

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-000163
Date: 16-Jul-2008
NCR #: OIW-0004

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Hinge K pipe beam fuses
Procedural	Procedural	Descriptor:	Un-approved welder and procedures

Reference Description: Hinge K pipe beam fuse sections - plate / heat D5002-2 & D5002-3**Description of Non-Conformance:**

The Contractor OIW has directed American Tank to tack weld without approved welders and without the approved as noted welding procedure specification (WPS). The second set of rolled sections of Hinge K Pipe Beam Fuses (D5002-2 & D5002-3) have been fit and tack welded. OIW elected to proceed with the welding after METS has requested the welder qualifications as required in the Contract Special Provisions. The approved as noted WPS was not available at American Tank.

Applicable reference:

AWS D1.5-2002, Section 5.21

Contract Special Provisions, Section 8-3

Who discovered the problem: Scott Croff, Caltrans QA Inspector**Name of individual from Contractor notified:** Jerry Danko, QC Representative**Time and method of notification:** 1500 hours, verbal notification, 7-16-2008**Name of Caltrans Engineer notified:****Time and method of notification:****QC Inspector's Name:** Jerry Danko**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
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Reviewed By:	Wright, Mark	QA Inspector
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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: 28-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-0004
Document No: 05.03.06-000136

Reference Description: Hinge K pipe beam fuse sections - plate / heat D5002-2 & D5002-3

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

Welding on Hinge K Pipe Beam Fuses D5002-2 and D5002-3 was performed using unapproved welders who did not use the approved WPS to perform the work.

See NCR - OIW-0004 for further details.

Action Required and/or Action Taken:

AT&F must use the approved WPS to tack weld the rolled Pipe Beam Fuses and use qualified welders per the Contract requirements.

Transmitted By: Warren Collins Assistant Structural Rep

Attachments: OIW-0004

cc: Rick Morrow, Brian Boal, Robert Kick

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: 05.03.06-000136

Subject: NCR No. OIW-0004

Dated: 21-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000091 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-000091R00;

Caltrans' comments:

Status: CLO

Date: 23-Oct-2008

The NCR is resolved.

It is noted that the WPS was approved in State Letter 05.03.01-002324 (ABF-SUB-000550R07) on July 3, 2008 and the welder qualifications in 05.03.01-002517 (ABF-SUB-000550R08) on August 7, 2008.

The attachment provided by the Contractor referencing Submittal ABF-SUB-000550R10 is not appropriate to this NCR.

Submitted by: Collins, Warren

Attachment(s):

Date: 23-Oct-2008



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
- Certificates of compliance
- Specs
- Schedule
- Design Report
- Calculations
- Copy of Letter
- 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 Your Use
- For Review/comment
- For Information
- Return For Correction
- Other

Remarks:

CC:

Please review / approve by : 03-Sep-2008

Submitted By: Charles Kanapicki
Project Manager

Checked & Sent By: Document Control

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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-000779
Date: 23-Oct-2008
NCR #: OIW-0004

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

The Contractor OIW has directed American Tank to tack weld without approved welders and without the approved as noted welding procedure specification (WPS). The second set of rolled sections of Hinge K Pipe Beam Fuses (D5002-2 & D5002-3) have been fit and tack welded. OIW elected to proceed with the welding after METS has requested the welder qualifications as required in the Contract Special Provisions. The approved as noted WPS was not available at American Tank.

Contractor's proposal to correct the problem:

ABFJV has submitted OIW WQCP Addendum 3 that contain the welder and NDT service provider.

Corrective action taken:

WPS approved in State Letter 05.03.01-002324 and welder qualifications in 05.03.01-002517.

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:**

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 Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Lee, Jason	Quality Assurance Inspector
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Reviewed By:	Fatemi, Mohammad	QA Reviewer
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