

NON-CONFORMANCE REPORT	22
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Location of Mat'l/Item: E2 Footing West Pile 5, Plate H, 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 Tuesday morning, 5/08/07 it was discovered the pre-heat on PHW E2W-5H-3&4 , went below the specified 250 degree Fahrenheit.
It was observed by the night boat monitors that the preheat was dropping at around 03:00 in zones 1 and 10. Temperatures in the zones dropped to 209 and 207 degree Farhenhiet.
It was determined that the heater console powering the 2 zones had experienced a power surge causing the heater to stop sending amprere to the heater blankets.

Recommended Corrective Action:
The heater controls were activated, and the preheat was brought back up to specified temperature.
When the preheat was back up to the specified 250 degrees, and the weld completed and Mt'd afterwards .The welds that loss preheat had been completed 98% on one weld while the other was 100% welded. The weld was completed, 3 passes, by the welder after he was assure of preheat
Caltrans informed that KFM would write and NCR for this loss of preheat.
The welder and QC inspectors were talked to by the foreman about MT inspection prior to the start of welds after loss of preheat no matter how complete the welds are.

Originator Signature: <i>Joel D. Dodd</i>	Date: 5/09/07	Superintendent Signature: <i>Joel D. Dodd</i>	Date: 5/09/07
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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. 05.003.01-003129

Subject: NCRs - Kiewit-FCI-Manson, 05/09/07 (Failure to Maintain Preheat Temperature)
Response to Submittal No. 1450, Revision No. 00 (KFM NCR 21, 22 Loss of Preheat)

Dear Kevin,

The Department issued two Non-conformance Reports (NCRs) at the SAS T1/E2 Foundations project site on May 9, 2007. The NCRs were 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 E2E-8 welds A3 and A4, and pile E2E-5 welds H3 and H4. QA notified Mr. Joel Dodd, KFM QC Manager, via telephone of these non-conformances on May 8, 2007.

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1450, Revision No. 00, dated May 11, 2007, which contained KFM NCR Nos. 21 and 22, issued to document the same issue of the above NCRs. The Department understands that the Contractor has taken corrective actions to resolve the NCRs. However, please note that the Department is concerned that this is an issue with multiple reoccurrences. The Department considers the NCRs dated May 9, 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, 55.1450