

NON-CONFORMANCE REPORT	19
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Location of Mat'l/Item: E2 Footing West Pile 1, Plate D, Weld 3 & 4
Title/Description: Loss of preheat
Group: E2 Foundations
Superintendent: Joel Dodd
Foreman: Scott McCoy

Report of Condition/Cause of Non-Conformance: On Saturday evening, 4/28/07 pre-heat on PHW E2W-1D3&4, went below the specified 250 degree Fahrenheit. It was found that a thermocouple wire had a bad connection to the pile steel, this cause it to not send a consisted flow of heat to the heater blankets, this caused the second zone of heater blankets to burn up its cam lock connection due to excessive amounts of amperes being delivered. The heat dropped to 157 and 187 degree Fahrenheit on the two welds.
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Recommended Corrective Action:
The thermocouple wire connection was fixed and the cam lock connection was replaced by a KFM employee. The preheat was brought back up to the specified preheat of 250 degree Fahrenheit.
Caltrans was notified that KFM would write an NCR. The weld was MT inspected, documented and okayed to complete the final weld passes, as one weld was 100% and the other was 40% complete.

Originator Signature: <i>Joel D. Dodd</i>	Date: 4/30/07	Superintendent Signature: <i>Joel D. Dodd</i>	Date: 4/30/07
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Designer Comments on Corrective Action:

Corrective Actions Verified Complete and Inspected:

Reference Documents:

Date Closed:	
Signature:	

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

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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. 05.003.01-003127

Subject: NCR - Kiewit-FCI-Manson, 04/30/07 (Failure to Maintain Preheat Temperature)
Response to Submittal No. 1435, Revision No. 00 (KFM NCR 19 Loss of Preheat E2W 1D3, 4)

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-1 welds D3 and D4. There were several subsequent weld passes that 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 28, 2007, and notified the Department via telephone on April 30, 2007.

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1435, Revision No. 00, dated May 3, 2007, which contained KFM NCR No. 19, 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, 55.1435