

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES
 MATERIALS ENGINEERING AND TESTING 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
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Contract #: 04-0120E4
 Cty SF Rte 80 PM 13.4.13.8
 File # 31.25

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Salt Lake City, Utah**Date:** 10/04/2004**Prime Contractor:** Kiewit/ FCI/ Manson- Joint Venture (KFM)**Submitting Contractor:** Eaton Metal Products (EMP)**Type of problem:**

Welding <input checked="" type="checkbox"/>	Concrete <input type="checkbox"/>	Other <input type="checkbox"/>
Welding: <input checked="" type="checkbox"/>	Curing: <input type="checkbox"/>	Procedural: <input type="checkbox"/>
Joint fit-up: <input type="checkbox"/>	Coating: <input type="checkbox"/>	Other: <input type="checkbox"/>
Procedural: <input checked="" type="checkbox"/>	Procedural: <input type="checkbox"/>	

Description of Non-Conformance: Eaton Metal Products (EMP), Quality Control Manager (QCM), Jason Hart, requested Caltrans OSM inspector Bill Kent to witness a welding procedure specification (WPS) identified as PQR-B-U3c-S-Modified. The target welding parameter range was set at a disallowable range of 440 amps to 930 amps. This target range is in direct violation of the $\pm 10\%$ variation allowed for the amperage setting. EMP QCM stated that EMP previously completed a 25mm PQR plate at a high input range of 930 amps, identified as B-U2-S-High, and a 92mm PQR plate at a low input range of 440 amps, identified as B-U2-S-Low. In conclusion, EMP QCM stated that with PQR's B-U2-S-High and B-U2-S-Low completed, EMP wants to be able to have wide latitude in range in their welding parameters.

Applicable reference: AWS D1.5-2002 and Caltrans Special Provisions Addendum No. 2 Section 8-3.01 Note C**Who discovered the problem:** Caltrans OSM Quality Assurance Inspector James Cochran and Bill Kent**Name of individual from Contractor notified:** Mr. Jason Hart, EMP QCM**Time and method of notification:** October 4, 2004, 15:30 hrs, verbal with Mr. Jason Hart**Name of Caltrans Engineer notified:** Pedro Sanchez**Time and method of notification:** Telephone, 15:00,**QC Inspector's Name:** Jason Hart**Was the QC Inspector aware of problem:** No

Contractor's proposal to correct the problem: Jason Hart decided not to proceed with PQR-B-U3c-S-Modified procedure testing due to weld side bends failed at testing. Jason stated that this procedure is not going to be reproduced.

Comments: This report is for the purpose of determining general 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 Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By: James Cochran

Quality Assurance Inspector

Reviewed By: Neil Brown

Lead QA Inspector

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(Continued, Page 1 of 2)

Reviewed By: Neil Brown

Lead QA Inspector

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

333 Burma Rd.
Oakland, CA 94607
(510) 286-0538, (510) 286-0550 fax



Kiewit-FCI-Manson, JV
220 Burma Rd.
Oakland, CA 94607

Attn: Mr. Chris Webb

February 17, 2006

Contract No. 04-0120E4
04-SF-80-13.4, 13.8
SAS T1 & E2 Foundations
SFOBB-ESSSP

Letter No. 05.003.01-000835

Subject: NCR - Eaton Metal Products, 10/04/2004 (WPS Run With Disallowed Parameters)

Dear Christopher,

The Department issued a Non-conformance Report (NCR) at Eaton Metal Products (EMP) in Salt Lake City, Utah, on October 4, 2004. The NCR was generated when Mr. Jason Hart, EMP QC, requested that QA witness a welding procedure specification (WPS) identified as PQR-B-U3c-S-Modified. QA observed that the welding parameter, amperage, was set to the range of 440 amps to 930 amps, which did not comply with the allowable +/-10% variation.

Mr. Hart informed QA that this PQR would not be reproduced by EMP because the side bends for this procedure failed. This NCR is considered by the Department to be resolved.

If you have any questions or need additional information, please contact Mark Vilcheck at (510) 286-0526.

Sincerely,

<<< ORIGINAL SIGNED >>>

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03