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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: E2West Foundation Date: 03-19-07

Prime Contractor: Kiewit/FCI/Manson-KFM-JV NCR #151

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: Loss of preheat temperature

Description of Non-Conformance: The Contractor failed to maintain the preheat temperature during the welding of E2W 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 6E1. Several subsequent weld pass that had been deposited prior to the loss of heat.

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

Who discovered the problem: KFM Superintendent, Joel Dodd on 3-18-07

Name of individual from Contractor notified: KFM Superintendent, Joel Dodd

Time and method of notification: 03/19/07 at approximately 07:00 via telephone notification

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

Time and method of notification: 1100 hours, 2007 via telephone notification

QC Inspector's Name: Kevin Carpenter, KFM QC

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: The contractor has issued a non-conformance report (NCR #10). The Contractor has elected to leave the weld in place and perform magnetic particle testing, bring the weld up to the required minimum preheat, and commence welding.

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 *Bill Levell* Quality Assurance Inspector

Reviewed By: Albert Carreon *Albert Carreon* Lead QA Reviewer

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NCR #151

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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:** **Loss of preheat temperature**

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

Time and method of notification: 1100 hours, 2007 via telephone notification

QC Inspector's Name: Kevin Carpenter, KFM QC

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: The contractor has issued a non-conformance report (NCR #10). The Contractor has elected to leave the weld in place and perform magnetic particle testing, bring the weld up to the required minimum preheat, and commence welding.

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: Albert Carreon

Lead QA Reviewer

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RECEIVED

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Contract # : 04-0120E4

Cty SF Rte 80 PM 13.4/13.8File # 1.25A**QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION****Location:** SFOBB Jobsite**Date:** April 2, 2007**Prime Contractor:** Kiewit/FCI/Manson (KFM) – Joint Venture**NCR #** 151**Submitting Contractor:** Kiewit/FCI/Manson (KFM) – Joint Venture**Type of problem:****Welding** **Concrete** **Other** **Welding:** **Curing:** **Procedural:** **Joint fit-up:** **Coating:** **Other:** **Procedural:** **Procedural:** **Bridge No.** 34-0006L/R**Component** E2 Foundation Footing**Date nonconformance report was written:** March 19, 2007**Description of Non-Conformance:** The Contractor failed to maintain the preheat temperature during the welding of E2W pile head connection plates (PHCP) identified as Pile 6E1 as required by Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connector Plates, Line F.**Contractor's proposal to correct the problem:** The Contractor issued a Non-Conformance Report (NCR) identified as NCR 010. The Contractor elected to leave the weld in place and perform Magnetic Particle (MT) Testing, then preheat and commence welding.**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?** 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 Submittal 1388-00, Notification of KFM NCR 010.**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)

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

Attn: Mr. Lee Zink
Project Director

April 4, 2007

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

Letter No. 05.003.01-003026

Subject: NCR - Kiewit-FCI-Manson, 03/19/07 (Failure to Maintain Preheat Temperature)
Response to Submittal No. 1388, Revision No. 00 (NCR 10)

Dear Lee,

The Department issued a Non-conformance Report (NCR) at the SAS T1/E2 Foundations project site on March 19, 2007. The NCR was generated when the Contractor failed to maintain the preheat temperature as required by the Special Provisions, Section 10-1.31, Subsection "Field Welding of Pile/Sleeve Connector Plates," Line F, during welding of Pier E2 Pile Head Connection Plate (PHCP) at pile E2W-6 weld E1 on March 18, 2007. There were several weld passes that had been deposited prior to the loss of preheat. Mr. Joel Dodd, KFM Superintendent, discovered the problem and notified the Department via telephone on March 19, 2007.

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1388, Revision No. 00, dated March 20, 2007, which contained KFM NCR No. 10, issued to document the same issue of the above NCR. The Department understands that the Contractor has taken corrective actions to resolve the NCR. However, please note that the Department does not find it acceptable to allow the temperature of the PHCP welds to drop below their minimum preheat temperature. Furthermore, the Contractor should continue to improve their welding procedures so that the minimum preheat temperature can be maintained continuously from beginning to completion of the entire weld in accordance with the subsection "Field Welding of Pile/Sleeve Connector Plates," found in Section 10-1.31, "Structural Steel," of the Special Provisions.

The Department considers both this NCR and KFM Submittal No. 1388 (KFM NCR No. 10) to be resolved. However, the Department reserves the right to readdress this issue with the Contractor should it reoccur in the future.

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

Letter No. 05.003.01-003026
Kiewit-FCI-Manson
Page 2 of 2

Sincerely,

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Vilcheck
R. Smith

file: 05.003.01, 09.006.03, 09.013, 55.1388