

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



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Contract # :04-0120E4
 Cty SF Rte 80 PM 8.3 / 8.5
 File # 10.25.B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Vancouver, Washington

Date: 12-13-2004

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

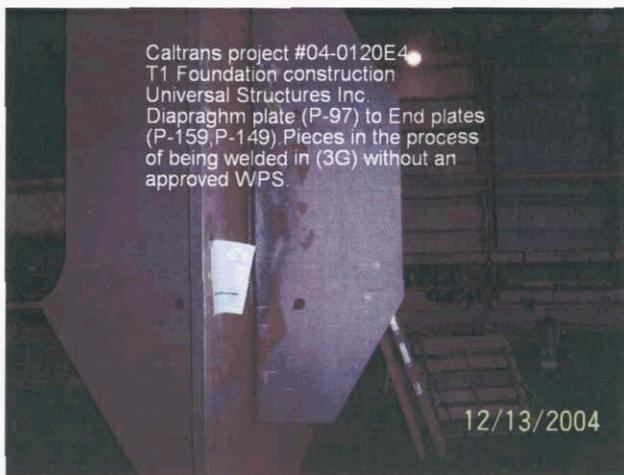
NCR# 12

Submitting Contractor: Universal Structural Inc.- (USI)

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"/> | | |

Description of Non-Conformance: OSM Quality Assurance Inspector Joe Adame observed items that are in non-conformance relative to the fabrication of a diaphragm plate identified as P-97 to end plate assemblies P-149 and P-159. The item in non-conformance is that USI is in the process of performing welding with the flux cored arc welding process in the vertical position (3G) without an approved welding procedure specification (WPS) for the joint being welded. The joint configuration that is being welded is a double bevel groove weld joint with a 45 included angle on each side. QA was informed by QC Lead Inspector Scott Reed that USI WPS 337A-14, which is the WPS in use, has been submitted but has not yet been approved by Caltrans for use on this project. The QC inspector informed QA that he would notify USI Quality Control Manager (QCM) Keith Stephenson. Included are digital pictures of the item in non-conformance.



Applicable reference: Caltrans Special Provisions Section.8-3 (Welding) & AWS D1.5-2002 Section 1.9.

Who discovered the problem: Caltrans QA Inspector Joe Adame.

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Name of individual from Contractor notified: QC Lead Inspector Scott Reed

Time and method of notification: 12-13-04, verbally at 15:00 pm.

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: Verbally on 12/14/04. Structure Rep. also called KFM QCM to notify on 12/14/04.

QC Inspector's Name: Scott Reed

Was the QC Inspector aware of problem: No

Contractor's proposal to correct the problem: No 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 Steve Gilbert, (858) 344-3839, who represents the Office of Structural Materials for your project.

Inspected By: Joe Adame

Quality Assurance Inspector

Reviewed By: David McClary

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

Attn: Mr. Chris Webb

February 17, 2006

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

Letter No. 05.003.01-000834

Subject: NCR - Universal Structural, Inc., 12/13/04 (Welding With Unapproved WPS)

Dear Christopher,

The Department issued a Non-conformance Report (NCR) at Universal Structural, Inc., in Vancouver, Washington on December 12, 2004. The NCR was generated when QA observed that USI performed welding on the connection of part No. P-97 to part Nos. P-149 and P-159 using an unapproved WPS.

The non-conforming weld was cut and removed to allow shipment of material from USI to Kiewit Offshore Services in Corpus Christi, Texas. This NCR is considered by the Department 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

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Contract # :04-0120E4
Cty SF Rte 80 PM 13.4,13.8
File # 10.25A

QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION

Location: Vancouver, WA.

Date: 10/25/05

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

Submitting Contractor: Universal Structural Inc. (USI)

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"/> | | |

Date nonconformance report was written: 12/13/04

Description of Non-Conformance: KFM Quality Control Manger (QCM) and onsite representatives allowed USI to weld in the vertical position (3G) without an approved "Welding Procedure Specification" (WPS). This was performed on Diaphragm Plate P-97 to End plate assemblies P-149 & P-159.

Contractor's proposal to correct the problem: At the time of the NCR no corrective proposal was submitted.

Corrective action taken: Weld was cut out for storage and shipping to new fabricator (KOS) in Texas.

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Did corrective action require Engineer's approval? Yes No

If so, name of the Engineer providing approval: N/A **Date:**

Is Engineer's approval attached: Yes No Defective weld removed.

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 QA Reviewer