

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 #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: 79.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Birmingham, AL**Report No:** NCR-000008**Prime Contractor:** MCM Construction, Inc.**Date:** 27-Nov-2007**Submitting Contractor:** Hardie-Tynes**NCR #:** NCR-000008**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Shear Rings
Procedural	Procedural	Description:	

Reference Description:**Description of Non-Conformance:**

Prequalified procedure TC-U5-S in AWS D1.1 2006 calls for a 60 degree bevel to be welded with the submerged arc process with tolerances of +10 and -5 degrees. The plates were cut to be welded with the Flux core process which allows for a 45 Degree bevel. Shop had been informed prior to welding these parts that this was not in accordance with minimal requirements of AWS D1.1 2006. The part numbers affected by this NCR are as follows, #s 1,2,3,5,12,14,15,16,19,and 21 of 26 on pier E17L.

Applicable reference:

Hardie-Tynes WPS 464-9P

AWS D1.1-2006 Figure 3.4 TC-U5-s

Who discovered the problem: Howard Stephens**Name of individual from Contractor notified:** Charles Whittington, QC director Hardie-Tynes Co.Inc.**Time and method of notification:** 11/27/2007 1500 hours Verbal**Name of Caltrans Engineer notified:** Mehran Ardakanian**Time and method of notification:** Email on 11/28/07**QC Inspector's Name:** Louis Knight**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Qualify the procedure for using 45 degree angle bevels with procedure qualification record (PQR)

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 Markian Petrina, 707-552-7715, who represents the Office of Structural Materials for your project.

Inspected By: Stephens,Howard**Reviewed By:** Wright,Mark

QA Inspector

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Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Birmingham, AL**Report No:** NCS-000013**Prime Contractor:** MCM Construction, Inc.**Date:** 18-Jan-2008**Submitting Contractor:** Hardie-Tynes**NCR #:** NCR-000008**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: 27-Nov-2007**Description of Non-Conformance:**

Prequalified procedure TC-U5-S in AWS D1.1 2006 calls for a 60 degree bevel to be welded with the submerged arc process with tolerances of +10 and -5 degrees. The plates were cut to be welded with the Flux core process which allows for a 45 Degree bevel. Shop had been informed prior to welding these parts that this was not in accordance with minimal requirements of AWS D1.1 2006. The part numbers affected by this NCR are as follows, #s 1,2,3,5,12,14,15,16,19,and 21 of 26 on pier E17L.

Contractor's proposal to correct the problem:

Qualify the procedure for using 45 degree angle bevels with procedure qualification record (PQR)

Corrective action taken:

PQR test plate has been welded and tested to AWS D1.1 section 4.9 and found to be acceptable

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: Stephens,Howard

Quality Assurance Inspector

Reviewed By: Wright,Mark

QA Reviewer