: Tower **Lift:** 05

Remarks:

During the Caltrans Quality Assurance (QA) in-process observation on West Tower Lift-5, this QA Inspector discovered the following issue:

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Action Required and/or Action Taken:

Propose resolutions for the identified non-conformance items and document that the various deficiencies have been brought in compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance. Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0912

cc: Rick Morrow, Peter Siegenthaler, Brian Boal, Mark Woods, Contract Files, Ching Chao, 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: 05.03.06-000909

Subject: NCR No. ZPMC-0912

Dated: 18-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000911 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC did remove the paint from the repair prior to welding which was verified by an ABFJV inspector.

ZPMC did remove the paint from the repair prior to welding which was verified by an ABFJV inspector. To settle this dispute ZPMC is submitting NDT to show that base metal is acceptable after the repair. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000911R00;

Caltrans' comments:

Status: CLO

Date: 18-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0912 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 18-Jan-2011



No. T-188

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-01-16

REGARDING: NCR-000953(ZPMC-912)

ZPMC received NCR-000965(ZPMC-924), it mentioned that CT inspectors found ZPMC performing base metal repairing work without paint removal.

Here we clarify as below. The truth was ZPMC did remove the paint, and it was conducted under both ZPMC and ABF's site inspectors' witness. Actually it couldn't even be starting on the paint.

Anyhow ZPMC take a positive rectification work on the component. And now the surface is all right.

Here we provide relative reports, hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000953(ZPMC-912)

T787-MT-12673

Zhang Wanki

2011.1.16

DEPARTMENT OF TRANSPORTATION
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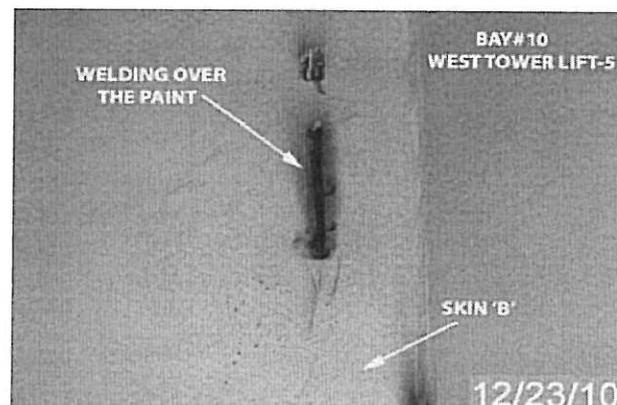
Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000953**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0912**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Lift 5 West Skin BProcedural Procedural Description:**Reference Description:** Lift 5 West Skin B- Weld repair without paint removal**Description of Non-Conformance:**

During the Caltrans Quality Assurance (QA) in-process observation on West Tower Lift-5, this QA Inspector discovered the following issue:

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**Applicable reference:**

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Name of individual from Contractor notified: Mr. Liu Cheng

Time and method of notification: 1630 hours, 12/23/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1115 hours, 12/24/10, Email

QC Inspector's Name: Mr. Ken Zhang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-12673 DATE日期 2010.12.31 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. G TSA5C/G CALTRANS CONTRACT NO.:
 图号: FIFTH LIFTING TOWER(N) SKIN 加州工程编号 04-0120F4
 PLATE STIFFENER

REFERENCING CODE ACCEPTANCE STANDARD PROCEDURE NO. CALIBRATION DUE DATE
 参考规范编码 接受标准 程序编号 仪器校正有效期
 AWS D1.5-2002 AWS D1.5-2002 ZPQC-MT-01 Dec. 28ST, 2011

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 连续编号
 MT YOKE PARKER da400S 17371

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

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

MATERIAL TO BE EXAMINED √ WELDING 焊接件 Material & thickness A709M-HPS485WT2-Z
 检测材料 CASTING 铸件 母材,厚度 60/50mm
 FORGING 锻造

WELDING PROCESS NA TYPE OF JOINT NA
 焊接方法 焊缝类型

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			
G TSA5C/G				ACC.		BASE METAL

BLANK

EXAMINED BY主探 Fu Zhi qiang REVIEWED BY 审核 Di Kun hui
 LEVEL - II SIGN 签名 / DATE日期 2010.12.31 LEVEL-II SIGN / DATE日期 2010.12.31
 质量经理 / QCM Lin Jian hua 用户CUSTOMER
 签字 SIGN / 日期 DATE 2010.12.31 签字 SIGN / 日期 DATE

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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-000891**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0912**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: 23-Dec-2010**Description of Non-Conformance:**

During the Caltrans Quality Assurance (QA) in-process observation on West Tower Lift-5, this QA Inspector discovered the following issue:

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- This component located at fabrication Bay#10.

Contractor's proposal to correct the problem:

Contractor will provide NDT report to prove the weld repair is acceptable. Area of damaged paint will require repairing in accordance with PQWP repair procedure.

Corrective action taken:

Contractor performed the weld repair, and the NDT report shows the weld is acceptable. Contractor repaired the paint area per the approved PQWP and is now in conformance with contract requirements.

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

Reviewed By: Devey, Jim

QA Reviewer