

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 #: 1x.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Watson Bowman Acme - Buffalo / NY**Report No:** NCR-001097**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Sep-2011**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0013**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Hinge A Seismic Joint Deck Assembly
Procedural	Procedural	Description:	

Reference Description: Welding without approved WPS**Description of Non-Conformance:**

The Contractor elected to proceed with the various shop welds using the FCAW process, 2F position without an approved WPS.

Applicable reference:

Conformed Special Provisions section 8-3.1, "Unless considered prequalified, fillet welds, including reinforcing fillet welds, shall be qualified in each position. The fillet weld soundness test shall be conducted using the essential variables of the WPS as established by the Procedure Qualification Record (PQR)".

Who discovered the problem: QMI Dustyn Broening**Name of individual from Contractor notified:** Welding QC Manager Jim Bowers**Time and method of notification:** Verbal, QA/QC meeting**Name of Caltrans Engineer notified:** Jason Wilcox**Time and method of notification:** Verbal**QC Inspector's Name:** John Gotwald**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Perform a successful fillet weld soundness test.

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 Bahjat Dagher, 510-557-8250, who represents the Office of Structural Materials for your project.

Inspected By: Dagher,Bahjat

QA Inspector

Reviewed By: Lowry,Patrick

SMR

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Watson Bowman Acme - Buffalo / NY**Report No:** NCS-000978**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Dec-2011**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0013**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: 08-Sep-2011**Description of Non-Conformance:**

The Contractor elected to proceed with the various shop welds using the FCAW process, 2F position without an approved WPS.

Contractor's proposal to correct the problem:

Contractor proposed to generate FCAW (2F) fillet weld WPS that includes multiple pass welds only (5/16" welds and larger). Multiple pass fillet weld soundness test was approved on 1/27/2010. In addition, WBA proposed to remove all single pass fillet welds performed using the unapproved process and replace them with SMAW welds. In addition to that, WBA submitted an NPR report showing that the fillet weld soundness tests performed between 08/2011 and 09/2011 failed to meet required standards only at the single pass portion of the test. By doing so, WBA prove that the already deposited multiple pass welds are acceptable.

Corrective action taken:

FCAW (2F) WPS # FCAW-11 was submitted 12/6/2011 and approved as noted.

FCAW single pass fillet welds deposited on the production assemblies are being removed by WBA and replaced with SMAW welds.

SMR Report # SMR000114 was generated. It details the history of the fillet welds soundness test NCR, and the analysis leading to its closure.

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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Dagher,Bahjat

Quality Assurance Inspector

Reviewed By: Choy,Nina

QA Reviewer