

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 13.4/13.80
File # 01 .25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: SFOBB Jobsite **JOBSITE NCR** **Date:** 10/18/2007

Prime Contractor: Kiewit/FCI/Manson (KFM) **NCR #213**

Submitting Contractor: KFM

Type of problem:

- Welding** **Concrete** **Other**
- Welding:** **Curing:** **Procedural:** **Bridge No.** 34-0006 L/R
- Joint fit-up:** **Coating:** **Other:** **Component:** T1 Foundation
- Procedural:** **Procedural:**

Description of Non-Conformance: The Contractor failed to maintain the pre-heat temperature during the welding of T1 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 of preheat occurred on PHCP weld 5B-2 for a length of 1 meter from the top of the plate down. The pre-heat temperature within this zone was between 200° F at the center of the span to 152° F at the top termination area.

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

Who discovered the problem: Quality Assurance Inspector, Ken Riley

Name of individual from Contractor notified: KFM Welding Foreman Scott McCoy

Time and method of notification: 10/18/07 at approximately 0930 hours, via verbal notification

Name of Caltrans Engineer notified: Assistant Structure Representative, Mark Baker

Time and method of notification: 10/18/07 at approximately 1600 hours, by telephone

QC Inspector's Name: Quality Control Inspector, Joselito Lizardo

Was the QC Inspector aware of problem: No

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Contractor's proposal to correct the problem: The contractor elected to leave the weld passes in place, bring the weld back up to the required minimum preheat temperature and perform magnetic particle testing prior to proceeding with the 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: Kenneth Riley Quality Assurance Inspector

Reviewed By: Albert Carreon 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

October 26, 2007

Attn: Mr. Rich Bienek
Welding Quality Control Manager

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

Letter No. 05.003.01-003616

Subject: NCR - Kiewit-FCI-Manson, 10/18/07 (Failure to Maintain Preheat)

Dear Rich,

The Department issued a Non-conformance Report (NCR) at the SAS T1/E2 Foundations project site on October 18, 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 T1 Pile Head Connection Plate (PHCP) at pile 5, weld B2. QA verbally notified Mr. Scott McCoy, KFM Welding Foreman, of this non-conformance on October 18, 2007.

The Department understands that the Contractor returned the weld to the minimum preheat temperature and that MT was performed on the in-place weld prior to resuming welding. The Department considers this NCR to be closed. However future instances of loss of preheat will be documented as necessary.

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