

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-000075**Prime Contractor:** MCM Construction, Inc.**Date:** 26-Apr-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000075**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: E-17L-3 weld #5 shear ring CJP
Procedural	Procedural	Description:	Failure to maintain continuous preheat

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

The QA Inspector observed weld #5 for the shear ring to pile designated E17L-3 failed to maintain the minimum required preheat of 225 degrees F. During the observation of the non-conformance production welding was not being performed on the filler weld passes. The loss of preheat occurred at the bottom 660mm of the weld joint. The QA Inspector verified the preheat temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 150°F, but less than 200°F.

Applicable reference:

Caltrans Special Provisions note J

AWS D1.1 2006 table 3.2

Who discovered the problem: Caltrans QA Inspector Rick Bettencourt**Name of individual from Contractor notified:** MCM Welding Superintendent Chris Smith**Time and method of notification:** 1000 via phone conversation**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 1000 in person**QC Inspector's Name:** Dave Aultman**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

perform MT of area where heat loss occurred after the minimum required preheat is re-established.

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.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Inspected By: Bettencourt,Rick

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-000079**Prime Contractor:** MCM Construction, Inc.**Date:** 12-Jun-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000075**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: 26-Apr-2008**Description of Non-Conformance:**

The QA Inspector observed weld #5 for the shear ring to pile designated E17L-3 failed to maintain the minimum required preheat of 225 degrees F. During the observation of the non-conformance production welding was not being performed on the filler weld passes. The loss of preheat occurred at the bottom 660mm of the weld joint. The QA Inspector verified the preheat temperature utilizing the required temperature indicating markers and noted the temperature within the weld zone was greater than 150°F, but less than 200°F.

Contractor's proposal to correct the problem:

Perform MT of area where heat loss occurred after the minimum required preheat is re-established.

Corrective action taken:

Magnetic particle testing was performed after the minimum required preheat of 225 degree F was restored and prior to the commencement of welding. (Reference MCM-SUB-000563-R0)

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:**

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Inspected By: Levell, Bill

Quality Assurance Inspector

Reviewed By: Fatemi, Mohammad

QA Reviewer