

**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 8.3 / 8.5  
 File # 13.25.B

## QUALITY ASSURANCE - NONCONFORMANCE REPORT

**Location:** Vancouver, Washington-Bay # 2

**Date:** 12-01-2004

**Prime Contractor:** Kiewit, FCI and Manson (KFM)- A Joint Venture

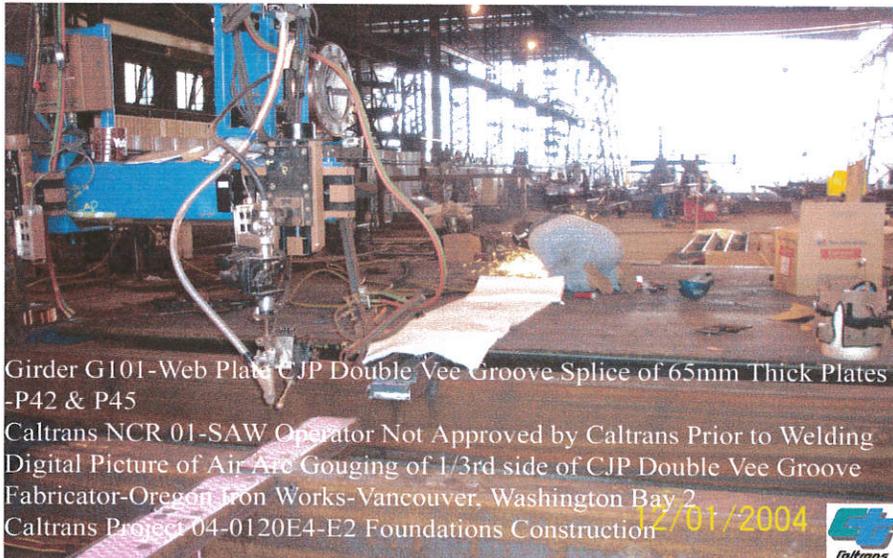
**NCR# 07**

**Submitting Contractor:** Oregon Iron Works-(OIW)

**Type of problem:**

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

**Description of Non-Conformance:** KFM's Quality Control Manager and onsite representatives allowed the contractor to proceed with the submerged arc welding (SAW) of an AWS D1.5 (2002) non-standard complete joint penetration groove weld using a SAW operator who has not been approved by Caltrans for use on this project. This SAW is being performed for joining two 65mm thick web plates identified as P42 and P45 for girder G101 using approved welding procedure specification 4227. OIW SAW operator Doug Elhart has applied filler passes to the large portion of the 70 degree included angle of the double vee groove. OIW welder Jeff Appel is performing air arc gouging to the smaller portion of the 45 degree included angle of the double vee groove as identified within the digital picture below



**Applicable reference:** Special Provisions section 8-3.01 Welding.

**Who discovered the problem:** Caltrans QA Inspector Robert Cuellar

**Name of individual from Contractor notified:** Mr. "Corky" Bates

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## QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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**Time and method of notification:** 12-01-04, verbally at 1425.

**Name of Caltrans Engineer notified:** Mark Vilcheck

**Time and method of notification:** Verbally by Steve Gilbert on 12/1/04.

**QC Inspector's Name:** Russ Lynch

**Was the QC Inspector aware of problem:** No

**Contractor's proposal to correct the problem:** No proposal has been submitted 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 Steve Gilbert, (858) 344-3839, who represents the Office of Structural Materials for your project.

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Inspected By: Robert Cuellar



Quality Assurance Inspector

Reviewed By: David McClary



QA Reviewer

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001369 DEC -2 2004



Contract # :04-0120E4  
 Cty SF Rte 80 PM 8.3 / 8.5  
 File # 13.25.B

## QUALITY ASSURANCE - NONCONFORMANCE REPORT

**Location:** Vancouver, Washington-Bay # 2**Date:** 12-01-2004**Prime Contractor:** Kiewit, FCI and Manson (KFM)- A Joint Venture**NCR#** 07**Submitting Contractor:** Oregon Iron Works-(OIW)**Type of problem:**

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

**Description of Non-Conformance:** KFM's Quality Control Manager and onsite representatives allowed the contractor to proceed with the submerged arc welding (SAW) of an AWS D1.5 (2002) non-standard complete joint penetration groove weld using a SAW operator who has not been approved by Caltrans for use on this project. This SAW is being performed for joining two 65mm thick web plates identified as P42 and P45 for girder G101 using approved welding procedure specification 4227. OIW SAW operator Doug Elhart has applied filler passes to the large portion of the 70 degree included angle of the double vee groove. OIW welder Jeff Appel is performing air arc gouging to the smaller portion of the 45 degree included angle of the double vee groove as identified within the digital picture below



Girder G101-Web Plate CJP Double Vee Groove Splice of 65mm Thick Plates -P42 & P45  
 Caltrans NCR 01-SAW Operator Not Approved by Caltrans Prior to Welding  
 Digital Picture of Air Arc Gouging of 1/3rd side of CJP Double Vee Groove  
 Fabricator-Oregon Iron Works-Vancouver, Washington Bay 2  
 Caltrans Project 04-0120E4-E2 Foundations Construction 12/01/2004

**Applicable reference:** Special Provisions section 8-3.01 Welding.**Who discovered the problem:** Caltrans QA Inspector Robert Cuellar**Name of individual from Contractor notified:** Mr. "Corky" Bates

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## QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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**Time and method of notification:** 12-01-04, verbally at 1425.

**Name of Caltrans Engineer notified:** Mark Vilcheck

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Inspected By: Robert Cuellar

Quality Assurance Inspector

Reviewed By: David McClary

QA Reviewer

**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

March 8, 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. 05.003.01-000891

Subject: Response to Submittal No. 343, Revision No. 00 (Oregon Iron Works Letter 63 - Response to Caltrans State Letter 635 - NCR Notification)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 343, Revision No. 00, dated February 17, 2006. This Submittal responded to the Department's Letter No. 635 dated December 9, 2005, which notified KFM of a Non-conformance Report (NCR) for Oregon Iron Works dated December 1, 2004. Regarding this Submittal, the Non-destructive Testing reports are acceptable, and the Department considers this NCR to be closed.

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, 55.343