

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: E2W Pile Head Connection Plates (PHCP) 1B-4

Date: 05-14-2007

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

NCR #167

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 a E2W pile head connection plate (PHCP) as required by Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connection Plates, Line F. The loss in preheat occurred on PHCP pile 1, plate B, weld-4 and there were several subsequent weld passes deposited prior to the loss of heat.

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

Who discovered the problem: Welder Foreman, Scott McCoy

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

Time and method of notification: 05/14/07 at approximately 0600 via verbal notification.

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

Time and method of notification: 05/14/07 at approximately 0800 via telephone

QC Inspector's Name: Heydar Alakbarov

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: The Contractor elected to leave the weld passes in place, bring the weld up to the required minimum preheat, perform magnetic particle testing, 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: Raymond Lara 

Quality Assurance Inspector

Reviewed By: Albert Carreon 

Lead QA Reviewer

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QUALITY ASSURANCE - NONCONFORMANCE REPORT**Location:** E2W Pile Head Connection Plates (PHCP) 1B-4**Date:** 05-14-2007**Prime Contractor:** Kiewit/FCI/Manson-KFM-JV**NCR #167****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 a E2W pile head connection plate (PHCP) as required by Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connection Plates, Line F. The loss in preheat occurred on PHCP pile 1, plate B, weld-4 and there were several subsequent weld passes deposited prior to the loss of heat.**Applicable reference:** Caltrans Special Provisions, Section 10-1.31, Field Welding of Pile/Sleeve Connection Plates, Line F**Who discovered the problem:** Welder Foreman, Scott McCoy**Name of individual from Contractor notified:** KFM Superintendent, Joel Dodd**Time and method of notification:** 05/14/07 at approximately 0600 via verbal notification.**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative, Doug Wright**Time and method of notification:** 05/14/07 at approximately 0800 via telephone**QC Inspector's Name:** Heydar Alakbarov**Was the QC Inspector aware of problem:** Yes**Contractor's proposal to correct the problem:** The Contractor elected to leave the weld passes in place, bring the weld up to the required minimum preheat, perform magnetic particle testing, 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: Raymond Lara

Quality Assurance Inspector

Reviewed By: Albert Carreon

Lead QA Reviewer

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RECEIVED

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 18, 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. 05.003.01-003189

Subject: NCR - Kiewit-FCI-Manson, 5/14/07 (Failure to Maintain Preheat Temperature)

Dear Kevin,

The Department issued a Non-conformance Report (NCR) at the SAS T1/E2 Foundations project site on May 14, 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 the Pier E2 Pile Head Connection Plate (PHCP) at pile E2W-1 weld B4. There were several subsequent weld passes that had been deposited prior to the loss of preheat. Mr. Scott McCoy, KFM Welder Foreman, discovered the problem and verbally notified the Department on May 14, 2007.

As the pile head connection plate welding at Pier E2 is now complete, this NCR is hereby resolved. However, please describe what measures the Contractor will take or has taken to ensure that welding preheat shall be continuously maintained during the pile head welding at Pier T1.

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