

**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: **Ingleside, Texas**

Date: 7-15-06

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

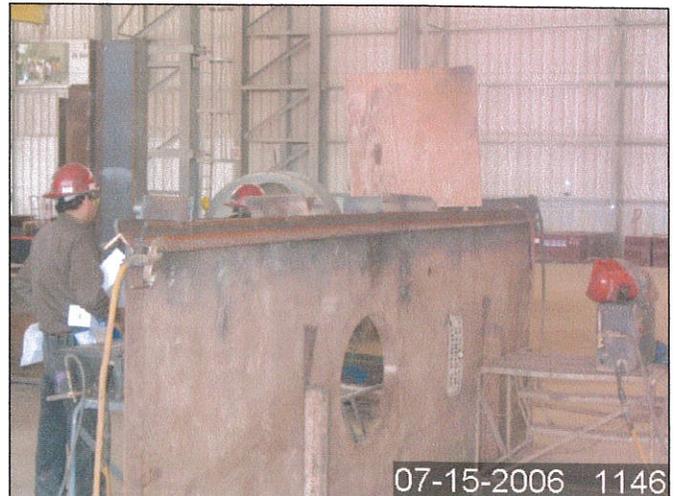
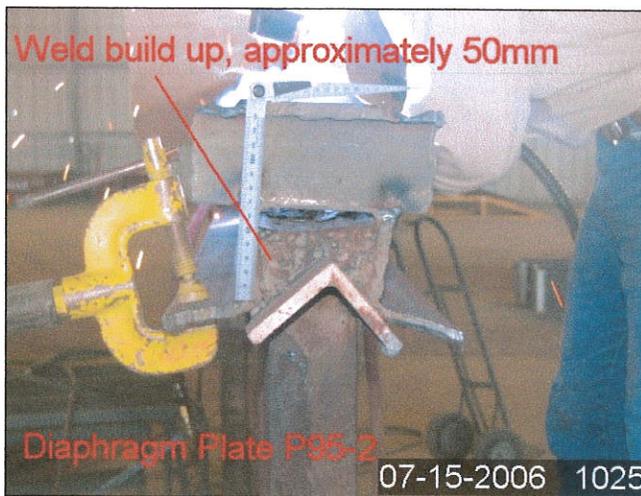
NCR #107

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 checked="" type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>	Component: #T1 Foundation Footing
Procedural:	<input checked="" type="checkbox"/>	Procedural:	<input type="checkbox"/>			

Description of Non-Conformance:

- 1.) KOS Quality Control (QC) Representative allowed KOS to build up diaphragm plate P95-2 by welding for the full length of 5320mm and a depth of approximately 50mm without prior approval from the Engineer.
- 2.) KOS Quality Control (QC) Inspector was not aware that KOS was welding on the identified diaphragm plate until the Caltrans Quality Assurance (QA) Inspector brought it to his attention at approximately 1045 hours. The shift on this date began at 0700 hours.
- 3.) The Caltrans QA Inspector measured the interpass temperature at KOS welder Mr. Pecina's station and found that it did not meet the minimum requirement of 107 degrees Celsius, using a 107 degree Celsius temperature indicating crayon.



Applicable reference: 1) AWS D1.5 2002 section 3.3.4.2 "Root openings larger than those allowed in 3.3.4.1 may be corrected by welding only with the approval of the engineer." Section 3.3.4.1 states "Root openings larger than those allowed in 3.3.4, but not greater than twice the thickness of the thinner part or 20 mm [3/4 in.], whichever is

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

less, may be corrected by welding to acceptable dimensions prior to joining the parts by welding.” 2.) Special Provisions Section 8-3.01. 3.) Welding procedure specification (WPS) C FG 3, Revision 1.

Who discovered the problem: Caltrans Quality Assurance Inspector Gregory Bertlesman

Name of individual from Contractor notified: KOS Quality Control Representatives (QC) Mr. Domingo Gonzales and Mr. George Barnhill

Time and method of notification: Verbal with Mr. Domingo Gonzales at 1045 on July 15, 2006, verbal with Mr. Barnhill at approximately 1000 hours on July 17, 2006

Name of Caltrans Engineer notified: Mark Vilcheck, Structural Representative

Time and method of notification: July 18, 2006, 1430 via telephone conversation

QC Inspector's Name: George Barnhill

Was the QC Inspector aware of problem: Yes

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: 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: 7-15-06

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

NCR #107

Submitting Contractor: Kiewit Offshore Services (KOS)

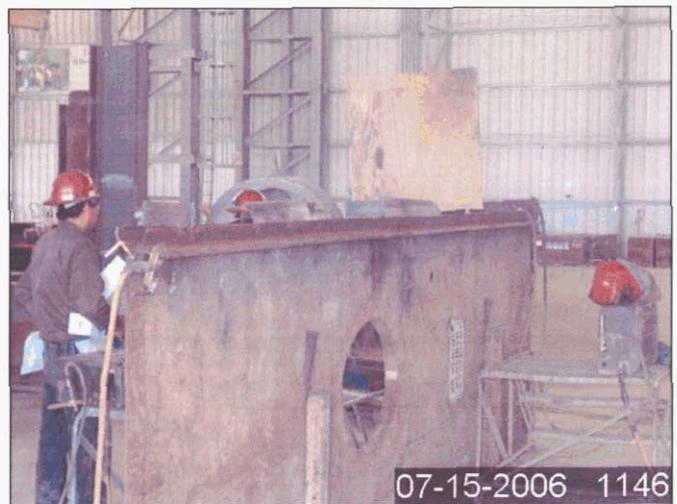
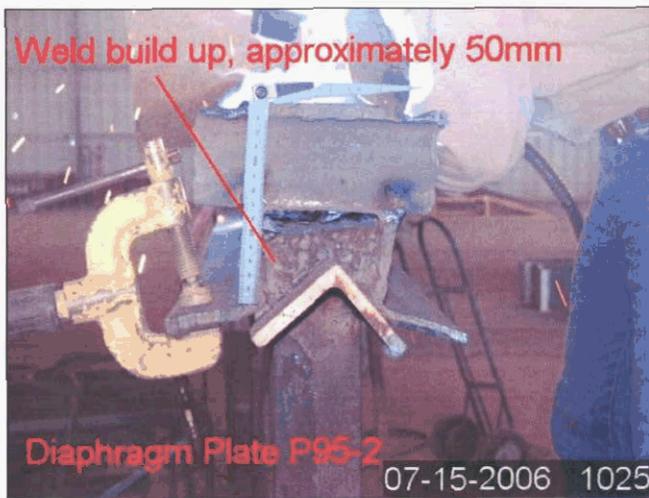
Type of problem:

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

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QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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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: September 19, 2006

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

NCR#107

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:

Welding	<input 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: July 15, 2006

Description of Non-Conformance: KOS Quality Control (QC) Representatives allowed KOS to butter diaphragm plate P95 without engineering approval.

Contractor's proposal to correct the problem: KOS has submitted Request for Information (RFI) 286 asking to lengthen the identified diaphragm plate.

Corrective action taken: None

Did corrective action require Engineer's approval? Yes No

If so, name of the Engineer providing approval: Mark Woods, per Caltrans state letter **Date:** 9-19-06
05.003.01-001957

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 *[Signature]*

Quality Assurance Inspector

Reviewed By: Robert Cuellar & Keith Hoffman *[Signatures]*

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

Attn: Mr. Lee Zink
Project Director

September 19, 2006

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

Letter No. 05.003.01-001957

Subject: Response to RFI No. 286, Revision No. 00 (KOS RFI 50 - Buttering of T1 Diaphragm P95)

Dear Lee,

RFI No. 286, Revision No. 00, pertains to Kiewit Offshore Service's (KOS) request to butter diaphragm plate P95 of the Pier T1 footing by adding 18mm to the original length. Regarding this RFI, the Department takes no exception to the request. However, the following shall be provided:

1. Both magnetic particle testing and ultrasonic testing of the buttered areas shall be performed as required by AWS D1.5:2002, Section 6.7.3.
2. Rejectable indications located in the buttered area during the nondestructive testing of the completed weld shall not be considered base metal indications and shall be repaired in accordance with the AWS D1.5:2002.

The Department also understands that this RFI is a response to the Department's Letter No. 1602 dated July 31, 2006, which notified Kiewit-FCI-Manson of a Non-conformance Report (NCR) for KOS dated July 15, 2006. The NCR for KOS dated July 15, 2006, is considered to be resolved.

If you have any questions or need additional information, please contact Mark Woods at (510) 622-5107.

Kiewit-FCI-Manson
Letter No. 05.003.01-001957
Page 2 of 2

Sincerely,

Mark Woods
Senior Bridge Engineer

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith
J. Duxbury

file: 05.003.01, 09.003.01, 09.006.03, 56.286