

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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Job Site**Report No:** NCR-000057**Prime Contractor:** MCM Construction, Inc.**Date:** 14-Mar-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000057**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: E18L CISS pile #4 splice weld.
Procedural	Procedural	Description:	Failure to maintain minimum required preheat

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

At approximately 1800 hours, the QA inspector used a temperature indicating crayon and noticed that the minimum required preheat temperature of 225°F was not being maintained on E18L Pile 4 splice weld. The QA inspector noted that contractor's personnel were removing fit-up aids (gap blocks) and preparing to finish welding the root of the pile splice weld. The QA inspector notified the Quality Control (QC) inspector Joe Knoblauch that the minimum required preheat did not appear to be maintained. The QA inspector noted that the actual preheat temperature appeared to be above 175°F but less than 200°F.

Applicable reference:

Contract Special Provisions, Section 10-1.50, field welding note J, AWS D1.1 2006, Table 3.2, Category C.

Who discovered the problem: QA inspector Scott Croff

Name of individual from Contractor notified: QC inspector Joe Knoblauch

Time and method of notification: 1800 hours, 3-14-2008, verbal notification

Name of Caltrans Engineer notified: Caltrans Assistant Structures Representative Mark Baker

Time and method of notification:

QC Inspector's Name: Joe Knoblauch

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

The QA inspector was informed that during the removal of the fit-up aids, the electric resistance heaters had been inadvertently disconnected. The preheat temperature was then restored to 225°F. Upon restoration of the minimum required preheat temperature, the QC inspector Joe Knoblauch conducted visual inspection and magnetic particle testing (MT) of the CJP pile splice weld on E18L Pile 4. The QA inspector witnessed the MT of the welds. The QC inspector notified the QA inspector that the weld was acceptable at that time and welding would continue.

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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concerning repairs or remedial efforts please contact Mohammad Fatemi, who represents the Office of Structural Materials for your project.

Inspected By: Croff,Scott

QA Inspector

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:** Job Site**Report No:** NCS-000060**Prime Contractor:** MCM Construction, Inc.**Date:** 23-Apr-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000057**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 14-Mar-2008**Description of Non-Conformance:**

At approximately 1800 hours, the QA inspector used a temperature indicating crayon and noticed that the minimum required preheat temperature of 225°F was not being maintained on E18L Pile 4 splice weld. The QA inspector noted that contractor's personnel were removing fit-up aids (gap blocks) and preparing to finish welding the root of the pile splice weld. The QA inspector notified the Quality Control (QC) inspector Joe Knoblauch that the minimum required preheat did not appear to be maintained. The QA inspector noted that the actual preheat temperature appeared to be above 175°F but less than 200°F.

Contractor's proposal to correct the problem:

The QA inspector was informed that during the removal of the fit-up aids, the electric resistance heaters had been inadvertently disconnected. The preheat temperature was then restored to 225°F. Upon restoration of the minimum required preheat temperature, the QC inspector Joe Knoblauch conducted visual inspection and magnetic particle testing (MT) of the CJP pile splice weld on E18L Pile 4. The QA inspector witnessed the MT of the welds. The QC inspector notified the QA inspector that the weld was acceptable at that time and welding would continue.

Corrective action taken:

The contractor reconnected the electric resistance heaters and restored the minimum preheat temperature. After the heat was restored magnetic particle testing was performed prior to the commencement of the welding. The contractor responded to the NCR in MCM submittal 520 rev.00.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?** Yes No**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, (916) 813-3677, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Inspected By: Levell,Bill

Quality Assurance Inspector

Reviewed By: Fatemi,Mohammad

QA Reviewer