

**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:** Port of West, St. Mary, LA**Report No:** NCR-000073**Prime Contractor:** MCM Construction, Inc.**Date:** 18-Apr-2008**Submitting Contractor:** Twin Brothers Marine**NCR #:** NCR-000073**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
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Girth Weld BA-202 to BA-207 Pile section B17R7-2	

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

At Around 9:30PM, this day, the QA Inspector noted Welder Corey Fontenette with ID number 275 welding without preheat. Mentioned welder was welding on the root of girth weld of cans BA-202 to BA-207 Pile segment B17R7-2 when this was discovered. The QA Inspector verified the non conformance to the procedure WPS-PM-02-KK-CORPAC with the 275 degree temperature crayon and it clearly showed insufficient preheat. As stipulated in the WPS, the working contract document to this project, the minimum preheat shall be 275 degree Fahrenheit. The QC Inspector Russel Carpenter was informed regarding this infraction but QC could not take appropriate action as to stop the welder soon enough or by removing undesirable weld that could put strain to the base metal. Instead, the QC Inspector informed QA that the welder will continue and just do an x-ray onto that particular girth weld when it is complete. By not following this working procedure it clearly manifest of not adhering to the contract requirements thus this Non-Conformance Report (NCR) is issued.

**Applicable reference:**

WPS-PM-02-KK-CORPAC

**Who discovered the problem:** QA Inspector Joselito Lizardo**Name of individual from Contractor notified:** QC Inspector Russel Carpenter**Time and method of notification:** April 19, 2008, 2130hrs. verbal**Name of Caltrans Engineer notified:** Mohammad Fatemi**Time and method of notification:** April 21, 2008 by phone**QC Inspector's Name:** Russel Carpenter**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:****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

( Continued Page 2 of 2 )

---

---

Structural Materials for your project.

---

---

**Inspected By:** Lizardo,Josecito

**Reviewed By:** Wright,Mark

QA Inspector

**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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Port of West, St. Mary, LA**Prime Contractor:** MCM Construction, Inc.**Submitting Contractor:** Twin Brothers Marine**Report No:** NCS-000061**Date:** 23-Apr-2008**NCR #:** NCR-000073**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>Description:</b>	

**Date the Non-Conformance Report was written:** 18-Apr-2008**Description of Non-Conformance:**

At Around 9:30PM, this day, the QA Inspector noted Welder Corey Fontenette with ID number 275 welding without preheat. Mentioned welder was welding on the root of girth weld of cans BA-202 to BA-207 Pile segment B17R7-2 when this was discovered. The QA Inspector verified the non conformance to the procedure WPS-PM-02-KK-CORPAC with the 275 degree temperature crayon and it clearly showed insufficient preheat. As stipulated in the WPS, the working contract document to this project, the minimum preheat shall be 275 degree Fahrenheit. The QC Inspector Russel Carpenter was informed regarding this infraction but QC could not take appropriate action as to stop the welder soon enough or by removing undesirable weld that could put strain to the base metal. Instead, the QC Inspector informed QA that the welder will continue and just do an x-ray onto that particular girth weld when it is complete. By not following this working procedure it clearly manifest of not adhering to the contract requirements thus this Non-Conformance Report (NCR) is issued.

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

Back gouge deeper than usual and MT before back welding.

**Corrective action taken:**

Gouged 15mm deep to remove linear indications and welded after preheat.

**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:**

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, (916) 813-3677, who represents the Office of Structural Materials for your project.

**Inspected By:** Madere, Mary

Quality Assurance Inspector

---

---

# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

---

---

**Reviewed By:** Fatemi,Mohammad

QA Reviewer