

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 #: 04-0120R4Cty: SF Rte: 80 PM: 12.6,13.2File #: 81.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

Location: Coolidge, Arizona
Prime Contractor: C.C. Myers
Submitting Contractor: Stinger Welding

Report No: NCR-000009
Date: 12-Sep-2008
NCR #: NCR-000009

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: ETI - South Truss Column A118A (FCM)
Procedural	Procedural	Descriptor:	Exceeding 1200°F during heat straightening, HSR-1A

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

The contractor exceeded 1200°F during 2nd application of heat straightening of FCM assembly, Column A118A. The contractor was using oxy-fuel torches to heat the web (phA118) and flange (A118A). The QC Inspector Dean Stults used a digital pyrometer to monitor the temperature of ASTM A709 Gr.50 F2 steel and observed / recorded a maximum temperature of 1216°F on the web. The QA Inspector witnessed this occurrence.

Applicable reference:

AWS D1.5 2002, section 3.7.3 & Heat Straightening Request - 1A

Who discovered the problem: Dean Stults, QC Inspector**Name of individual from Contractor notified:** Gary Gardner, QC Manager**Time and method of notification:** 1500 hours, 9-12-2008; verbal notification**Name of Caltrans Engineer notified:** Karen Wang**Time and method of notification:** over the phone, 09:30 am, 09-16-08**QC Inspector's Name:** Dean Stults**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

None provided at this time.

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 Jinesh Mehta, 1-951-840-0541, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	QA Inspector
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Reviewed By:	Hager, Craig	QA Inspector
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Contract #: 04-0120R4Cty: SF Rte: 80 PM: 12.6,13.2File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**

Location: Coolidge, Arizona
Prime Contractor: C.C. Myers
Submitting Contractor: Stinger Welding

Report No: NCS-000014
Date: 13-Jul-2009
NCR #: NCR-000009

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 12-Sep-2008**Description of Non-Conformance:**

The contractor exceeded 1200°F during 2nd application of heat straightening of FCM assembly, Column A118A. The contractor was using oxy-fuel torches to heat the web (phA118) and flange (A118A). The QC Inspector measured the maximum temperature on the web of ASTM A709 Gr.50 F2 steel at 1216°F.

Contractor's proposal to correct the problem:

The contractor states that only minimal section of steel was over-heated and was heated above 1200°F for a very short amount of time. The contractor proposes to leave the part as is. Reference Submittal 292-156.

Corrective action taken:

Heat Straightening monitoring was increased. Review of QC reports of heat straightening reports do not indicate any additional over-heating of steel. Additionally, QA verifications did not observe any steel being heated over 1200°F.

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 Jinesh Mehta, (707) 552-7715 (284), who represents the Office of Structural Materials for your project.

Inspected By: Croff,Scott

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer