

**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 #149**

**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:** E2E foundation footing

**Procedural:**  **Procedural:**

**Description of Non-Conformance:** The KFM Quality Control Inspector failed to record multiple Magnetic Particle Test (MT) relevant linear indications at various locations in the weld terminations. These indications were later discovered by the QA Inspector located at pile #3 plate A, weld 1 & 2-bottom, pile #3 plate B, weld 1 & 2-bottom, pile #3 plate C, weld 1-top, pile #3 plate D, weld-1-bottom and pile#3 plate E, weld-2-top and were not in compliance with code requirements. The QA Inspector noted that KFM/ISI QC Inspector's, Andrew Coffman and Bernard Docena previously accepted these welds.

**Applicable reference:** AWS D1.5-2002 section 6.26.2.1 and 6.26.2.3

**Who discovered the problem:** QA Inspector Sherri Brannon

**Name of individual from Contractor notified:** KFM Quality Control Manager, Kevin Carpenter

**Time and method of notification:** January 28, 2007 at approximately 1300 hours via verbal notification

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

**Time and method of notification:** February 28,2007 at approximately 1300 hours via verbal notification

**QC Inspector's Name:** KFM/ISI Andrew Coffman and Bernard Docena

**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: Sherri Brannon *Sherri Brannon*

Quality Assurance Inspector

Reviewed By: Bill Levell *[Signature]*

Lead QA Reviewer

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Date: 02-28-07 Wed

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

NCR #149

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

Type of problem:

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

Description of Non-Conformance: The KFM Quality Control Inspector failed to record multiple Magnetic Particle Test (MT) relevant linear indications at various locations in the weld terminations. These indications were later discovered by the QA Inspector located at pile #3 plate A, weld 1 & 2-bottom, pile #3 plate B, weld 1 & 2-bottom, pile #3 plate C, weld 1-top, pile #3 plate D, weld-1-bottom and pile#3 plate E, weld-2-top and were not in compliance with code requirements. The QA Inspector noted that KFM/ISI QC Inspector's, Andrew Coffman and Bernard Docena previously accepted these welds.

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Inspected By: Sherri Brannon

Quality Assurance Inspector

Reviewed By: Bill Levell

Lead QA Reviewer

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DEPARTMENT OF TRANSPORTATION

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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 # 149

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

Type of problem:

Welding [ ] Concrete [ ] Other [x]
Welding: [ ] Curing: [ ] Procedural: [ ]
Joint fit-up: [ ] Coating: [ ] Other: [x] Non-destructive Testing
Procedural: [ ] Procedural: [ ]
Bridge No. 34-0006L/R Component E2 Foundation Footing

Date nonconformance report was written: February 28, 2007

Description of Non-Conformance: Two (2) Inspection Services, Incorporated (ISI) Quality Control (QC) Representatives, Andrew Coffman and Bernard Docena, failed to identify multiple relevant linear indications in the weld terminations while performing magnetic particle (MT) testing.

Contractor's proposal to correct the problem: The QC Inspectors were counseled and received additional training in MT procedures and techniques as well as a review of the ASTM E709 requirements.

Corrective action taken: The QC Inspectors received additional training in MT procedures and techniques and reviewed the requirements of ASTM E709.

Did corrective action require Engineer's approval? [x] 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 254.

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)

## 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 254 – RESPONSE TO METS NONCONFORMANCE REPORT (NCR) 149

The Materials Engineering and Testing Service (METS) has reviewed KFM Letter 254 dated March 22, 2007. This letter is requesting to close the METS NCR which was issued to the Contractor by State Letter's 05.03.01-0002937.

In February 2007, METS documented that two of the Contractor's Quality Control (QC) Inspector's had failed to record multiple indications using Magnetic Particle Testing (MT). As stated in the Contractor's response, these were relevant indications that should have been recorded by the QC Inspectors.

As stated in the Contractor's response letter, the Contractor believes these two inspectors had an increased workload and overlooked the indications while trying to complete their heavy workload. However, the Contractor has agreed this is not beneficial for the project and has taken steps to resolve the issue in the future. Notably the two technicians were counseled and received additionally training on MT procedures and techniques as well as review of the ASTM E709 requirements. METS understands that the Contractor continues to monitor the technician's progress and METS considers NCR 149 to be resolved at this time.

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