

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 # 45 .25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Kiewit Offshore Services

Date: 02-21-2006

Prime Contractor: Kiewit/FCI/Manson (KFM) Joint Venture

NCR #052

Submitting Contractor: Kiewit Offshore Services

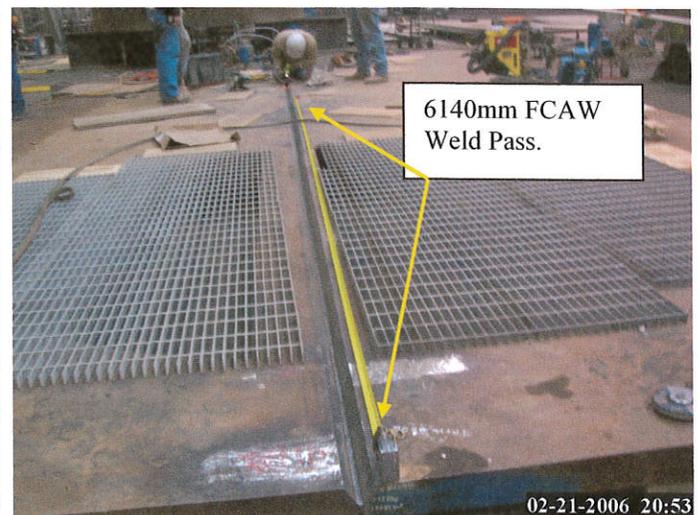
Type of problem:

Welding **Concrete** **Other**
Welding: **Curing:** **Procedural:**
Joint fit-up: **Coating:** **Other:**
Procedural: **Procedural:** <<Description>>

Bridge No.: #34-0006L/R

Component: # T1 Foundation Footing

Description of Non-Conformance: KOS performed welding without approved Procedural Fabrication Plan. Caltrans QA observed plate P37-A to P38-A bottom plate splice weld joint weld pass, welded with Flux Cored Arc Welding (FCAW) process. The measured weld length is recorded as 6140mm long and the FCAW weld pass appears to be backing weld to support the submerged arc welding (SAW) filler pass weld. The welder that performed the FCAW weld pass, is identified as welder stencil #8048, Mr. Andrew Carales. The following digital picture illustrates FCAW weld pass performed at the workstation.

**Applicable reference:** Special Provisions**Who discovered the problem:** Caltrans Quality Assurance Inspector, Mike Hasler**Name of individual from Contractor notified:** KOS Leadman Mr. Dick Smith and KOS/Walzel Quality Control Inspector, Mr. James Creech.**Time and method of notification:** 02/21/06 at 2000 hours, verbal notification**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative

TL-15, Nonconformance Report (10/27/05)

Page 1 of 2

Hardcopy Routing Instructions:

1. Resident Engineer

2. Inspecting Branch Contract File

3. Responsible Branch Contract File (with supporting documentation)

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Time and method of notification: 02/21/06 at approximately 0915 hours via a conversation in person

QC Inspector's Name: Mr. James Creech.

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: None 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: Mike Hasler *MH*

Quality Assurance Inspector

Reviewed By: Mahlon Lindenmuth *ML*

QA Reviewer

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Contract #: 04-0120E4
 Cty SF Rte 80 PM 13.8
 File # 45.25A

QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION

Location: Ingleside, Texas

Date: June 19, 2006

Prime Contractor: Kiewit/FCI/Manson (KFM) – Joint Venture

NCR#52

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:

Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>
Welding:	<input type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>
Procedural:	<input checked="" type="checkbox"/>	Procedural:	<input type="checkbox"/>		

Bridge No. 34-0006L/R

Component T1 Foundation Footing

Date nonconformance report was written: February 21, 2006

Description of Non-Conformance: KOS performed welding without an approved Fabrication Plan as required in the Special Provisions. Caltrans Quality Assurance (QA) Inspector Mr. Mike Hasler observed welding of bottom plate complete joint penetration weld splice joining bottom plate sections P37A and P38B for a length of approximately 6140 millimeters using the flux-cored arc welding (FCAW) process.

Contractor's proposal to correct the problem: KOS has submitted a Fabrication Plan also identified as KFM Submittal 642, Revision 0.

Corrective action taken: None

Did corrective action require Engineer's approval? Yes No

If so, name of the Engineer providing approval: Mark Vilcheck, per Caltrans state letter 05.003.01-001410

Date: 6-19-06

Is Engineer's approval attached: Yes No

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: Mary Madere

Quality Assurance Inspector

Reviewed By: Robert Cuellar & Keith Hoffman

Quality Assurance Reviewer and Branch Senior

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

June 19, 2006

Attn: Mr. Christopher Villa
Deputy Project Director

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

Letter No. 05.003.01-001410

Subject: Response to Submittal No. 642, Revision No. 00 (KOS Response to NCR Issued by State Letter 993)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 642, Revision No. 00, dated June 13, 2006. This Submittal responded to the Department's Letter No. 993 dated April 10, 2006, which notified KFM of a Non-conformance Report (NCR) at Kiewit Offshore Services (KOS) dated February 21, 2006, for welding without an approved procedural fabrication plan. Regarding this Submittal, the Department's Letter No. 1000 dated April 17, 2006, approved the KOS Fabrication Plan. The Department hereby approves Submittal No. 642, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for KOS dated February 21, 2006, is considered to be resolved.

If you have any questions or need additional information, please contact Mark Vilcheck at (510) 286-0526.

Sincerely,

<<< ORIGINAL SIGNED >>>

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03, 55.642

Memorandum

*Flex your power!
Be energy efficient!*

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

COMPLETED

Date: June 14, 2006
File: 04-0120E4
E2/T1 Foundations

From: RYAN T. SMITH
Structural Materials Representative
Quality Assurance and Source Inspection Branch
Office of Structural Materials

KFM SUBMITTAL 642-00 –KIEWIT OFFSHORE SERVICES (KOS) RESPONSE TO NCR 052

The Office of Structural Materials has reviewed the following submittals regarding requests to close Nonconformance Reports (NCRs) regarding the fabrication of the T1 Pile Cap in Ingleside, TX. The following submittals are approved or rejected with comments:

Submittal Number	Date of Submittal	Description	Approved/ Rejected	Notes
642	06/13/06	KOS Response to NCR 052	Approved	1

Notes:

1. The subject submittal is approved and resolves the NCR issued by State Letter 993. The Contractor shall be advised that although the Fabrication Plan (KFM Submittal 288) has been approved, the Dimensional Control Plan (KFM Submittal 293) and the Distortion Control Plan (KFM Submittal 301) are still pending approval.

If you have any questions, or would like to discuss the issues, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
Patryk Pich
Robert Cuellar