

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-000091**Prime Contractor:** MCM Construction, Inc.**Date:** 24-May-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000091**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 1.8 meter CISS pile E-22L-7
Procedural	Procedural	Description:	Rain water entering the weld zone

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

The QA Inspector observed the contractor allowed moisture (rain) into the immediate weld area while the weld and surrounding base material was maintained at 225 degrees F. The QA Inspector observed the water had crossed the weld area at several locations and pooled up on the landing. Upon the arrival of the QA Inspector at 0600 the temperature appeared to be maintained at 225 degrees F. The QA Inspector noted no welding was being performed when water entered the weld zone.

QA Inspector noted the top of the pile was open allowing rain water inside the pile.

Applicable reference:

AWS D1.1 2006 section 5.12.2

Caltrans Special Provisions field welding note K

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: 1030 via phone notification

Name of Caltrans Engineer notified: Caltrans Assistant Structures Representative Mark Baker

Time and method of notification: 1100 via phone conversation

QC Inspector's Name: Kevin Scrivner

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Perform magnetic particle testing of the entire weld prior to performing production 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.

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-000085**Prime Contractor:** MCM Construction, Inc.**Date:** 13-Jun-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000091**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: 24-May-2008**Description of Non-Conformance:**

The QA Inspector observed the contractor allowed moisture (rain) into the immediate weld area while the weld and surrounding base material was maintained at 225 degrees F. The QA Inspector observed the water had crossed the weld area at several locations and pooled up on the landing. Upon the arrival of the QA Inspector at 0600 the temperature appeared to be maintained at 225 degrees F. The QA Inspector noted no welding was being performed when water entered the weld zone.

QA Inspector noted the top of the pile was open allowing rain water inside the pile.

Contractor's proposal to correct the problem:

Perform magnetic particle testing of the entire weld prior to performing production welding.

Corrective action taken:

The weld was brought up to the required minimum preheat temperature, magnetic particle testing was performed prior to welding. After the welding was completed, the area where water came in contact with the weld joint was ground flush so ultrasonic testing could be performed in a transverse direction to check for transverse indications in the weld. This testing was performed in addition to the normal UT testing. Reference MCM-SUB-00593R00.

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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Inspected By: Levell,Bill

Quality Assurance Inspector

Reviewed By: Fatemi,Mohammad

QA Reviewer