

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:** 04-30-07**Prime Contractor:** Kiewit/FCI/Manson-KFM-JV**NCR #162****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:** E2W 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 plate weld (PHCP) 8A1 and 2. Several subsequent weld passes had been deposited on top of the root pass 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 4-30-07

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

Time and method of notification: 04/30/07 at approximately 06:00 via telephone notification

Name of Caltrans Engineer notified: Doug Wright, Caltrans Assistant Structure Representative

Time and method of notification: 0800 hours, 4-30-2007 via telephone notification

QC Inspector's Name: KFM/ISI QC, Kevin Carpenter

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: The contractor issued a non-conformance report (NCR #20). 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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Quality Assurance Inspector

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Lead QA Reviewer

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 6, 2007

Attn: Mr. Kevin Carpenter
Welding Quality Control Manager

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

Letter No. 05.003.01-003128

Subject: NCR - Kiewit-FCI-Manson, 04/30/07 (Failure to Maintain Preheat Temperature)
Response to Submittal No. 1436, Revision No. 00 (KFM NCR 20 Loss of Preheat E2W 8A1, 2)

Dear Kevin,

The Department issued a Non-conformance Report (NCR) at the SAS T1/E2 Foundations project site on April 30, 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-8 welds A1 and A2. Several subsequent weld passes had been deposited on top of the root pass prior to the loss of preheat. Mr. Joel Dodd, KFM Superintendent, discovered the problem on April 30, 2007, and notified the Department via telephone.

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1436, Revision No. 00, dated May 3, 2007, which contained KFM NCR No. 20, which documents the above noted issue. The Department understands that the Contractor has taken corrective actions to resolve the NCR. However, please note that the Department is concerned that this is an issue with multiple reoccurrences. The Department considers the NCR dated April 30, 2007, to be resolved.

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

Sincerely,

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03, 09.013, 55.1436