

**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


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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**


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**Location:** Job site**Report No:** NCR-000055**Prime Contractor:** MCM Construction, Inc.**Date:** 13-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000055**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-4
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	Loss of preheat.

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

The QA Inspector observed MCM welding personnel Lorenzo Cisneros and Francisco Aguirre at approximately 01230 hours failed to maintain preheat/interpass temperature for pile designated E18L-4. During the observation of the non-conformance production welding was being performed on the root weld passes. The loss of preheat occurred at 80-150 inches Y datum 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 175°F.

**Applicable reference:**

Caltrans Special Provisions Field Welding Note J.

AWS D1.1 2006, Table 3.2, Category C

**Who discovered the problem:** QA Inspector Danny Smith**Name of individual from Contractor notified:** Jose Albornoz**Time and method of notification:** 01235/verbal**Name of Caltrans Engineer notified:** Mahmoud Khandaghabudi**Time and method of notification:** 01245/verbal**QC Inspector's Name:** Joe Knoblauch**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:** Smith,Danny

**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-000058**Prime Contractor:** MCM Construction, Inc.**Date:** 23-Apr-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000055**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:** 13-Mar-2008**Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel Lorenzo Cisneros and Francisco Aguirre at approximately 01230 hours failed to maintain preheat/interpass temperature for pile designated E18L-4. During the observation of the non-conformance production welding was being performed on the root weld passes. The loss of preheat occurred at 80-150 inches Y datum 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 175°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. The contractor responded to the NCR in MCM submittal 520 rev.00.

**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