

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 # 1 .25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: E2East Foundation**Date:** 02-28-07 Wed**Prime Contractor:** Kiewit/FCI/Manson-KFM-JV**NCR #148 Rev.01****Submitting Contractor:** Kiewit/FCI/Manson-KFM-JV**Type of problem:****Welding** **Concrete** **Other** **Welding:** **Curing:** **Procedural:** **Bridge No.** 34-0006 L / R**Joint fit-up:** **Coating:** **Other:** **Component:** Pier E2E, Pile Head Connection Plate weld 8F3.**Procedural:** **Procedural:**

Description of Non-Conformance: KFM Welder Mr. Hugo Tlapa-Martinez was found to be welding outside the parameters of the Welding Procedure Specification (WPS). Mr. Tlapa-Martinez's parameters were measured by the Quality Assurance Inspector to be 285 amps, 26.0 volts, and a travel speed of 15.5 cm/m; in which the volts exceed the allowable range as stated in the approved WPS.

Additionally, the QC Inspector, Barry Drake, who measured the parameters was unaware that Mr. Tlapa-Martinez's volts were not in compliance with WPS FCV-001. At the time the QA Inspector discussed the issue with the QC Inspector it appeared that Mr. Drake was unaware that Mr. Tlapa-Martinez volts were not in compliance with the (WPS) mentioned above. Mr. Drake measured and recorded the parameters at 301 amps, 25.9 volts and a travel speed of 15.5 cm/m.

It should be noted that the QA Inspector calculated the heat input based on the parameters that were recorded and determined the maximum heat input had not been exceeded.

Applicable reference: KFM (WPS) FCV-001**Who discovered the problem:** QA Inspector Sherri Brannon**Name of individual from Contractor notified:** KFM Weld Superintendent, Dennis Winter**Time and method of notification:** January 28, 2007 at approximately 07:30 hours via verbal notification**Name of Caltrans Engineer notified:** Saman Soheilifard, Caltrans Structures Representative**Time and method of notification:** January 28, 2007 via verbal notification**QC Inspector's Name:** KFM/ISI Inspector Barry Drake**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.

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Inspected By: Sherri Brannon



Quality Assurance Inspector

Reviewed By: Albert Carreon/ Bill Levell



Lead QA Reviewer

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QUALITY ASSURANCE - NONCONFORMANCE REPORT

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Date: 02-28-07 Wed

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

NCR #148 Rev.01

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: Pier E2E, Pile Head Connection Plate weld 8F3.

Procedural: [X] Procedural: []

Description of Non-Conformance: KFM Welder Mr. Hugo Tlapa-Martinez was found to be welding outside the parameters of the Welding Procedure Specification (WPS). Mr. Tlapa-Martinez's parameters were measured by the Quality Assurance Inspector to be 285 amps, 26.0 volts, and a travel speed of 15.5 cm/m; in which the volts exceed the allowable range as stated in the approved WPS.

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Who discovered the problem: QA Inspector Sherri Brannon

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

Time and method of notification: January 28, 2007 at approximately 07:30 hours via verbal notification

Name of Caltrans Engineer notified: Saman Soheilifard, Caltrans Structures Representative

Time and method of notification: January 28, 2007 via verbal notification

QC Inspector's Name: KFM/ISI Inspector Barry Drake

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: Unknown at this time.

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QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Inspected By: Sherri Brannon

Quality Assurance Inspector

Reviewed By: Albert Carreon/ Bill Levell

Lead QA Reviewer

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Hardcopy Routing Instructions:

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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:** April 2, 2007**Prime Contractor:** Kiewit/FCI/Manson (KFM) – Joint Venture**NCR # 148, Revision 1****Submitting Contractor:** Kiewit/FCI/Manson (KFM) – Joint Venture**Type of problem:**

Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>
Welding:	<input checked="" 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"/>		

Bridge No. 34-0006L/R**Component** E2 Foundation Footing, Girder 201-1**Date nonconformance report was written:** February 28, 2007**Description of Non-Conformance:** The Contractor's Quality Control (QC) Inspector, Mr. Barry Drake, was unaware that welder Mr. Hugo Tlapa-Martinez was welding outside of the requirements of the welding procedure specification.**Contractor's proposal to correct the problem:** The QC Inspector was counseled regarding the proper inspection procedures when checking welding parameters and was moved to a part of the project that would allow him to become more familiar with the processes.**Corrective action taken:** The QC Inspector was removed from the E2 Project.**Did corrective action require Engineer's approval?** Yes No**If so, name of the Engineer providing approval:** Structural Materials Representative (SMR) **Date:** 4-2-07
Ryan Smith, in accordance with response to KFM Letter 253.**Is Engineer's approval attached:** 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

Quality Assurance Inspector

Reviewed By: Ryan Smith

Structural Materials Representative (SMR)

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: April 2, 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 LETTER 253 – RESPONSE TO METS NONCONFORMANCE REPORTS
(NCR) 147 and 148**

The Materials Engineering and Testing Service (METS) has reviewed KFM Letter 253 dated March 22, 2007. This letter is requesting to close METS NCR's which was issued to the Contractor by State Letter's 05.03.01-0002905 and 05.03.01-0002936.

In February 2007, METS documented that the Contractor's Quality Control (QC) Inspector had accepted welding parameters that were outside the allowable ranges of the approved Welding Procedure Specifications (WPS) while welding girder G201-1. Through further investigation by METS personnel, it was discovered that the inspector did not have the correct WPS during the inspection.

Additionally, the same QC Inspector was found accepting parameters outside the allowable range of the WPS on a separate date. In this instance the QC Inspector had the correct WPS and failed to identify the nonconformance. In both instances, the QC Inspector and the Welding Quality Control Manger were notified immediately.

As stated in the Contractor's response letter, this inspector was counseled regarding proper inspection procedures when checking welding parameters and was moved to a part of the project that would allow him to become more familiar with the processes. METS understands that the Contractor continues to monitor the QC Inspector's progress and METS considers NCRs 147 and 148 resolved at this time.

Mark Vilcheck
April 2, 2007
Page 2

If you have any questions, or would like to discuss the issues, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
Albert Carreon