

**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 #: 1.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Job Site**Report No:** NCR-000023**Prime Contractor:** MCM Construction, Inc.**Date:** 17-Jan-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000023**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> 1.8 meter CISS pile E-19L-1
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	Failure to maintain continuous 225 degree preheat

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

The QA Inspector discovered the area of root pass between location marks 80"-120" did not maintain the minimum required preheat of 225 degrees F. The QA Inspector noted the temperature dropped to approximately 200 degrees F.

**Applicable reference:**

Caltrans Special Provisions Field Welding section J

**Who discovered the problem:** QA Inspector Rick Bettencourt**Name of individual from Contractor notified:** Welding Superintendent Chris Smith**Time and method of notification:** 1200 in person**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 1600 via phone conversation**QC Inspector's Name:** Kevin Scrivner**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

immediately apply heat with a rose bud torch and perform magnetic particle testing after the 225 degree F preheat was restored.

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

**Inspected By:** Bettencourt, Rick**Reviewed By:** Levell, Bill

QA

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Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Job Site**Report No:** NCS-000050**Prime Contractor:** MCM Construction, Inc.**Date:** 15-Apr-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000023**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 17-Jan-2008**Description of Non-Conformance:**

The QA Inspector discovered the area of root pass between location marks 80"-120" did not maintain the minimum required preheat of 225 degrees F. The QA Inspector noted the temperature dropped to approximately 200 degrees F.

**Contractor's proposal to correct the problem:**

immediately apply heat with a rose bud torch and perform magnetic particle testing after the 225 degree F preheat was restored.

**Corrective action taken:**

The material was brought back up to the minimum required temperature of 225 degrees F and magnetic particle testing was performed by the QC Inspector. After the completion of the weld ultrasonic testing (UT) was performed on 100% of total weld length to ensure weld quality.

**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:** Bettencourt, Rick

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer