

**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-000053**Prime Contractor:** MCM Construction, Inc.**Date:** 07-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000053**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> 1.8m CISS Pile E18L-5
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Field splice weld loss of preheat.	

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

The QA Inspector observed MCM welding personnel Kevin Rosenblum and Gilbert Moya at approximately 1310 hours failed to maintain preheat/interpass temperature for pile designated E18L-5. During the observation of the non-conformance production welding was being performed on the filler weld passes. The loss of preheat occurred the entire length of the pile splice weld. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was approximately 165°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 William Clifford**Name of individual from Contractor notified:** MCM Welding Foreman Marco Torres**Time and method of notification:** 1320 in person.**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 1325 by telephone**QC Inspector's Name:** Joselito Lizardo**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Bring the weld up to the required minimum preheat temperature and perform magnetic particle testing prior to the commencement of welding

**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.

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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**Inspected By:** Clifford, William

**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-000076**Prime Contractor:** MCM Construction, Inc.**Date:** 12-Jun-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000053**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:** 07-Mar-2008**Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel Kevin Rosenblum and Gilbert Moya at approximately 1310 hours failed to maintain preheat/interpass temperature for pile designated E18L-5. During the observation of the non-conformance production welding was being performed on the filler weld passes. The loss of preheat occurred the entire length of the pile splice weld. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was approximately 165°F.

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

Bring the weld up to the required minimum preheat temperature and perform magnetic particle testing prior to the commencement of welding

**Corrective action taken:**

The weld was brought up to the required minimum preheat temperature and magnetic particle testing was performed prior to the commencement of welding. In addition the weld will be ultrasonically tested after completion. (Reference MCM\_SUB\_00448 R00)

**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:** Levell, Bill

Quality Assurance Inspector

**Reviewed By:** Fatemi, Mohammad

QA Reviewer