

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

City SF Rte 80 PM 8.3/8.5File # 13.25 B**QUALITY ASSURANCE - NONCONFORMANCE REPORT****Location:** Oregon Iron Works, Clackamas, OR**Date:** 12-01-04**Prime Contractor:** Kiewit-FCI-Manson (KFM)- A Joint Venture**NCR # 08****Submitting Contractor:** Oregon Iron Works**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"/> <<Description>>
Procedural:	<input type="checkbox"/>	Procedural:	<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 sections of the 90mm thick ring flange identified as R07-1 using welding procedure specification 4227. OIW SAW operator Steve Vilhauer has applied filler passes to the large portion of the 70 degree included angle of the double vee groove.

Applicable reference: Special Provisions Sec. 8-3.01**Who discovered the problem:** Mark Wright Caltrans QA**Name of individual from Contractor notified:** Mr. "Corkey" Bates**Time and method of notification:** 12-01-2004,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:** Don Cox**Was the QC Inspector aware of problem:** yes**Contractor's proposal to correct the problem:** Submit welders for approval.

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.

Inspected By: Mark Wright

Quality Assurance Inspector

Reviewed By: Dave McClary

Reviewer

TL-15, Nonconformance Report (9/14/04)

Page 1 of 1

Hardcopy Routing Instructions:

1. Resident Engineer

2. Inspecting Branch Contract File

3. Responsible Branch Contract File (with supporting documentation)

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Inspected By: Mark Wright

Quality Assurance Inspector

Reviewed By: Dave McClary

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

August 7, 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. 05.003.01-001669

Subject: Response to Submittal No. 720, Revision No. 00 (OIW Response to NCRs Issued by State Letters 636 and 940)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 720, Revision No. 00, dated July 10, 2006. This Submittal responded to the Department's Letters No. 636 dated December 9, 2005, and No. 940 dated March 27, 2006. This Submittal provided the nondestructive testing reports for the welds performed by unapproved welder Mr. Vilhauer, requested in the Department's Letter No. 940.

The Department hereby approves Submittal No. 720, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for OIW dated December 1, 2004, 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, 55.720

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: August 3, 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 720-00 – OREGON IRON WORKS (OIW) RESPONSE TO CALTRANS NONCONFORMANCE REPORT (NCR) NO. 008

The Department issued State Letter 05.003.01-0000636, dated December 9, 2005 and State Letter 05.003.01-000940, dated March 27, 2006, requesting the Contractor's nondestructive testing (NDT) reports verifying the examination of the welds deposited by Mr. Steve Vilhauer on the complete joint penetration (CJP) weld of the 90-mm ring plate (R07-1) prior to December 1, 2006.

The Materials Engineering Testing Service (METS) has reviewed KFM Submittal 720-00 (response to OSM NCR 008) dated July 10, 2006. As stated in the OIW letter dated June 26, 2006, OIW has forwarded the requested NDT reports. METS finds the response to NCR 008 to be acceptable and considers the NCR to be resolved at this time.

If you have any questions or concerns regarding this issue, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
David McClary