

**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 (TBS) - 1025 Kaiser Road Napa, CA**Date: **Tues. 05/09/2006**Prime Contractor: **Kiewit, FCI, Manson, (KFM) Joint Venture**NCR # **085**Submitting Contractor: **Trans Bay Steel (TBS)****Type of problem:**

<b>Welding</b>	<input checked="" type="checkbox"/>	<b>Concrete</b>	<input type="checkbox"/>	<b>Other</b>	<input type="checkbox"/>	
<b>Welding:</b>	<input checked="" type="checkbox"/>	<b>Curing:</b>	<input type="checkbox"/>	<b>Procedural:</b>	<input type="checkbox"/>	<b>Bridge No.:</b> # 34-0006
<b>Joint fit-up:</b>	<input type="checkbox"/>	<b>Coating:</b>	<input type="checkbox"/>	<b>Other:</b>	<input type="checkbox"/>	<b>Component:</b> E2 Permanent Steel Casing
<b>Procedural:</b>	<input checked="" type="checkbox"/>	<b>Procedural:</b>	<input type="checkbox"/>			

**Description of Non-Conformance:** 1. TBS Quality Control allowed the in process welding of the inside diameter girth seam between pile segments designated E-5 to D-13 (E2-Top) with an unqualified welding operator. The welding operator, Sathaporn Pornsririsak (ID-9030) performed the SAW for the majority of the 3<sup>rd</sup> shift. There is no record of this individual performing a qualification test for the non standard joint (approximate 40 degree included groove angle) per the contract documents.

2. Additionally, the TBS QC inspector allowed the welding operator to weld without maintaining the required minimum preheat and interpass temperature of 110 degrees "C" (225 degrees F) at any location along the weld joint.

**Applicable reference:** AWS D1.1, 2002, section 1.4.2 and section 6.4.1. and the Special Provisions, Section 8-3.01

**Who discovered the problem:** OSM Quality Assurance Inspectors Mike Garcia and Mike Foerder

**Name of individual from Contractor notified:** QC Inspector Kurt Lightner and TBS QCM Bill Kroplin

**Time and method of notification:** 05-09-06 verbally at approximately 0200 and 0930, respectively.

**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:** NO

**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: Mike Garcia

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

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. 05.003.01-001814

Subject: Response to Submittal No. 811, Revision No. 00 (Trans Bay Steel Response to NCR Issued by State Letter 1179)

Dear Lee,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 811, Revision No. 00, dated August 18, 2006, which responded to the Department's Letter No. 1179 dated May 12, 2006, which notified KFM of a Non-conformance Report (NCR) for Trans Bay Steel (TBS) dated May 8, 2006. The Department hereby approves Submittal No. 811, Revision Nos. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for TBS dated May 8, 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, 55.811