

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
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Contract #: 04-0120E4
Cty SF Rte 80 PM 13.4/13.8
File # 1.25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: E2East Foundation

Date: 02-05-07

Prime Contractor: Kiewit/FCI/Manson-KFM-JV

NCR #142

Submitting Contractor: Kiewit/FCI/Manson-KFM-JV

Type of problem:

- Welding [X] Concrete [] Other []
Welding: [X] Curing: [] Procedural: [] Bridge No. 34-0006 L / R
Joint fit-up: [] Coating: [] Other: [] Component: E2E foundation footing
Procedural: [X] Procedural: [] Loss of preheat temperature

Description of Non-Conformance: The Contractor failed to maintain the preheat temperature during the welding of E2E pile head connector plates (PHCP) as required by Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connector Plates, Line F. The loss in preheat occurred on pile head connector plates (PHCP) Pile 5H2. A subsequent weld pass that had been deposited prior to the loss of heat. The Contractor elected to leave the weld in place and perform magnetic particle testing, bring the weld up to the required minimum preheat, and commence welding.

Applicable reference: Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connector Plates, Line F

Who discovered the problem: QA Inspector, Alfredo Acuna

Name of individual from Contractor notified: KFM Weld Superintendent, Dennis Winter

Time and method of notification: 02/05/07 at approximately 10:30 via verbal notification

Name of Caltrans Engineer notified: Saman Soheilifard, Caltrans Assistant Structure Representative

Time and method of notification: 1000 hours February 5, 2007 via telephone notification

QC Inspector's Name: Greg Martinez KFM QC

Was the QC Inspector aware of problem: No

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: Bill Levell [Signature]

Quality Assurance Inspector

Reviewed By: Albert Carreon [Signature]

Lead QA Reviewer

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Contract # : 04-0120E4
Cty SF Rte 80 PM 13.4/13.8
File # 1.25A

QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION

Location: SFOBB Jobsite

Date: February 26, 2007

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

NCR # 142

Submitting Contractor: Kiewit/FCI/Manson (KFM) – Joint Venture

Type of problem:

Welding [X] Concrete [] Other [X]
Welding: [] Curing: [] Procedural: []
Joint fit-up: [] Coating: [] Other: [X] Loss of preheat temperature
Procedural: [X] Procedural: []

Bridge No. 34-0006L/R Component E2 Foundation Footing

Date nonconformance report was written: February 5, 2007

Description of Non-Conformance: The Contractor failed to maintain the preheat temperature during the welding of E2E pile head connection plates (PHCP) as required by Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connector Plates, Line F. The loss of preheat occurred at the location identified as 5H2.

Contractor's proposal to correct the problem: The Contractor has implemented additional measures to prevent future occurrences of loss of preheat, such as elevation of the issue to the supplier of the heating equipment, periodic monitoring of the preheat consoles and monitoring by the night shift tug operators, and increased verification by the welders and Quality Control (QC) personnel during welding operations.

Corrective action taken: The Contractor performed Magnetic Particle Testing after the weld was brought back up to the minimum required preheat temperature.

Did corrective action require Engineer's approval? [X]Yes []No

If so, name of the Engineer providing approval: Structural Materials Representative (SMR) Date: 2-26-07
Ryan Smith, in accordance with response to KFM Letter.

Is Engineer's approval attached: [X]Yes []No

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: Bill Levell [Signature] Quality Assurance Inspector

Reviewed By: Ryan Smith [Signature] Structural Materials Representative (SMR)

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

February 27, 2007

Attn: Mr. Lee Zink
Project Director

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

Letter No. 05.003.01-002904

Subject: Response to Submittal No. 1335, Revision No. 00 (KFM Preheat NCR's 4, 5, 6)

Dear Lee,

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1335, Revision No. 00, dated February 7, 2007, which notified the Department of the Contractor's Non-conformance Report (NCR) Nos. 4, 5, and 6. Regarding these NCRs, the Department has already documented and notified the Contractor of the NCRs in the Department's Letter Nos. 2795, 2806, and 2807. In addition, the KFM Letter Nos. 239, 241, and 242 have already responded to these Department's letters. The Department's Letter No. 2901, dated February 26, 2007, was issued to close these NCRs. The Department has no further comments regarding Submittal No. 1335, Revision No. 00, and considers it closed.

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

Sincerely,

Mark Woods
Senior Bridge Engineer

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Vilcheck
R. Smith

file: 05.003.01, 09.006.03, 09.013, 55.1335

NON-CONFORMANCE REPORT

5

Location of Mat'l/Item: E2E Pile 2
Title/Description: Loss of preheat Pile 2 - D
Group: E2 Foundations
Superintendent: Joel Dodd
Foreman: Scott McCoy

Report of Condition/Cause of Non-Conformance:
 Temperature dropped at start of shift below 250 degree farenhiet, due to ventilation fans being started before shift and blowing onto pile.

Recommended Corrective Action:
 The source of air was removed from the pile and the heat was allowed to return to 250 degree Farenheit. The weld was MT inspected and documented and okayed to weld complete. Heat blankets are placed over weld areas, and welders have been instructed to ensure that fans are pointed away from metal at end of shift.

Originator Signature:	Date:	Superintendent Signature:	Date:
Joel Dodd	2/3/07	<i>Joel Dodd</i> Joel Dodd	2/3/2007

Designer Comments on Corrective Action:

Corrective Actions Verified Complete and Inspected:

Reference Documents:

Date Closed:	
Signature:	

NON-CONFORMANCE REPORT

6

Location of Mat'l/Item: E2E Pile 5 - H1&2
Title/Description: Loss of preheat Pile 2 Plate D Welds 1 & 2
Group: E2 Foundations
Superintendent: Joel Dodd
Foreman: Scott McCoy

Report of Condition/Cause of Non-Conformance:
 KFM had safety stand down on this date in the morning, plate was temp. sticked okay before stand down. At end of stand down, 3-4 hours later, when crew started back to work it was discovered that the 3/o camlock connection from the Cooperheat console to the heater blanket had failed. Metal temperature fell below 250 degree Fahrenheit.

Recommended Corrective Action:
 Caltrans was notified and cam lock connection was replace with a new one, pre-heat was then brought up to temperature, the weld was MT inspected, documented and okayed to weld complete.

Originator Signature:	Date:	Superintendent Signature:	Date:
Joel Dodd	2/5/07	<i>Joel O. Dodd</i> Joel Dodd	2/07/07

Designer Comments on Corrective Action:

Corrective Actions Verified Complete and Inspected:

Reference Documents:

Date Closed:	
Signature:	

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: February 26, 2007

File: 04-0120E4
E2/T1 Foundations

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

KFM LETTERS 230, 234, 238, 239, 240, 241, and 242 – RESPONSE TO METS NCRs 130, 131, 133, 134, 135, 137, 138, 139, 140, 141, 142, and 143

The Materials Engineering and Testing Service (METS) has reviewed KFM Letters 230 (01/29/07), 234 (01/31/07), 238 (02/15/07), 239 (02/15/07), 240 (02/15/07), 241 (02/15/07), and 242 (02/15/07). These letters have been written in response to the State Letter's notifying the Contractor of the nonconformance regarding their failure to maintain preheat on several E2 Pile/Sleeve Connector Plate (PSCP) welds.

As required by the contract Special Provisions, Section 10-1.31, "Field Welding", Line, F, the preheat and interpass temperature shall be in conformance with AWS D1.5, Section 12.14 and also shall be at least 65°C. Furthermore, the specification requires that the minimum preheat temperature shall be maintained continuously from beginning to completion of the entire weld, even if welding is interrupted. On multiple occasions in January and February 2007, METS inspectors documented that the Contractor failed to comply with this specification. The dates and affected welds are listed below:

NCR #	Date	PSCP Weld #
130	01/08/07	2G1, 2G2, 3G3, 3G4, 3H
131	01/10/07	3E1, 7F1, 7F2
133	01/12/07	6F2
134	01/16/07	6D2
135	01/17/07	6D1
137	01/19/07	6A2
143	01/20/07	6D2, 2E1

138	01/22/07	7B2, 2E2
139	01/31/07	2D1, 2D2, 3C3, 3C4, 3F3, 3F4, 2B3, 1D1, 1D2
140	02/02/07	4D2
141	02/03/07	2E3
142	02/05/07	5H2

As stated in the response letters, the Contractor believes they have identified the cause of the heating elements failures to be combination of the following:

1. Burnt heater connection cables
2. Thermocouple wires being incidentally knocked loose
3. Cooling air flow from ventilation fans

KFM Letter 230 specifically states that the Contractor has implemented additional measures to prevent future occurrences of the afore mentioned issues. These additional measures include:

1. Elevation of the issue to the supplier of the heating equipment in order to re-inspect the equipment and the Contractor's set-up.
2. Periodic monitoring of the preheat consoles and monitors by the night shift tug operators. The tug operators have been instructed to notify the Contractor in order to have someone repair the malfunction, should they witness any drop in temperature on the welds.
3. Increased checks by both the welder and the Quality Control inspector to ensure the heating equipment is working properly during welding operations. As stated in subsequent letters, the welders will be checking for burnt connectors and loose wires so that they can be replaced and/or corrected.

METS understands the power failure that occurred on January 31, 2007 to be an isolated case and does not expect similar issues in the future. Additionally, METS inspectors have noted no further instances of lost preheat since February 5, 2007 and considers NCRs 130, 131, 133, 134, 135, 137, 138, 139, 140, 141, 142, and 143 resolved at this time. However, should this issue reoccur, METS recommends the Department advise the Contractor that the issue shall be readdressed.