

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 #: 77.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Twin Brothers Marine / Port of West St Marys, LA**Report No:** NCR-000028**Prime Contractor:** MCM Construction, Inc.**Date:** 24-Jan-2008**Submitting Contractor:** Twin Brothers Marine**NCR #:** NCR-000028**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 1.8M CISS Piles
Procedural	Procedural	Description: Insufficient preheat/interpass temperature	

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

The contractor TBM at 0100 failed to maintain preheat/interpass temperature on the longitudinal seam for the 40mm thick steel casing segment BC-3/BC4. During the observation of the non-conformance production welding was being performed by welding operator Patrick Landry welder ID-163 on the filler weld passes. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone and base material was below 150°F for the full length of the longitudinal seam weld and was not within the required temperature range (275°F to 600°F) as noted in WPS PM-02-KK-CORPAC.

Note: Two identification piece marks identified on steel casing segment will later be cut and used as two separate steel casing segments.

Applicable reference:

Welding Procedure Specification: PM-02-KK-CORPAC

Who discovered the problem: Mike Garcia**Name of individual from Contractor notified:** TBM welding foreman Leroy Savioe Jr.**Time and method of notification:** January 25, 2008 verbal notification**Name of Caltrans Engineer notified:** Mohammad Fertemi**Time and method of notification:** January 25, 2008 verbal notification**QC Inspector's Name:** Derek Ricks**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

The Contractor elected to leave the weld passes in place and bring the weld up to the required minimum preheat temperature and have Quality Testing and Inspection Incorporated perform magnetic particle testing to verify material soundness prior to welding

Comments:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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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: Garcia, Mike

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:** Twin Brothers Marine / Port of West St Marys, LA**Report No:** NCS-000016**Prime Contractor:** MCM Construction, Inc.**Date:** 06-Feb-2008**Submitting Contractor:** Twin Brothers Marine**NCR #:** NCR-000028**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: 24-Jan-2008**Description of Non-Conformance:**

The contractor TBM at 0100 failed to maintain preheat/interpass temperature on the longitudinal seam for the 40mm thick steel casing segment BC-3/BC4. During the observation of the non-conformance production welding was being performed by welding operator Patrick Landry welder ID-163 on the filler weld passes. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone and base material was below 150°F for the full length of the longitudinal seam weld and was not within the required temperature range (275°F to 600°F) as noted in WPS PM-02-KK-CORPAC.

Note: Two identification piece marks identified on steel casing segment will later be cut and used as two separate steel casing segments.

Contractor's proposal to correct the problem:

The Contractor elected to leave the weld passes in place and bring the weld up to the required minimum preheat temperature and have Quality Testing and Inspection Incorporated perform magnetic particle testing to verify material soundness prior to welding

Corrective action taken:

Quality Inspection performed 100% ultrasonic testing and 100% magnetic particle testing on the internal and external weld. TBM reviewed welding procedures with welders.

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

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Inspected By:	Madere, Mary		
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Quality Assurance Inspector

Reviewed By:	Wright, Mark		
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QA Reviewer