

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING 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  
(707) 649-5493

Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: 1.25B


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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**


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**Location:** Jobsite**Report No:** NCR-000048**Prime Contractor:** MCM Construction, Inc.**Date:** 29-Feb-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000048**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> E-19L 1.8M CISS Pile
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	Failure to maintain the minimum required preheat

**Reference Description:****Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel, at 0600 failed to maintain preheat/interpass temperature at weld #1 and #6 for the shear ring to pile designated E19L-9, at weld #3 for the shear ring to pile designated E19L-6 and also at weld 2 for the shear ring to pile designated E19L-5. During the observation of the non-conformance production welding was not being performed on the filler weld passes at any of these welds. The loss of preheat occurred throughout the weld joint. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 225°F, but less than 250°F.

**Applicable reference:**

Caltrans Special Provisions Field Welding note J  
AWS D1.1 2006 Table 3.2 category C

**Who discovered the problem:** Caltrans QA inspector Charles Bookout**Name of individual from Contractor notified:** CWI QC inspector Kevin Scrivner**Time and method of notification:** 0630 in person**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 0745 telephone**QC Inspector's Name:** Kevin Scrivner**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Unknown

**Comments:**

This report is for the purpose of determining 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 Mohammad Fatemi, who represents the Office of Structural Materials for your project.

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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**Inspected By:** Bookout, Charles

**Reviewed By:** Levell, Bill

QA

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Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Jobsite**Report No:** NCS-000038**Prime Contractor:** MCM Construction, Inc.**Date:** 06-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000048**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 29-Feb-2008**Description of Non-Conformance:**

The QA Inspector observed MCM welding personnel, at 0600 failed to maintain preheat/interpass temperature at weld #1 and #6 for the shear ring to pile designated E19L-9, at weld #3 for the shear ring to pile designated E19L-6 and also at weld 2 for the shear ring to pile designated E19L-5. During the observation of the non-conformance production welding was not being performed on the filler weld passes at any of these welds. The loss of preheat occurred throughout the weld joint. The QA Inspector verified the preheat/interpass temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 225°F, but less than 250°F.

**Contractor's proposal to correct the problem:**

See below under corrective action taken. In addition, the contractor has submitted a request for information (RFI) numbered 288.

**Corrective action taken:**

The minimum required preheat/interpass temperature was restored and welding resumed.

**Did corrective action require Engineer's approval?** Yes No**If so, name of Engineer providing approval:** Per RFI response 288.**Date:****Is Engineer's approval attached?** Yes No**Comments:**

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**Inspected By:** Foerder, Michael

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer