

DEPARTMENT OF TRANSPORTATIONDIVISION 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

FAX: (707) 649-5493

Contract # : 04-0120E4
Cty SF Rte 80 PM 13.4. 13.8
File # 31 .25 B**QUALITY ASSURANCE - NONCONFORMANCE REPORT**

Location: Eaton Metal Products, Salt Lake City, Utah

Date: 11-01-05

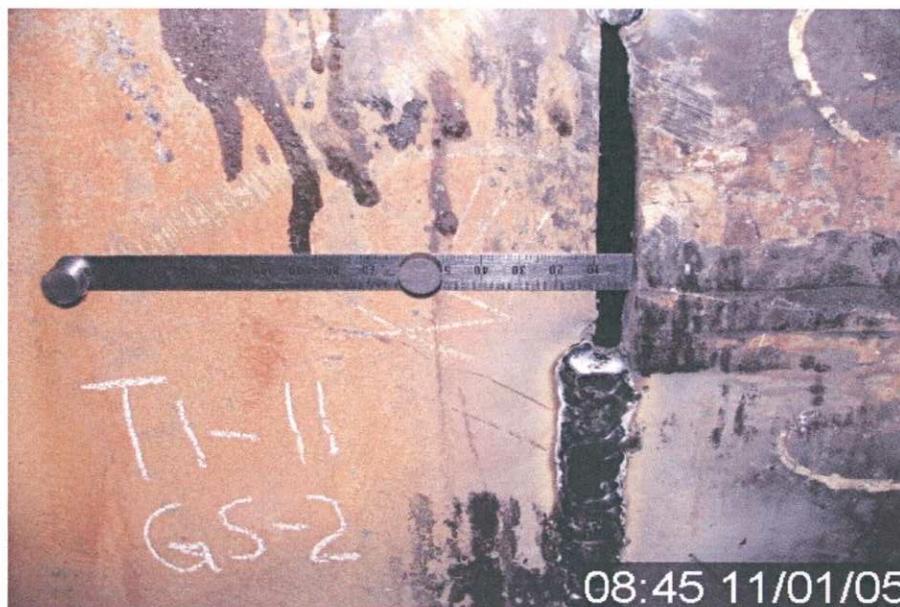
Prime Contractor: Kiewit/ FCI/ Manson (KFM), Joint Venture

Submitting Contractor: Eaton Metal Products (EMP)

Type of problem:

Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>	
Welding:	<input type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>	Bridge No.: Unknown
Joint fit-up:	<input checked="" type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>	Component: #T1 Pile Sleeves.
Procedural:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>			

Description of Non-Conformance: Complete joint penetration Girth Seam (GS) fit-up is not in compliance with contract requirements. EMP WPS B-U2c-S-Z allows for maximum root opening of 3mm (1/8"). QA observed GS-2 in T1-11 pile sleeve that is fit-up and tacked in preparation for submerged arc welding (SAW) with a maximum root opening of 9mm (see photo below). QA observed in the T-1 pile sleeve that is in process of fit-up on this date, a maximum root opening of 7mm in GS-2 (joining 75mm pile sleeve sections Mk-4 plate 16P to Mk-5 plate 8P). Eaton Metal Products representative Mr. Jason Hart was informed that QA has observed root openings that exceed 1/8" and do not appear to be in compliance with contract documents. Mr. Hart stated that root openings vary as necessary to maintain overall pile sleeve length. Mr. Hart stated that prior to the welding of a SAW inside diameter (ID) root pass, a full-length FCAW tack weld is installed in the ID groove, and EMP considers that the flux cord arc welding (FCAW) pass closes the root opening.



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QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Applicable reference: AWS D1.5, 2002, Section 2.12.1, Figure 2.4, EMP WPS B-U2c-S-Z

Who discovered the problem: Bert Madison, METS QA Inspector

Name of individual from Contractor notified: Jason Hart, EMP Quality Control Manager

Time and method of notification: 11-01-05, 1400 hours, verbal

Name of Caltrans Engineer notified: Mark Woods, Senior Structure Representative

Time and method of notification: November 4, 2005, via email

QC Inspector's Name: Jason Hart

Was the QC Inspector aware of problem: YES

Contractor's proposal to correct the problem: Unknown at this time.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: Bert Madison

Quality Assurance Inspector

Reviewed By: Robert Mertz

Lead QA Inspector

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 DIVISION OF ENGINEERING SERVICES
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 Cty SF Rte 80 PM 13.4. 13.8
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QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Eaton Metal Products, Salt Lake City, Utah

Date: 11-01-05

Prime Contractor: Kiewit/ FCI/ Manson (KFM), Joint Venture

Submitting Contractor: Eaton Metal Products (EMP)

Type of problem:

- | | | | | | | |
|----------------------|-------------------------------------|--------------------|--------------------------|--------------------|--------------------------|-------------------------------------|
| Welding | <input checked="" type="checkbox"/> | Concrete | <input type="checkbox"/> | Other | <input type="checkbox"/> | |
| Welding: | <input type="checkbox"/> | Curing: | <input type="checkbox"/> | Procedural: | <input type="checkbox"/> | Bridge No.: Unknown |
| Joint fit-up: | <input checked="" type="checkbox"/> | Coating: | <input type="checkbox"/> | Other: | <input type="checkbox"/> | Component: #T1 Pile Sleeves. |
| Procedural: | <input type="checkbox"/> | Procedural: | <input type="checkbox"/> | | | |

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QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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Who discovered the problem: Bert Madison, METS QA Inspector

Name of individual from Contractor notified: Jason Hart, EMP Quality Control Manager

Time and method of notification: 11-01-05, 1400 hours, verbal

Name of Caltrans Engineer notified:

Time and method of notification:

QC Inspector's Name: Jason Hart

Was the QC Inspector aware of problem: Yes.

Contractor's proposal to correct the problem: Unknown at this time.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: Bert Madison



Quality Assurance Inspector

Reviewed By: Robert Mertz



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

March 16, 2006

Attn: Mr. Christopher Villa
Deputy Project Director

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

Letter No. 05.003.01-000918

Subject: Response to Submittal No. 371, Revision No. 00 (Eaton Metal Products Response to NCR Issued by State Letter 787)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 371, Revision No. 00, dated March 1, 2006. This Submittal responded to the Department's Letter No. 787 dated February 9, 2006, which notified KFM of a Non-conformance Report (NCR) for Eaton Metal Products (EMP) dated November 1, 2005. The Department hereby approves Submittal No. 371, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for EMP dated November 1, 2005, is considered 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, 55.371

Memorandum

*Flex your power!
Be energy efficient!*

To: MARK VILCHECK
Structure Representative
333 Burma Road
Oakland, CA 94607

Date: March 15, 2006

File: 04-0120E4
E2/T1 Foundations

From: RYAN T. SMITH
Structural Materials Representative
Quality Assurance and Source Inspection Branch
Office of Structural Materials

KFM SUBMITTAL 371-00 – EATON METAL PRODUCTS (EMP) RESPONSE TO CALTRANS NONCONFORMANCE REPORT (NCR) NO. 019

The Caltrans Office of Structural Materials (OSM) has reviewed KFM Submittal 371-00, dated March 1, 2006, which contains the response to State Letter 05.003.01-000787.

NCR 019 was issued on November 1, 2005 after it was observed that the fit-up for Girth Seam (GS) No. 2 in pile sleeve No. T1-11 contained a maximum root opening that exceed that allowable by EMP's Welding Procedure Specification B-U2c-S-Z. The Department issued State Letter 05.003.01-000787, dated February 9, 2006, requesting a report providing explanation for the excessive root gap and the Contractor's proposed resolution to remedy the issues with GS No.2 and also in future pile sleeve fit-up operations.

As stated in EMP's letter dated February 27, 2006, the excessive root gap for GS No. 2 on pile sleeve T1-11 has been corrected and the material has been brought back into conformance with the approved WPS B-U2c-S-Z; thus OSM recommends NCR 019 be considered resolved.

If you have any questions, or would like to discuss the issues, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
Jim Cochran