

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-000043**Prime Contractor:** MCM Construction, Inc.**Date:** 26-Feb-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000043**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: E-19L-3 weld #6
Procedural	Procedural	Description: Failure to maintain the minimum required preheat	

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

The QA Inspector observed MCM welding personnel Marco Torres at 0900 failed to maintain preheat/interpass temperature at weld #6 for the shear ring to pile designated E19L-3. During the observation of the non-conformance production welding was not being performed on the filler weld passes. The loss of preheat occurred at the top 915mm of the weld joint. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 225°F, but less than 250°F.

Applicable reference:

Caltrans Special Provisions Field Welding note J

AWS D1.1 2006 Table 3.2 category C

Who discovered the problem: Caltrans QA Inspector Rick Bettencourt**Name of individual from Contractor notified:** MCM Welding Foreman Marco Torres**Time and method of notification:** 0900 in person**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 0930 in person**QC Inspector's Name:** Kevin Scrivner**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 Mohammad Fatemi, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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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-000029**Prime Contractor:** MCM Construction, Inc.**Date:** 05-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000043**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: 26-Feb-2008**Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel Marco Torres at 0900 failed to maintain preheat/interpass temperature at weld #6 for the shear ring to pile designated E19L-3. During the observation of the non-conformance, production welding was not being performed on the filler weld passes. The loss of preheat occurred at the top 915mm of the weld joint. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 225°F, but less than 250°F.

Contractor's proposal to correct the problem:

The contractor restored the 300° F preheat/interpass temperature, elected to perform magnetic particle testing (MT) prior to commencing further welding operations and in order to address future issues place an additional electric resistance heating band.

Corrective action taken:

As noted above in contractor's proposal. In addition, the contractor has submitted a request for information (RFI) numbered 288 and no further action is required.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Per RFI response numbered 288. **Date:****Is Engineer's approval attached?** Yes No**Comments:**

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Inspected By: Foerder, Michael

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer