

**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

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**QUALITY ASSURANCE - NONCONFORMANCE REPORT**


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**Location:** E2E Footing Box**Date:** 05-15-07 Fri**Prime Contractor:** Kiewit/FCI/Manson-KFM-JV**NCR #168****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 East Transition Girder 201-1  
**Procedural:**  **Procedural:**  Loss of preheat temperature

**Description of Non-Conformance:** The Contractor performed repair welding to the overhead Nelson studs on the underside of the bottom flange of the Southeast transition girder without an approved welding procedure specification (WPS). In addition the Quality Control (QC) Inspector was not notified prior to or during the welding so the electrical parameters could be verified and the welds inspected.

**Applicable reference:** Caltrans Special Provisions, Section 8-3 Welding, AWS D1.5 section 7

**Who discovered the problem:** Quality Assurance Inspector, Mike Foerder

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

**Time and method of notification:** 05/15/07 at approximately 1400 via verbal notification.

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

**Time and method of notification:** 05/15/07 via telephone notification

**QC Inspector's Name:** Andrew Coffman

**Was the QC Inspector aware of problem:** No

**Contractor's proposal to correct the problem:** No proposal 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: Michael Foerder 

Quality Assurance Inspector

Reviewed By: Albert Carreon 

Lead QA Reviewer

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TUES.

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Date: 05-15-07

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

NCR #168

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

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- Welding [X] Concrete [ ] Other [ ]
Welding: [X] Curing: [ ] Procedural: [ ] Bridge No. 34-0006 L / R
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Lead QA Reviewer

## Memorandum

*Flex your power!  
Be energy efficient!*

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

**Date:** July 25, 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 273 – RESPONSE TO METS NCR’S 168

The Materials Engineering and Testing Service (METS) has reviewed KFM Letter 273 dated June 25, 2007. This letter is requesting to close METS NCR’s 168 which was issued to the Contractor by State Letter 05.03.01-0003151.

In May 2007, METS documented that the Contractor’s Quality Control Inspector allowed a welder to perform a repair weld to the overhead Nelson studs on the Southeast transition girder without an approved welding procedure specification (WPS). In addition the Quality Control (QC) Inspector was not notified prior to or during the welding in order to properly verify the electrical parameters of the weld.

As stated in the Contractor’s response letter, the Contractor did not continue to weld with the WPS, instead used a WPS approved in KFM-SUB-1452. Additionally, the Contractor began tracking the stud welding on their 5-week schedule in order to provide adequate notice of welding and to assure proper QC coverage. METS inspectors have noted no further instances of the issue since that time and consider NCR 168 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