

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: 04-13-2006

Prime Contractor: Kiewit/ FCI/Manson (KFM)

NCR #077

Submitting Contractor: Eaton Metal Products (EMP)

Type of problem:

Welding	<input type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input checked="" type="checkbox"/>
Welding:	<input type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/> Bridge No.: ##34-0006L/R
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input checked="" type="checkbox"/> Component: #Pile sleeve T1-11
Procedural:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>	<u>QC inspector accepting nonconforming items.</u>	

Description of Non-Conformance: The Caltrans QA inspector performed random ultrasonic testing (UT) sampling verification of a complete joint penetration (CJP) groove girth seam (GS) weld that was previously UT inspected by Eaton Metal Products contracted Quality Control (QC) UT Level II technician from Professional Service Inspection (PSI), Mr. Mike Butler.

The CJP groove girth seam is associated with pile sleeve T1-11. The QA inspector observed one nonconforming area in the GS weld joining the 75mm thick plate 17P, Mk#4, to the 75mm thick plate 7P, Mk#5. The area found by QA is identified by the American Welding Society, standard D1.5-2002, as being a Class A, large flaw, which is defined as being rejectable regardless of length.

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, Bert Madison.

Name of individual from Contractor notified: Doug Neilson, EMP Quality Control Inspector.

Time and method of notification: 14:00 hours, verbal notification.

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: April 17, 2006 at approximately 1630 hours via verbal notification

QC Inspector's Name: PSI Quality Control, Mr. Mike Butler.

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.

Inspected By: Bert Madison

Quality Assurance Inspector

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Reviewed By: James Cochran

Lead QA Inspector

Hardcopy Routing Instructions:

1. Resident Engineer

2. Inspecting Branch Contract File

3. Responsible Branch Contract File (with supporting documentation)

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Prime Contractor: Kiewit/ FCI/Manson (KFM)

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Welding:	<input type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>	Bridge No.: ##34-0006L/R
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input checked="" type="checkbox"/>	Component: #Pile sleeve T1-11
Procedural:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>	QC inspector accepting nonconforming items.		

Description of Non-Conformance: Quality Assurance (QA) inspector performed random sampling verification of quality control (QC) ultrasonic testing (UT) of complete joint penetration girth seam (GS) weld in pile sleeve T1-11. The QA inspector observed one nonconforming area in the GS weld joining the 75mm thick plate 17P, Mk#4, to the 75mm thick plate 7P, Mk#5. This nonconforming area has been previously tested and accepted by Professional Service Inspection (PSI) QC UT Level II technician Mr. Mike Butler. This is a class "A" ultrasonic indication.

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, Bert Madison.

Name of individual from Contractor notified: Doug Neilson, Quality Control Inspector.

Time and method of notification: 14:00 hours, verbal notification.

Name of Caltrans Engineer notified:

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QC Inspector's Name: PSI Quality Control Mr. Mike Butler.

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.

Inspected By: Bert Madison

BF Madison

Quality Assurance Inspector

Reviewed By: James 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

June 20, 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. 05.003.01-001417

Subject: Response to Submittal No. 580, Revision No. 00 (Eaton Metal Products Response to NCR Generated by State Letter 1082)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 580, Revision No. 00, dated May 18, 2006. This Submittal responded to the Department's Letter No. 1082 dated May 3, 2006, which notified KFM of a Non-conformance Report (NCR) at Eaton Metal Products (EMP) dated April 13, 2006, for a failure by Mr. Butler (EMP QC inspector) to record rejectable indications in the Pier T1 pile sleeve girth seam. Regarding this Submittal, the Department understands that the Contractor has counseled Mr. Butler regarding the frequency of missing indications and that no subsequent failures to record rejectable indications have been detected. The Department hereby approves Submittal No. 580, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for EMP dated April 13, 2006, is considered to be resolved.

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

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, 55.580