

**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  
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Contract #: 04-0120E4  
 Cty SF Rte 80 PM 13.4, 13.8.  
 File # 20 .25.B

## QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Trans Bay Steel, Napa, CA.

Date: 02-21-2006

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

NCR #

Submitting Contractor: Trans Bay Steel

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 checked="" type="checkbox"/>	Procedural:	<input type="checkbox"/>		

Description of Non-Conformance: In process welding of pile segment interior of long seam complete joint penetration weld of E2 steel casing component N-10. Welding was submerged arc welding (SAW) per approved welding procedure specification WPS-P-317-B-U3c-S 45-65mm in the 1G (flat) position. Trans Bay Steel personnel Suphan Buakham was the welding operator.

The welder has tested, but is not approved to weld on this project as of this date.

Applicable reference: AWS D1.1 paragraph 1.4.2 Contractor's Responsibilities. The Contractor Special Provisions section 8 paragraph H. Copies of all certifications for welders for each welding process and position that will be used. Certifications shall list the filler metals used, test position, base metal and thickness, tests performed, and the witnessing authority. The submitted documentation shall be approved by the Engineer prior to any project welding being performed by a welder or welding operator. In addition, D1.1, paragraph 6.4.1 states the Inspector shall allow welding to be performed only by welders, welding operators, and tack welders who are qualified in accordance with the requirements of section 4. Additionally, Section 8-03 requires all welding personnel to be qualified and approved prior to starting work.

Who discovered the problem: Roscoe Dixon

Name of individual from Contractor notified: QCM Bill Kroplin

Time and method of notification: 02-21-06 verbally at approximately 1630

Name of Caltrans Engineer notified:

Time and method of notification:

QC Inspector's Name: Scott Martel

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: None 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: Roscoe Dixon Quality Assurance Inspector

Reviewed By: Robert Mertz 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

April 4, 2006

Attn: Mr. Chris Webb  
Welding Quality Control Manager

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

Letter No. 05.003.01-000988

Subject: NCR - Trans Bay Steel, 02/21/06 (Unapproved Welder Performing Production Work)

Dear Christopher,

The Department issued a Non-conformance Report (NCR) at Trans Bay Steel, Inc. (TBS) on February 21, 2006. The NCR was generated when QA observed that Mr. Suphan Buakham performed welding on E2 production piling using the submerged arc welding process in the flat position. Mr. Buakham was not approved for this work by the Engineer. Mr. Bill Kroplin, TBS QC Manager, was verbally notified of this non-conformance on February 21, 2006.

The qualifications of Mr. Buakham were provided in KFM Submittal No. 358, Revision No. 01, dated March 9, 2006, which was approved by the Department's Letter No. 929 dated March 21, 2006. This NCR is considered to be resolved. However, since this type of non-conformance appears to be reoccurring in nature, please provide an explanation of what steps the Contractor shall take to ensure that future welding production work is performed only by qualified personnel approved in advance by the Engineer.

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

