

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 # **20.25 B****QUALITY ASSURANCE - NONCONFORMANCE REPORT**Location: **Trans Bay Steel, Napa, Ca.**Date: **03-21-06**Prime Contractor: **Kiewit, FCI, Manson, (KFM) Joint Venture**NCR #**064**Submitting Contractor: **Trans Bay Steel (TBS)****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"/>	Bridge No.: 34-0006
Joint fit-up:	<input checked="" type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>	Component: Cast in Steel Shell Casing-"b-14"
Procedural:	<input checked="" type="checkbox"/>	Procedural:	<input type="checkbox"/>			

Description of Non-Conformance:

1. TBS was performing in process welding of pile segment B-14 (85mm thick) interior of long seam complete joint penetration weld with a non-standard included groove angle of 44 degrees without the approval of the Engineer. The welding was submerged arc welding utilizing the parameters from a prequalified welding procedure specification WPS-P-317-B-U3c-S 85-95mm in the 1G (flat) position, with 60 degrees included groove angle. Welding operator Oudalay Chindavong performed the welding of the root pass and welding operator Somporn Promkhan performed the welding of the fill passes. Neither of these welding operators have been approved to weld this non-standard joint detail on this project at this time. Note: The welding of this seam was not completed at the time the NCR was issued. The remaining portion of the weld was welded on a different shift.
2. TBS also performed this welding without having a qualified welding procedure specification (WPS) for the non-standard weld joint detail as required.

Applicable reference: Special Provisions Section 8-3.01, Welding**Who discovered the problem:** Quality Assurance Inspectors Joe Lanz and Mike Foerder**Name of individual from Contractor notified:** The QCM Bill Kroplin**Time and method of notification:** Verbally on this date at 1400.**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative**Time and method of notification:** March 21, 2006 via phone conversation**QC Inspector's Name:** John Page**Was the QC Inspector aware of problem:** Yes**Contractor's proposal to correct the problem:** Submit the PQR to the Engineer to support a WPS to be used in production once the testing is completed. Additionally, submit an RFI to the Engineer with a proposal to qualify the welding operators by means other than what is required in the Special Provisions.

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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: Michael Foerder

Quality Assurance Inspector

Reviewed By: Robert Mertz

Lead QA Inspector

DEPARTMENT OF TRANSPORTATION

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Contract # : 04-0120E4
 Cty SF Rte 80 PM 13.4/13.8
 File # 20.25A

QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION**Location:** Trans Bay Steel, Napa, CA.**Date:** 10-27-2006**Prime Contractor:** Kiewit, FCI, Manson, (KFM) Joint Venture**NCR#** 64**Submitting Contractor:** Trans Bay Steel (TBS)**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"/>
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 . : 34-0006**Component:** B-14**Date nonconformance report was written:** 03-21-2006**Description of Non-Conformance:**

Welding of non-standard joint on pile segment B-14 (85mm thick) interior of long seam CJP weld without the approval of the Engineer. Additionally, the welding operators (Oudalay Chindavong and Somporn Promkhan) were not qualified to weld this non-standard joint.

Contractor's proposal to correct the problem: Remove root pass welded by welder Oudalay Chindavong. Qualify welder Somporn Promkhan, and perform 100% ultrasonic testing (UT) of the completed weld.

Corrective action taken: Welder Oudalay Chindavong's root pass was removed and welder Somporn Promkhan completed the welding. RFI 203 approved as noted to allow qualifications on production material by State Letter 1086 dated 05/04/06. Submittal 484 rev 01, WQCP addendum 30: Addition of WPS-A-147-SAW and PQR-A-147-SAWS was approved on 05/09/06 by state letter 1129. Welder qualification for welder Somporn Promkhan was approved on 05/22/06 by state letter 1228. The weld joint was 100% examined by UT. Submittal 640 rev 0 was a response to state letter 962 that notified KFM of NCR 64. State Letter 1597 dated 7/26/06 approved submittal 640 and resolved the NCR.

Did corrective action require Engineer's approval? Yes No

If so, name of the Engineer providing approval: Mark Vilcheck**Date:** 7-26-2006**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 Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By: Bert Madison

Quality Assurance Inspector

Reviewed By: James Cochran

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

July 26, 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. 05.003.01-001597

Subject: Response to Submittal No. 640, Revision No. 00 (TBS Response to NCR Issued by State Letter 962)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 640, Revision No. 00, dated June 13, 2006. This Submittal responded to the Department's Letter No. 962 dated March 30, 2006, which notified KFM of a Non-conformance Report (NCR) at Trans Bay Steel, Inc., (TBS) in Napa, California, on March 21, 2006, for unapproved welders and an unapproved welding procedure specification. The Department hereby approves Submittal No. 640, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for TBS issued on March 21, 2006, is considered to be resolved.

If you have any questions or need additional information, please contact Mark Vilcheck at (510) 286-0526.

Sincerely,

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03, 55.640

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: June 30, 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 SUBMITTALS FOR TRANS BAY STEEL (TBS) RESPONSE TO NCRs

The Materials Engineering and Testing Service (METS) has reviewed the following submittals requesting to close Nonconformance Reports (NCRs) regarding the fabrication of the E2 and T1 Steel Piling in Napa, CA. Please find the following comments regarding NCRs:

Submittal Number	Date Submitted	Description	Approved / Rejected	Notes
789-00	08/11/06	TBS Response to NCR 93	Approved	1
790-00	08/11/06	TBS Response to NCR 56	Approved	2
808-00	08/18/06	TBS Response to NCR 88	Approved	3
809-00	08/18/06	TBS Response to NCR 86	Approved	4
810-00	08/18/06	TBS Response to NCR 84	Approved	5
811-00	08/18/06	TBS Response to NCR 82	Approved	6
812-00	08/18/06	TBS Response to NCR 64	Approved	7
813-00	08/18/06	TBS Response to NCR 73	Approved	8
815-00	08/18/06	TBS Response to NCR 85	Rejected	9

Notes:

1. In accordance with the TBS letter dated July 21, 2006, all long seam welds in pile sections D11 and E8 examined by Mr. Berchel White were reexamined by an approved Ultrasonic Testing (UT) Technician with an approved UT procedure. The documentation for this reexamination has been verified by METS in the Certificate of Compliance for the E2-5T. Additionally, TBS has indicated (both verbally and through the letter mentioned above) they have counseled Mr. White regarding the proper methods for performing UT inspection on the long seams of the piles. METS considers this NCR to be closed at this time.
2. The TBS letter dated August 11, 2006 documents TBS' removal of the area in question on pile section P-11 and the repair made by the approved welder. Furthermore, the area was examined by UT and Magnetic Particle Testing (MT) when the adjacent girth seam was inspected on a later date. Additionally, the repair of this area has been documented through TBS Critical Weld Repair (CWR) 001 which was approved by METS. METS finds this resolution to be acceptable and considers the NCR to be closed at this time. It should also be noted that the comments above were verbally issued to the Contractor on August 11, 2006 by METS personnel.
3. In accordance with the TBS letter dated August 17, 2006, the welder burned through the ST-5 stabbing guide while depositing the initial weld and did not understand that a CWR would be necessary to repair the area. It should be noted that METS has advised the Contractor that a CWR will be necessary to make similar repairs in the future. METS considers this NCR to be resolved at this time.
4. In accordance with the TBS letter dated August 17, 2006, the welders have received training regarding the use of proper preheat before welding the steel piling. As of the date of this memorandum, METS understands that the Contractor has addressed the issue as no further issues have been documented regarding improper preheat. METS considers this NCR to be resolved at this time.
5. As stated in the TBS letter dated August 17, 2006, the correct Welding Procedure Specification for the grout beads on the 85-mm material was not

posted at the time the grout beads were being welded on May 9, 2006. Although TBS indicates that a “corrected” WPS was posted during the production welding, it should be noted that the WPS referenced by TBS was not approved by the Department at the time of its use. The WPS (WPS-A-145 85mm 12mm Grout Beads) was not submitted for review until July 25, 2006 and approved by METS on July 31, 2006. However, METS understands that the approved preheat temperature was utilized during production welding even though the WPS was not approved by the Department. METS reminds the Contractor that Section 8-3.01 of the Special Provisions requires that WPS’s shall be approved by the Engineer prior to their use and that future violations of this specification may constitute rejection of the work affected. METS considers this issue to be resolved at this time.

6. As indicated in the TBS letter date August 17, 2006, the Contractor ground the fillet weld of the stabbing guide on pile section P-14 down to the approximate depth of the root pass and performed MT examination of the weld. The report of the MT examination was included as part of KFM Submittal 811-00. METS understands this will not be an issue in the future as this weld will no longer be performed in multiple passes. METS considers this issue to be resolved.
7. METS understands that this issue was resolved per KFM Submittal 640-00 which was approved by METS on July 24, 2006. Submittal 812-00 was not reviewed by METS personnel.
8. The letter issued by TBS indicates that WPS P-321-B-U2-GF ½” Plate Rev. 02 was submitted and approved by the Department. However, it should be noted that welding with this WPS began on April 9, 2006 but the WPS was not approved by METS until August 4, 2006 (KFM Submittal 473-03). METS reminds the Contractor that Section 8-3.01 of the Special Provisions requires that WPS’s shall be approved by the Engineer prior to their use and that future violations of this specification may constitute rejection of the work affected. METS considers this issue to be resolved at this time.
9. The Department issued NCR 085 on May 9, 2006, in order to document the Contractor’s use of an unapproved welder working on the steel piling. Although, the welder has since qualified in accordance with the contract Special Provisions and the Contractor has provided the NDT reports for the girth seam deposited (D13 to E5) by the unapproved welder; the issue of

Mark Vilcheck
August 30, 2006
Page 4

using welders who have not passed the required qualification testing still stands without recourse by the Contractor.

After numerous meetings between the Contractor and the Department regarding this issue, including involvement from the Fabrication, Action, and Solution Team (FAST), OSM understands that Contract Change Order (CCO) 039 has been drafted to address the use of a welder training program at TBS. OSM also understands that this CCO is still being negotiated with the Contractor as of the date of this memorandum. Thus, it is OSM's recommendation that this NCR remain open until the Department and the Contractor can come to an agreement regarding CCO 039. Should the CCO be agreed to by both parties, OSM recommends the closure of this NCR, and others documenting the same issue, be readdressed for closure. OSM will consider this issue to remain open until that time.

If you have any questions, or would like to discuss the issues, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
Jim Cochran