

**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 #: 1825B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

**Location:** OTD Job Site @ Footing E18-R  
**Prime Contractor:** MCM Construction, Inc.  
**Submitting Contractor:** MCM Construction, Inc.

**Report No:** NCR-000109  
**Date:** 22-Aug-2008  
**NCR #:** NCR-000109

**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> Shear Rings
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Gouges in Base Metal	

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

Description of Non-Conformance: QA observed gouges into the flanges of the shear lug assemblies. These gouges were caused by the air arc removal of run-off welding tabs. MCM welders gouged into the base metal as seen below. These gouges are near the backing bar of the CJP welds. The following areas were observed to have the type of gouges as seen below. These areas are E18R P7W4, P7W5, P6W3, P6W2, P1W1, & P1W4. QC Dave Aultman was helpful in locating these areas. MCM was aware of the problem since August 13th when Dave Aultman notified MCM QCM, Chris Smith. Photographs below are of E18R pile 6 near weld 2. The gouge is 3.5" inches in Length X 5."inches (12mm) wide and approximately .125" (3mm) in depth. These pictured below maybe the worst case.

**Applicable reference:**

AWS D1.1 sections 5.15.4.2, 5.15.4.3 &amp; 5.15.4.4. Preparation of Base Metal

**Who discovered the problem:** Caltrans QA Kevin Carpenter**Name of individual from Contractor notified:** QCM Chris Smith**Time and method of notification:** 1430 by phone**Name of Caltrans Engineer notified:** CT Mark Baker**Time and method of notification:** By Phone @ 1430**QC Inspector's Name:** Dave Alutman**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 , 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:** Estabrook, James

**Reviewed By:** Fatemi, Mohammad

Structural Materials Rep

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Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**

**Location:** OTD Job Site @ Footing E18-R  
**Prime Contractor:** MCM Construction, Inc.  
**Submitting Contractor:** MCM Construction, Inc.

**Report No:** NCS-000107  
**Date:** 25-Sep-2008  
**NCR #:** NCR-000109

**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:** 22-Aug-2008**Description of Non-Conformance:**

Description of Non-Conformance: QA observed gouges into the flanges of the shear lug assemblies. These gouges were caused by the air arc removal of run-off welding tabs. MCM welders gouged into the base metal as seen below. These gouges are near the backing bar of the CJP welds. The following areas were observed to have the type of gouges as seen below. These areas are E18R P7W4, P7W5, P6W3, P6W2, P1W1, & P1W4. QC Dave Aultman was helpful in locating these areas. MCM was aware of the problem since August 13th when Dave Aultman notified MCM QCM, Chris Smith.

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

See MCM CWR #35 Repair gouges using WPS MCM-SMAW/FCAW-003G. Then visual inspection.

**Corrective action taken:**

See MCM-SUB-000763 R0

**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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<b>Inspected By:</b> Estabrook, James	Quality Assurance Inspector
<b>Reviewed By:</b> Fatemi, Mohammad	QA Reviewer