

DEPARTMENT OF TRANSPORTATIONDIVISION 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: **Ingleside, Texas**

Date: 5-30-06

Prime Contractor: **Kiewit/FCI/Manson (KFM) – Joint Venture**Submitting Contractor: **Kiewit Offshore Services (KOS)****Type of problem:**

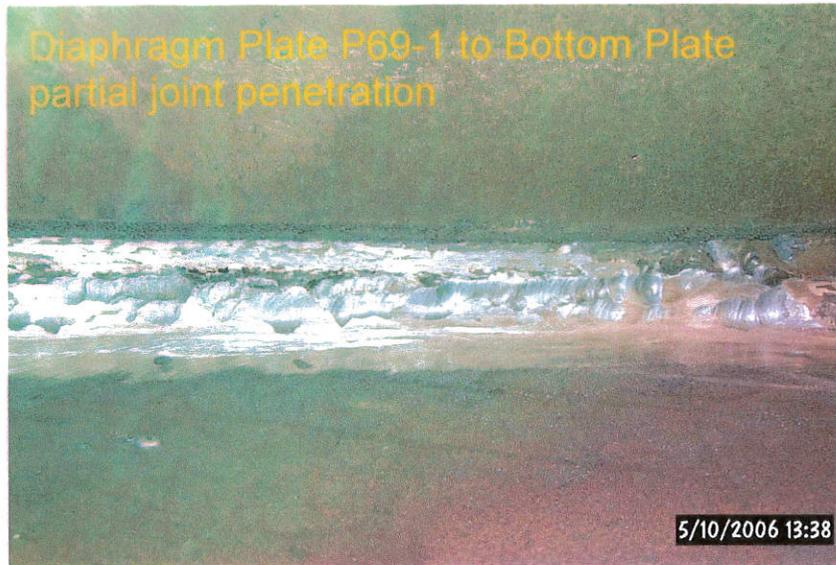
Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>	
Welding:	<input type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>	Bridge No.: #34-0006L/R
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>	Component: #T1 Foundation Footing
Procedural:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>			

Description of Non-Conformance: KOS Quality Control Inspector (QC), Mr. Ronald Deets, has shown systemic lapses in quality control by visually approving weld joints that were not in compliance with the code. The following are summaries of such instances:

- 1.) On May 10, 2006, Mr. Deets accepted weld preparation that was out of compliance with the Special Provisions and KOS approved shop drawings. A digital photograph below shows a partial penetration weld joint joining diaphragm plate P69-1 and the bottom plate with insufficient grinding after air carbon arc gouging. Mr. Deets visually accepted this weld joint on the above listed date.
- 2.) On May 15, 2006, Caltrans Quality Assurance Inspectors observed approximately 700 millimeters of undercut on complete joint penetration (CJP) weld joining diaphragm plate P69-1 to the center pile sleeve that was visually accepted by Mr. Deets.
- 3.) On May 22, 2006, a Quality Assurance Inspector observed a 0 to 3 mm root opening on diaphragm plate P83-1 to diaphragm plates P85-2 and P65-1 complete joint penetration welds. The required root opening for this CJP groove weld that uses a steel backing bar is four (4) to twelve (12) mm. Mr. Deets visually accepted this weld joint.
- 4.) On May 23, 2006, a Quality Assurance Inspector observed Mr. Deets as he accepted a CJP weld joining diaphragm plate p74-2 and diaphragm plate P69-1. The Quality Assurance Inspector observed visible rust in the weld zone.
- 5.) On May 23, 2006, a Quality Assurance Inspector witnessed Leonardo Ortiz perform magnetic particle inspection on critical weld repair number 004. The Quality Assurance Inspector observed undercut of three (3) mm deep for approximately 1200 mm of weld length of the repaired area. In addition, the base metal was excessively ground to 2 mm and was visually accepted by Mr. Deets.

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)



Applicable reference: 1.) Special Provisions, "The back gouged areas shall be ground to bright metal." Applicable to listed items 1 & 4. 2.) AWS D1.5 2002, Section 6.25.1.5 "In primary members, undercut shall be no more than 0.25 mm [0.01 in.] deep when the weld is transverse to tensile stress under any design loading condition. Undercut shall be no more than 1 mm [1/32 in.] deep for all other cases." Applicable to listed items 2 & 5. 3.) Welding Procedure Specification C FG 4 revision 1. Applicable to listed item 3

Who discovered the problem: Multiple Caltrans Quality Assurance Inspector's

Name of individual from Contractor notified: Verbal with George Barnhill

Time and method of notification: 1600 hours, May 30, 2006

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: June 1, 2006, 1045 via phone conversation

QC Inspector's Name: Ronald Deets

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: KOS QCM George Barnhill will review these issues with Mr. Deets and provide further training to alleviate future occurrences.

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, Patryk Pich (858-699-0514), who represents the Office of Structural Materials for your project.

Inspected By: Gregory Bertlesman

Quality Assurance Inspector

Reviewed By: Robert Cuellar

Lead QA Inspector

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Contract # : **04-0120E4**
Cty **SF** Rte **80** PM **13.4/13.8.**
File # **45.25 B****QUALITY ASSURANCE - NONCONFORMANCE REPORT**Location: **Ingleside, Texas**

Date: 5-30-06

Prime Contractor: **Kiewit/FCI/Manson (KFM) – Joint Venture**Submitting Contractor: **Kiewit Offshore Services (KOS)***NCR 094*
*Ⓢ***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"/>	Bridge No.: #34-0006L/R
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>	Component: #T1 Foundation Footing
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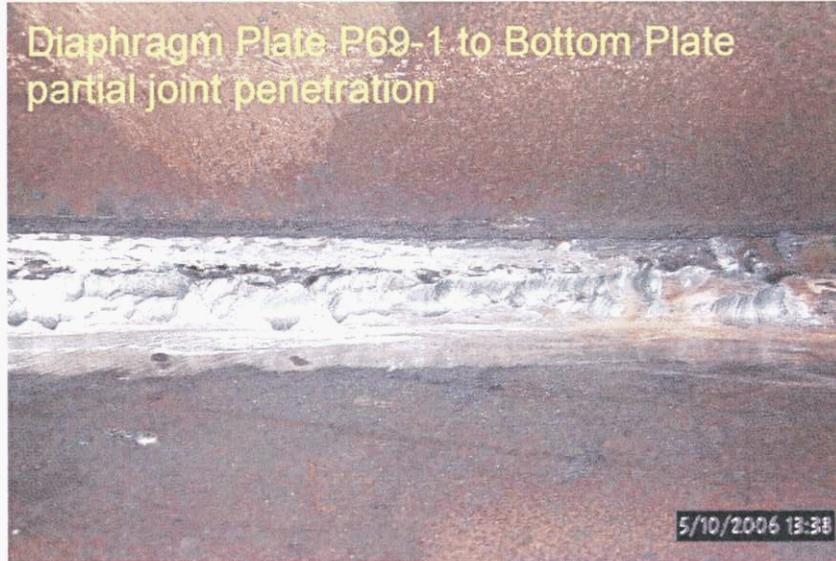
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QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)



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005328 JUN -1 06

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Name of individual from Contractor notified: Verbal with George Barnhill

Time and method of notification: 1600 hours, May 30, 2006

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Time and method of notification: June 1, 2006, 1045 via phone conversation

QC Inspector's Name: Ronald Deets

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: KOS QCM George Barnhill will review these issues with Mr. Deets and provide further training to alleviate future occurrences.

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, Patryk Pich (858-699-0514), who represents the Office of Structural Materials for your project.

Inspected By: Gregory Bertlesman

Quality Assurance Inspector

Reviewed By: Robert Cuellar

Lead QA Inspector

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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: July 17, 2006

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

NCR#94

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:

Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>
Welding:	<input checked="" 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 type="checkbox"/>	Procedural:	<input type="checkbox"/>		

Bridge No. 34-0006L/R

Component T1 Foundation Footing

Date nonconformance report was written: May 30, 2006

Description of Non-Conformance: KOS Quality Control (QC) Inspector Ronald Deets has shown systemic lapses in QC by visually approving weld joints that were not in compliance with the code. Five instances are documented on this non-conformance.

Contractor's proposal to correct the problem: KOS has generated Submittal 686, Revision 00.

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 **Date:** 7-17-06
05.003.01-001528

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

QA 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

July 17, 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. 05.003.01-001528

Subject: Response to Submittal No. 686, Revision No. 00 (KOS Response to NCR Issued by State Letter 1419)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 686, Revision No. 00, dated June 27, 2006. This Submittal responded to the Department's Letter No. 1419 dated June 20, 2006, which notified KFM of a Non-conformance Report (NCR) at Kiewit Offshore Services (KOS) in Ingleside, Texas, on May 30, 2006, for Mr. Ronald Deets, KOS QC Inspector, visually approving weld joints that were not in compliance with AWS D1.5:2002. The Department hereby approves Submittal No. 686, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for KOS issued on May 30, 2006, is considered 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, 55.686