

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES
 MATERIALS ENGINEERING AND TESTING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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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, UT

Date: 12-14-2005

Prime Contractor: Kiewit/ FCI/Manson (KFM)

NCR #30

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

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Description of Non-Conformance: QA on several occasions has observed nonconforming issues regarding grout bead welds that have been previously inspected and accepted by Eaton Metal Products Quality Control (QC) personnel that are non-compliant with the contract documents. These issues appear to be ongoing and have been documented in QA daily reports on 12/09/05 and 12/12/05, for pile sleeves E2-3, E2-7 and T1-3.

- On 12/09/05, EMP QC requested QA to select areas of grout beads for 25% QC MT inspection in pile sleeve sections E2-3, E2-7 and T1-3. QA representative performed a visual review of grout bead welding in each of these pile sleeve sections and observed areas of grout bead welds that do not visually appear to be in general compliance with contract documents. QA observed nonconforming conditions including undercut, porosity, overlap and areas of grout beads that appear to have a reentrant angle of less than 90°. QA informed EMP QC Mr. Doug Neilson and Mr. Neilson concurred with QA observations and agreed to re-inspect.
- On 12/12/05, QC presented pile sleeve E2-3 to QA for selection of areas of grout beads for 25% QC MT inspection. QA observed that some of the same areas of grout bead welds previously observed do not visually appear to be in general compliance with contract documents. QA representative informed QC Mr. Doug Neilson of QA observations of nonconforming areas. Mr. Neilson stated that QC Mr. Doug Reynolds would perform re-inspection at this location.
- On 12/12/05, QC presented pile sleeve T1-3 to QA for selection of areas of grout beads for 25% QC MT inspection. QA observed that some of the same areas of grout bead welds previously observed do not visually appear to be in general compliance with contract documents. QA representative informed QC Mr. Neilson of QA observations of nonconforming areas. Mr. Neilson stated that QC Mr. Reynolds would perform re-inspection at this location.
- On 12/12/05, QC again presented pile sleeve E2-3 to QA after re-inspection by QC Mr. Reynolds. QA observed that some of the same areas of grout bead welds previously observed do not visually appear to be in general compliance with contract documents. QA representative informed QC Mr. Doug Neilson of QA observations of nonconforming areas. Mr. Neilson stated that QC Mr. Doug Reynolds would perform re-inspection at this location.

Applicable reference: Special Provisions Section 10-1.31 Steel Structures, Shop Welding, paragraph G, items 2 through 4, Eaton Metal Products Welding Quality Control Plan, Section 8 - Inspection and Sections 6 of the AWS D1.5 - 2002 Bridge Welding Code.

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Who discovered the problem: Quality Assurance representative, Bert Madison

Name of individual from Contractor notified: Doug Neilsen, EMP Quality Control

Time and method of notification: 08:00 hours, 12-14-05, verbal notification

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: 12/15/05 at 1330 hours during the weekly fabrication meeting

QC Inspector's Name: Eaton Metal Products Quality Control Doug Neilson

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: None provided 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

April 10, 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. 05.003.01-001007

Subject: Response to Submittal No. 421, Revision No. 00 (Eaton Metal Products - Response to NCR Issued by State Letter 789)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 421, Revision No. 00, dated March 23, 2006. This Submittal responded to the Department's Letter No. 789 dated February 10, 2006, which notified KFM of a Non-conformance Report (NCR) for Eaton Metal Products (EMP) dated December 14, 2005. The Department hereby approves Submittal No. 421, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for EMP dated December 14, 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, 55.421