

**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

**QUALITY ASSURANCE - NONCONFORMANCE REPORT**

Location: Eaton Metal Products, Salt Lake City, UT

Date: 01-24-2006

Prime Contractor: Kiewit/ FCI/Manson (KFM)

NCR #040

Submitting Contractor: Eaton Metal Products (EMP)

**Type of problem:**

<b>Welding</b>	<input type="checkbox"/>	<b>Concrete</b>	<input type="checkbox"/>	<b>Other</b>	<input checked="" 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 checked="" type="checkbox"/> QC NDT Oversight
<b>Procedural:</b>	<input type="checkbox"/>	<b>Procedural:</b>	<input type="checkbox"/>		

**Description of Non-Conformance:** Caltrans Quality Assurance (QA) inspector located an area of weld metal not conforming to project specifications that was previously inspected and accepted by Professional Service Inspection (PSI) Quality Control (QC) UT Level II technician Mr. Wesley Muhlestein.

On this date, the QA inspector completed random ultrasonic testing (UT) for verification of completed and previously QC accepted complete joint penetration long seam welds associated with E2/T1 pile sleeves. One of the welds randomly examined, a non-conforming area was found to exist. The rejectable indication is identified by American Welding Society (AWS), Bridge Welding Code D1.5-2002, as a Class A. This nonconforming area is for the following weld on the listed pile sleeve.

Plate / long seam #	Date of QA UT verification testing / report.	QA Representative.
65mm Plate #24p mk# 3	01/24/06	Dave Flygare

**Applicable reference:** Eaton Metal Products Welding Quality Control Plan, Section 8 – Inspection; AWS D1.5:2002, Section 6.26.3.1 (Table 6.3 Tensile Stress), and Special Provisions Section 8-3.01 Welding.

**Who discovered the problem:** Quality Assurance representative, Dave Flygare

**Name of individual from Contractor notified:** James Barton, EMP Quality Control

**Time and method of notification:** 1630 hours, 01-25-06, verbal notification

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

**Time and method of notification:** 01/27/06 at 1000 hours via a conversation with the SMR

**QC Inspector's Name:** PSI Quality Control Mr. Wesley Muhlestein

**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.

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Inspected By: David Flygare

Quality Assurance Inspector

Reviewed By: Jim Cochran

Lead QA Inspector

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**QUALITY ASSURANCE - NONCONFORMANCE REPORT**

Location: Eaton Metal Products, Salt Lake City, UT

Date: 01-24-2006

Prime Contractor: Kiewit/ FCI/Manson (KFM)

Submitting Contractor: Eaton Metal Products (EMP)

**Type of problem:**

<b>Welding</b>	<input type="checkbox"/>	<b>Concrete</b>	<input type="checkbox"/>	<b>Other</b>	<input checked="" 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 checked="" type="checkbox"/> QC NDT Oversight
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**Description of Non-Conformance:** Caltrans Quality Assurance (QA) located an area of weld metal not conforming to project specifications that was previously inspected and accepted by Professional Service Inspection (PSI) Quality Control (QC) UT Level II technician Mr. Wesley Muhlestein.

On this date, the QA inspector completed random ultrasonic testing (UT) for verification of completed and previously QC accepted complete joint penetration long seam welds associated with E2/T1 pile sleeves. One of the welds randomly examined, a non-conforming area was found to exist. The rejectable indication is identified by American Welding Society (AWS), Bridge Welding Code D1.5-2002, as a Class A. This nonconforming area is for the following weld on the listed pile sleeve.

Plate / long seam #	Date of QA UT verification testing / report.	QA Representative.
65mm Plate #24p mk# 3	01/24/06	Dave Flygare

**Applicable reference:** Eaton Metal Products Welding Quality Control Plan, Section 8 – Inspection; AWS D1.5:2002, Section 6.26.3.1 (Table 6.3 Tensile Stress), and Special Provisions Section 8-3.01 Welding.

**Who discovered the problem:** Quality Assurance representative, Dave Flygare

**Name of individual from Contractor notified:** James Barton, EMP Quality Control

**Time and method of notification:** 1630 hours, 01-25-06, verbal notification

**Name of Caltrans Engineer notified:**

**Time and method of notification:**

**QC Inspector’s Name:** PSI Quality Control Mr. Wesley Muhlestein

**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: David Flygare *David Flygare* Quality Assurance Inspector  
 Reviewed By: Jim Cochran *Jac* 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 26, 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. 05.003.01-001277

Subject: NCR Resolution – Eaton Metal Products (12/14/2006, 01/24/2006, 01/31/2006 and 04/12/2006)

Dear Christopher,

The Department's Letter No. 1047, dated April 18, 2006, directed the Contractor to perform additional nondestructive testing (NDT) of welds in pile sleeves fabricated by Eaton Metal Products (EMP) for the Pier T1 and Pier E2 footings. Therefore, the NCRs for Eaton Metal Products dated December 14, 2005, January 24, 2006, January 31, 2006, and April 12, 2006 are 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