



# MOUNTAIN STATES STEEL

325 SOUTH GENEVA ROAD, LINDON, UTAH 84042

Telephone: (801) 785-5085

Fax: (801) 785-1100

## NON-CONFORMANCE REPORT

Contract No. <u>464</u>	Project: <u>Skyway Project #04-012024</u>	Incident Date: <u>22 Dec. '04</u>
Piece Mark: <u>11080 &amp; 1108E</u>		Tag No: <u>0001 rev.4</u>

Condition Should Be: FCAW welding per drawing ... B-U2-F (5/8" plate)

Non-conformance: SAW welding ... B-U2-S. Joint prepared for SAW welding.

Recommended Corrective Action: Use parts as-is. Revise drawing to show SAW joint B-L2c-S.

Inspector: per Bill Kent of Caltrans 10-21-03

Corrective Action: Stop SAW welding of 5/8" plate until drawings are approved.

Approvals: Revised drawings were approved per State Letter #5.03.1-002997

Jeffery Peery   
 QA/QC Manager

Bill Kent      10-28-03  
 Inspector

Disposition After Corrective Action: The pieces will be disposed of because of a desian revision.

*"M a k i n g I t H a n n e n"*



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Piece Mark: <u>1108E</u>			Tag No: <u>0002 rev.3</u>

Condition Should Be: Carbon-arc gouged weld joints are to be ground to shiny metal before welding.

Non-conformance: The second side of the weld joint between top plate (eh1108) and side plate (f1108) was backgouged, then welding began in the joint between bottom plate (b1108) and side plate (f1108). The panel was on it's side, with the area being worked on approximately 20' above the shop floor. The Caltrans inspector thought welding was being done in the joint backgouged, but not ground. MSS inspector, Vern Gray, went up the ladder and confirmed the backgouged joint was not being welded.

Recommended Corrective Action: None.

Inspector: John Kinsey / Vern Gray

Corrective Action: Training was provided to fitters and welders that emphasized the importance of grinding aowed surfaces to shiny metal. MSS's inspector is continuina to monitor & enforce the need to grind gouged surfaces to shiny metal.

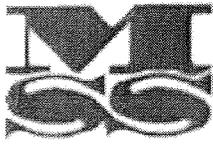
Approvals:

Jeff Peery  
QA/QC Manager

Inspector

Disposition After Corrective Action: The piece will be disposed of because of a design revision,

*" Making It Happen "*



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Piece Mark:	<u>1108E</u>			Tag No.:	<u>0003 rev.3</u>

Condition Should Be: The welding shop should be temperature controlled to 10°C (50°F) minimum.

Non-conformance: The welding shop was found to be 48°F at a location about 5' above the shop floor. Welding was being done about 20' above the shop floor, and the weld joint was preheated to at least 150°F.

Recommended Corrective Action: Nothing for the piece in question here. There was no thermometer near the weld joint, but the building is being heated with forced air heaters about 10' off the shop floor. No heater was blowing directly into the area where the 48°F reading was taken. Between the rising heat, and radiant heat from the preheated steel, we are confident the temperature in the vicinity of the weld was well over the required 50°F minimum specified.

Inspector: John Kinsey / Vern Gray

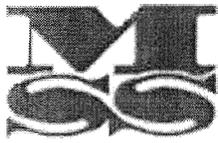
Corrective Action: No corrective action. State Letter #5.03.1-003549 allows welding at ambient temperatures down to -20°C (0°F). Also, the piece involved will not be used on the project because of a design revision (reference CCO #90).

Approvals:

<u>Jeff Peery</u> QA/QC Manager	<u>Inspector</u>
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Disposition After Corrective Action: The piece will be disposed of because of a design revision.

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## NON-CONFORMANCE REPORT

Contract No.	<u>464</u>	Project:	<u>Skyway Project #04-012024</u>	Incident Date	<u>22 Dec.'03</u>
Piece Mark:	<u>1108C, 1108D, &amp; 1108E</u>			Tag No:	<u>0004 rev.3</u>

Condition Should Be: Caltrans is notified prior to performing NDT inspection.

Non-conformance: UT inspection was performed (12-3-03, 12-8-03, & 12-15-03) on panels without advising Caltrans that inspection was going to be happening.

Recommended Corrective Action: Send an INSPECTION REQUEST to Caltrans for all anticipated inspection activities when production resumes.

Inspector: John Kinsey / Vern Gray

Corrective Action: No Corrective Action required, The pieces involved will not be used on the project because of a design revision (reference CCO #90).

Approvals:

Jeff Peery

QA/QC Manager

Inspector

Disposition After Corrective Action: The pieces involved will be disposed of because of a design revision.

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## NON-CONFORMANCE REPORT

Contract No.	464	Project:	Skyway Project #04-012024	Incident Date	22 Dec. '03
Piece Mark:	1108C, 1108D, & 1108E			Tag No:	0005 rev.3

Condition Should Be: Caltrans is notified when welding is going to be performed, and daily welding reports sent to the QCM weekly

Non-conformance: One or two people were periodically working/welding on Bikepath panels without notification to Caltrans, and Daily Welding Reports were not sent to the QCM between 10 Oct. 2003 & 17 Dec. 2003.

Recommended Corrective Action: Send an INSPECTION REQUEST to Caltrans for all anticipated fabrication activities, and submit Daily Inspection Reports in a timely manner when production resumes.

Inspector: John Kinsey / Jeff Peery

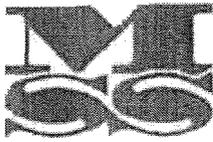
Corrective Action: No Corrective Action required. The pieces involved will not be used on the project because of a design revision (reference CCO #90).

Approvals: \_\_\_\_\_

Seff Peery  \_\_\_\_\_  
QA/QC Manager

\_\_\_\_\_ Inspector

Disposition After Corrective Action: The pieces involved will be disposed of because of a design revision.



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## NON-CONFORMANCE REPORT

Contract No. 464 Project: Skyway Project #04-012024  
Piece Mark: 6308A-01

Incident Date: 29 Mar. '04  
Tag No: 0006 rev.2

Condition Should Be: Welding only in positions certified for.

Non-conformance: Pedro Hernandez was tack welding in a position he is not certified for.

Recommended Corrective Action: Certify the welder in the positions used.

Inspector: Paul Dawson / Dave Flygare

Corrective Action: The welder, Pedro Hernandez, was certified for SMAW tack welding in the vertical (3F) and overhead (4F) positions. A Caltrans QA inspector witnessed the testing. Copies of Pedro's certification were sent to KFM in Mountain States Steel's D1.5 WQCP addendum #8.

Approvals:

Jeff Peery

QA/QC Manager

Inspector

Disposition After Corrective Action: Use as-is.

*" Making It Happen "*