

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 # 13.25B**QUALITY ASSURANCE - NONCONFORMANCE REPORT**

Location: Vancouver, WA.

Date: 3/28/2006

Prime Contractor: Kiewit, FCI & Manson (KFM) Joint Venture

NCR #066 Rev.1

Submitting Contractor: Oregon Iron Works (OIW)

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.: #34-0006

Component: # E2

Description of Non-Conformance: Oregon Iron Works Quality Control allowed Oregon Iron Works Welder Shannon Doolittle welder identification D-18 to perform welding on non-standard weld joints without being submitted and approved by the Engineer.. The welder was observed welding on a non standard single vee groove weld (40° angle). The welder was performing submerged arc welding in the flat position. Location of the welding was at SA1, at the junction of Girders 141-4/131-4 to Girder 121-2 top flanges.

Applicable reference: AWS D1.5-2002, Sec.5.21, Contract 04-012024 Special Provisions Section 8.3**Who discovered the problem:** Quality Assurance Inspector Joe Adame**Name of individual from Contractor notified:** Quality Control Inspector Russ Lynch**Time and method of notification:** In person at 1400.**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative**Time and method of notification:** March 29, 2006 at approximately 1300 hours via email**QC Inspector's Name:** Quality Control Inspector, Russ Lynch**Was the QC Inspector aware of problem:** No**Contractor's proposal to correct the problem:** No corrective 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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: Joe Adame

Quality Assurance Inspector

Reviewed By: Dave McClary

Lead QA Inspector

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Bridge No.: #34-0006

Component: # E2

Description of Non-Conformance: Oregon Iron Works Quality Control allowed Oregon Iron Works Welder Shannon Doolittle (welder identification D-18) to perform welding on non-standard weld joints without certification and without being submitted and approved by the Engineer. The welder was observed welding on a non-standard single vee groove weld (40° angle). The welder was performing submerged arc welding in the flat position on SA1, at the junction of Girders 141-4/131-4 to Girder 121-2 top flanges.

Oregon Iron Works Quality Control also allowed welder Darren Delozier (welder identification D-25) to perform welding on this project without certification and without being submitted and approved by the Engineer. This was performed on day shift of 03-28-06. The welder was performing flux core arc welding in the vertical position on a complete joint penetration weld on SA2, Pile Sleeve 303-1 to Girder 161-4 web plate.

Applicable reference: AWS D1.5-2002, Sec.5.21, Contract 04-012024 Special Provisions Section 8.3

Who discovered the problem: Quality Assurance Inspector Joe Adame

Name of individual from Contractor notified: Quality Control Inspector Russ Lynch

Time and method of notification: In person at 1400.

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: March 29, 2006 at approximately 1300 hours via email

QC Inspector's Name: Quality Control Inspector Russ Lynch

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: No corrective proposal has been submitted at this time.

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Inspected By: Joe Adame

Quality Assurance Inspector

Reviewed By: Dave McClary

Lead QA Inspector

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

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: Joe Adame

Quality Assurance Inspector

Reviewed By: Dave McClary

Lead QA Inspector

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

May 24, 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. 05.003.01-001246

Subject: Response to Submittal No. 542, Revision No. 00 (Oregon Iron Works Response to NCR Issued by State Letter 961)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 542, Revision No. 00, dated May 4, 2006. This Submittal responded to the Department's Letter No. 961 dated April 3, 2006, which notified KFM of a Non-conformance Report (NCR) for an unapproved welder performing production welding at Oregon Iron Works (OIW) dated March 28, 2006. The Department hereby approves Submittal No. 542, Revision Nos. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for OIW dated March 28, 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, 55.542

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: May 23, 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 542-00 – OREGON IRON WORKS (OIW) RESPONSE TO CALTRANS NONCONFORMANCE REPORT (NCR) NO. 066

The Department issued State Letter 05.003.01-000961, dated March 28, 2006, requesting the Contractor's proposal to alleviate future issues regarding the use of welders prior to the approval by the Engineer.

The Office of Structural Materials (OSM) has reviewed KFM Submittal 542-00 (response to OSM NCR 066) dated May 4, 2006. In accordance with the letter from OIW, dated April 27, 2006, Mr. Shannon Doolittle was qualified to perform submerged arc welding (SAW) in the 1G position prior to welding on girders 141-4/131-4 and 121-2 top flange. However, the Contractor had not submitted Mr. Doolittle's qualification records before allowing him to weld on the project.

As indicated in the subject submittal and through multiple conversations during the weekly fabrication meetings, the Contractor and Fabricator have advised the Department that they understand the requirement to obtain approval by the Engineer prior to allowing welders to work on the project. Additionally, the Contractor has indicated that they will ensure updated Welder Rosters have been submitted in a timely manner to alleviate future occurrences of this issue. OSM finds the response to NCR 066 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