

**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  
 FAX: (707) 649-5493



Contract # : 04-0120E4  
 Cty SF Rte 80 PM 13.4/13.8  
 File # 31.25 B

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**QUALITY ASSURANCE - NONCONFORMANCE REPORT**


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Location: Eaton Metal Products, Salt Lake City, UT

Date: 12-22-2005

Prime Contractor: Kiewit/ FCI/Manson (KFM)

NCR #36

Submitting Contractor: Eaton Metal Products (EMP)

**Type of problem:**

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

**Description of Non-Conformance:** Eaton Metal Products (EMP) is performing critical weld repair (CWR) excavation without approval of the Engineer. Caltrans quality assurance (QA) inspector observed that EMP welding personnel, while performing grout bead repairs in pile sleeve T1-10, removed portions of grout bead welds resulting in inside diameter grooves in the base metal. QA inspector subsequently observed that the grooves in the base metal were welded utilizing the Flux Cored Arc Welding (FCAW) process. The repair welding at this location was not submitted as a Critical Weld Repair prior to gouging the base metal or welding the grooves.

**Applicable reference:** Eaton Metal Products Welding Quality Control Plan Section 10.2

**Who discovered the problem:** Quality Assurance representative, Bert Madison.

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

**Time and method of notification:** 14:30 hours, 12-22-05, verbal notification.

**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative

**Time and method of notification:** December 22, 2005 at 1135 hours via phone

**QC Inspector's Name:** Eaton Metal Products Quality Control Manager Mr. Jason Hart.

**Was the QC Inspector aware of problem:** No.

**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.

002836 JAN 13 05  
RECEIVED

Inspected By: Bert Madison

Quality Assurance Inspector

Reviewed By: Jim Cochran

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

May 12, 2006

Attn: Mr. Chris Webb  
Welding Quality Control Manager

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

Letter No. 05.003.01-001160

Subject: NCR - Eaton Metal Products, 12/22/05 (CWR Excavation Performed Without Approval)

Dear Chris,

The Department's Letter No. 829, dated February 16, 2006 informed Kiewit-FCI-Manson that a Non-conformance Report (NCR) was generated at Eaton Metal Products (EMP) in Salt Lake City, Utah on December 22, 2006. The NCR regards an unapproved critical weld repair (CWR) for the grout bead on pile sleeve T1-10. This NCR has been resolved by Submittal No. 268, Revision No. 01, dated March 23, 2006.

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

Sincerely,

Mark Vilcheck  
Structure Representative

For: Pedro J. Sanchez  
Resident Engineer

cc: P. Sanchez  
M. Woods  
R. Smith

file: 05.003.01, 09.006.03, 55.268

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## QUALITY ASSURANCE - NONCONFORMANCE REPORT

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Date: 12-22-2005

Prime Contractor: Kiewit/ FCI/Manson (KFM)

Submitting Contractor: Eaton Metal Products (EMP)

**Type of problem:**

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<b>Welding:</b> <input type="checkbox"/>	<b>Curing:</b> <input type="checkbox"/>	<b>Procedural:</b> <input type="checkbox"/>
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<b>Procedural:</b> <input checked="" type="checkbox"/>	<b>Procedural:</b> <input type="checkbox"/>	

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**Who discovered the problem:** Quality Assurance representative, Bert Madison.

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**Name of Caltrans Engineer notified:**

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**QC Inspector's Name:** Eaton Metal Products Quality Control Manager Mr. Jason Hart.

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Inspected By: Bert Madison

*Bert Madison*

Quality Assurance Inspector

Reviewed By: Robert Mertz

*Robert Mertz*

Lead QA Inspector