

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 **13.4/13.8.**
 File # **20.25 B**

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: **Trans Bay Steel (TBS) - 1025 Kaiser Road Napa, CA**Date: **Tues. 05/09/2006**Prime Contractor: **Kiewit, FCI, Manson, (KFM) Joint Venture**NCR # **084**Submitting Contractor: **Trans Bay Steel (TBS)****Type of problem:**

Welding **Concrete** **Other**
Welding: **Curing:** **Procedural:** **Bridge No.:** # 34-0006
Joint fit-up: **Coating:** **Other:** **Component:** Permanent Steel Casing E2
Procedural: **Procedural:** _____

Description of Non-Conformance: TBS Quality Control Inspectors allowed submerged arc welding (SAW) of the interior grout beads without an approved welding procedure specification (WPS) that shows the correct values for the minimum preheat and interpass temperature for the 85 mm thick segments. The WPS being utilized is WPS-A-145 12mm Grout Beads which reflects 65 degrees "C" (150 degrees F) as the minimum preheat. This issue has been relayed to the welding contractor previously with no remedial action performed as of this date.

The lack of adequate minimum preheat has been previously noted by the QA inspector on April 28th and May 5th in which the welding operators have been observed welding with the base metal adjacent to the welding below the minimum required 110 degrees "C" (225 degrees F) preheat.

Applicable reference: AWS D1.1, 2002, section 3.5 and Table 3.2.**Who discovered the problem:** OSM Quality Assurance Inspector James S. Bowers and Mike Foerder**Name of individual from Contractor notified:** TBS QCM Bill Kroplin**Time and method of notification:** 05-09-06 verbally at approximately 0930**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative**Time and method of notification:** May 10, 2006 via email at approximately 2015 hours**QC Inspector's Name:** Kurt Lightner**Was the QC Inspector aware of problem:** Not at the time the Quality Assurance Inspector noted**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: James S. Bowers

Quality Assurance Inspector

Reviewed By: Robert Mertz

Lead QA Inspector

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

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Hardcopy Routing Instructions:

1. Resident Engineer

2. Inspecting Branch Contract File

3. Responsible Branch Contract File (with supporting documentation)

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

September 6, 2006

Attn: Mr. Lee Zink
Project Director

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

Letter No. 05.003.01-001813

Subject: Response to Submittal No. 810, Revision No. 00 (Trans Bay Steel Response to NCR Issued by State Letter 1175)

Dear Lee,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 810, Revision No. 00, dated August 18, 2006, which responded to the Department's Letter No. 1175 dated May 12, 2006, which notified KFM of a Non-conformance Report (NCR) for Trans Bay Steel (TBS) dated May 9, 2006, for welding by TBS without an approved WPS. The Department reminds the Contractor that, per Section 8-3.01, "Welding," of the Special Provisions, WPS shall be approved by the Engineer prior to their use and that future violations of this specification may constitute refection of the work affected. The Department hereby approves Submittal No. 810, Revision Nos. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for TBS dated May 9, 2006, for welding by TBS without an approved WPS 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, 55.810