

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 #: 13.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

Location: American Tank & Fabrication, Cleveland, Ohio
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Oregon Iron Works Clackamas, Or.

Report No: NCR-000158
Date: 10-Jul-2008
NCR #: OIW-0003

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Hinge K pipe beam fuse
Procedural	Procedural	Descriptor: NDT being conducted by non-approved personnel.	

Reference Description: Hinge K pipe beam fuse section after rolling, plate / heat D5002-2.**Description of Non-Conformance:**

The contractor OIW directed Stork Herron Testing Labs (SHTL) to conduct MT on the Hinge K pipe beam fuse sections that have been roll formed at American Tank & Fabrication in Cleveland Ohio. SHTL has not been approved by the Engineer at this time.

Applicable reference:

State Letter 04.03.01-002330 specifically states that Stork Herron Testing Lab (SHTL) must not perform any NDT operations until these issues (submittal revisions) have been satisfactorily resolved.

Contract Special Provisions, section 8-3.01, Welding Quality Control

Who discovered the problem: Scott Croff, Caltrans QA Inspector

Name of individual from Contractor notified: Jerry Danko, QC Rep & Shane Levermann, SHTL NDT Technician

Time and method of notification: 1500 hours, verbal notification, 7-10-2008

Name of Caltrans Engineer notified:

Time and method of notification:

QC Inspector's Name: Jerry Danko, Shane Levermann

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Unknown.

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 Ryan Smith, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott QA Inspector

Reviewed By: Wright, Mark QA Inspector



DEPARTMENT OF TRANSPORTATION

333 Burma Road
Oakland CA 94607
Tel: 510-622-5661 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607
Date: 14-Jul-2008

Dear: Mr. Charles Kanapicki
Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Attention: Mr. James Bowers
Job Name: SAS Superstructure

Subject: NCR No. OIW-0003
Document No: 05.03.06-000132

Reference Description: Hinge K pipe beam fuse section after rolling, plate / heat D5002-2.

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.

Remarks:

Material Location: Pipe Beam **Lift:** N/A

As issued in State Letter 05.03.01-002330 - Stork Herron Testing Laboratories (SHTL) have not addressed the findings from the Department Audit and are therefore not approved to perform NDT (MT). Until the deficiencies are addressed, SHTL must not perform NDT on the Pipe Beam Fuses.

See NCR #OIW-0003

Action Required and/or Action Taken:

Address the findings from the Department Audit and then use SHTL to perform NDT, or use OIW approved personnel to perform NDT of the Hinge Pipe Beam Fuses rolled at American Tank & Fabrication (AT&F).

Transmitted By: Warren Collins Assistant Structural Rep

Attachments: OIW-0003

cc: Rick Morrow, Brian Boal, Robert Kick, Ryan Smith

File: 05.03.06, 55.0550

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000132

Subject: NCR No. OIW-0003

Dated: 21-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000090 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABFJV has submitted OIW WQCP Addendum 3 that contain the welder and NDT service provider information as well as the PQR discussed in the Department's NCR

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000090R00;

Caltrans' comments:

Status: REJ

Date: 13-Oct-2008

The proposed NCR resolution is unacceptable for the following reasons:

a) Provide QC procedures to prevent a re-occurrence of this issue. Note: NCR #OIW-0008, which covers the same issue, was sent to the Contractor subsequent to this NPR being received.

b) The referenced WQCP addendum #3 (ABF-SUB-000510R10) was returned "Incomplete" on August 26, 2008.

As previously informed, NDT (MT) performed by Stork Herron will not be accepted. Repeat all NDT (MT) procedures with approved/qualified personnel.

Submitted by: Collins, Warren

Date: 23-Oct-2008

Attachment(s):



A JOINT VENTURE

375 Burma Road Oakland CA 94607
Phone 510-808-4600 / Fax 510-808-4601

LETTER OF SUBMITTAL
SAS Superstructure Project

Run Date 21-Aug-08
Time 6:55 AM

Dated: 20-Aug-2008

SUBMITTAL No: ABF-SUB-000550 Rev: 10

To: Gary Pursell

Co/Job # 660110

California Department of Transportation
333 Burma Road
Oakland CA 94607
Phone: (510) 622-5100 Fax: (510) 622-5165

Contract # 04-0120F4

Sub/Supplier: OIW

Sub/Supplier No: TL-2244-00228

Subject: Welding Quality Control Plan (WQCP) for Oregon Iron Works -
Addendum #3 - OIW

Special Provis. (SP) REF: 8-3
Standard Spec. (SS) REF:

Schedule ID:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items: Attached

Via Fax

- Plans
- Design Report
- Certificates of compliance
- Calculations
- Specs
- Copy of Letter
- Schedule
- Invoice

- Samples
- Payroll
- Change Order
- Other

Item	Date	Copies	Description	Drawing No	Rev	Subcon Dwg No	Rev	Status	Pages
01	20-Aug-08	2	Weld Quality Control Plan (WQCP) - OIW - Addendum #3		0			Pending	68

These are transmitted as checked below:

- For Approval
- For Review/comment
- Return For Correction
- For Your Use
- For Information
- Other

Remarks:

CC:

Please review / approve by : 03-Sep-2008

Submitted By: Charles Kanapicki
Project Manager

Checked & Sent By:
Document Control

NCR PROPOSED RESOLUTION

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

Dated: 18-Dec-2008

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000090 **Rev:** 01

Ref: 05.03.06-000132

Subject: NCR No. OIW-0003

Contractor's Proposed Resolution:

Reference Resolution: OIW to perform MT with their own staff at their Clackamas, OR facility

As discussed in the teleconference with ABFJV and Caltrans on November 18, 2008, OIW will perform MT with their own staff at their Clackamas, OR facility. The MT performed by Stork-Herron at AT&F was for OIW internal informational purposes only, not for compliance purposes, and it is respectfully requested that issues relating to Stork-Herron's approval status in OIW's WQCP not apply to the work they performed at AT&F.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000090R01

Caltrans' comments:

Status: CLO

Date: 27-Mar-2009

The NCR is resolved.

Note: The revision to OIW's Hinge K Fabrication procedure - Submittal ABF-SUB-000583R04 - also documented that MT performed on the fuses while at AT&F was for information only.

Submitted by: Collins, Warren

Date: 01-Apr-2009

Attachment(s):

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**

Location: American Tank & Fabrication, Cleveland, Ohio
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Oregon Iron Works Clackamas, Or.

Report No: NCS-000164
Date:
NCR #: OIW-0003

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: 10-Jul-2008**Description of Non-Conformance:**

The contractor OIW directed Stork Herron Testing Labs (SHTL) to conduct MT on the Hinge K pipe beam fuse sections that have been roll formed at American Tank & Fabrication in Cleveland Ohio. SHTL has not been approved by the Engineer at this time.

Contractor's proposal to correct the problem:

As discussed in the teleconference with OIW and ABFJV on November 18, 2008, OIW will perform MT with their own staff at their Clackamas, OR facility. The MT performed by Stork-Herron at AT&F is considered for OIW internal informational purposes only, not for compliance purposes. Therefore, fabricated items shipping from AT&F will be blue tagged pending MT testing at OIW.

Corrective action taken:

See Contractor's proposal to correct the problem.

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:	Fatemi, Mohammad	Quality Assurance Inspector
Reviewed By:	Fatemi, Mohammad	QA Reviewer