

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-000049**Prime Contractor:** MCM Construction, Inc.**Date:** 28-Feb-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000049**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: E-19L-5 weld #2, E-19L-9 weld #1
Procedural	Procedural	Description:	Failure to maintain the minimum required preheat

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

The QA Inspector observed MCM welding personnel Wayne Nunes failed to maintain preheat/interpass temperature at E-19L-5 weld #2 for the shear ring to pile complete joint penetration groove weld. During the observation of the non-conformance, production welding was not being performed on the filler weld passes. The loss of preheat occurred on the full length 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. The QA Inspector observed the same occurrence as noted above at location E-19L-9 weld #1. The QA Inspector observed the top 1100mm appeared to be approximately 250 degrees 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 Superintendent Chris Smith**Time and method of notification:** 1400 in person**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 1000 in person**QC Inspector's Name:** Kevin Scrivner**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

restore the minimum required preheat of 300 degrees F and perform magnetic particle testing of the weld.

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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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-000031**Prime Contractor:** MCM Construction, Inc.**Date:** 06-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000049**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: 28-Feb-2008**Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel Wayne Nunes failed to maintain preheat/interpass temperature at E-19L-5 weld #2 for the shear ring to pile complete joint penetration groove weld. During the observation of the non-conformance, production welding was not being performed on the filler weld passes. The loss of preheat occurred on the full length 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. The QA Inspector observed the same occurrence as noted above at location E-19L-9 weld #1. The QA Inspector observed the top 1100mm appeared to be approximately 250 degrees F.

Contractor's proposal to correct the problem:

Restore the minimum required preheat of 300 degrees F, perform magnetic particle testing of the weld and continue welding.

Corrective action taken:

As noted above in contractor's proposal. In addition, the contractor has submitted a request for information (RFI) numbered 288.

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

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Inspected By: Foerder, Michael

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Reviewed By: Levell,Bill

QA Reviewer