

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: 10/30/2007

Prime Contractor: Kiewit/FCI/Manson (KFM)

NCR #218

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 minimum pre-heat temperature of 225 degrees Fahrenheit during the welding of Critical Weld Repair #94 located on the top face (side A) of the T1 Lifting Lug Insert Plate designated as Insert Plate #1. Temperature indicating crayons (200 and 225 degree) were used to verify the temperature of the steel during the in process welding neither of which melted. It was noted that the welder was welding his final cover passes when the loss of pre-heat was discovered.

Applicable reference: KFM Critical Weld Repair #94 and AWS D1.5-02 Table 4.4

Who discovered the problem: Assistant Structure Representative, Mark Baker and METS Quality Assurance Inspector, Edward Leach

Name of individual from Contractor notified: KFM General Welding Foreman, Jim Belcher

Time and method of notification: 2100hrs-10/30/2007 – Verbal

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

Time and method of notification: 2110hrs-10/30/2007 – Verbal

QC Inspector's Name: Inspection Services, Inc. Quality Control Inspector Gary Ehram

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: Unknown.

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: Edward Leach

Quality Assurance Inspector

Reviewed By: Albert Carreon

Lead QA Reviewer

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Submitting Contractor: KFM

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

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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

November 6, 2007

Attn: Mr. Dan Proctor
Construction Manager

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

Letter No. 05.003.01-003628

Subject: NCR - Kiewit-FCI-Manson, 10/30/07 (Failure to Maintain Preheat Temperature)
Response to Submittal No. 1655, Revision No. 00 (KFM NCR 56 Preheat T1 1 D2)

Dear Dan,

The Department issued a Non-conformance Report (NCR) at the SAS T1/E2 Foundations project site on October 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 T1 Pile Head Connection Plate (PHCP) at pile 1 weld D2. Mr. Dan Smith, KFM QC Inspector, discovered the problem on October 30, 2007, and verbally notified the Department and Mr. Jim Belcher, KFM General Welding Foreman.

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1655, Revision No. 00, dated November 2, 2007, which contained KFM NCR No. 56, which documents the above noted issue. 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 the NCR dated October 30, 2007, and Submittal No. 1655, Revision No. 00, 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, 55.1655