

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-000084**Prime Contractor:** MCM Construction, Inc.**Date:** 01-May-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000084**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 1.8M CISS Pile at E21L
Procedural	Procedural	Description: Welding outside of approved WPS parameters	

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

The QA Inspector observed welder Danny Arnett preparing to weld a temporary attachment onto the lower pile casing at E21L pile #9. The QA Inspector noted that no welding parameter verification was done prior to striking an arc on the pile casing. The welding machine was apparently set at a substantially higher current than required by approved WPS MCM-SMAW-003G and the electrode created a 1/4" deep, 1/2" diameter crater in the base metal of the pile casing. The QC Inspector Joe Knoblauch was present and acknowledged that the base metal repair will require the Engineer's approval.

Applicable reference:

Contract Special Provisions, section 8-3.01 Welding; General; "The QC Inspector shall inspect and approve each ... fit up, assembly practice, welding technique ... and the performance of each welder ... to make certain that the applicable requirements of this code and the approved WPS are met."

AWS D1.1 2006, section 5.18.1 "temporary welds shall be subject to the same WPS requirements as the final welds."

Approved WPS MCM-SMAW-003G

Who discovered the problem: Caltrans QA Inspector Scott Croff

Name of individual from Contractor notified: QC Inspector Joe Knoblauch

Time and method of notification: 2200 hours, verbal, 5-1-2008

Name of Caltrans Engineer notified: Assistant Structures Representative Mark Baker

Time and method of notification: 1930 hours, telephone, 5-2-2008

QC Inspector's Name: Joe Knoblauch

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

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-000081**Prime Contractor:** MCM Construction, Inc.**Date:** 12-Jun-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000084**Type of problem:**

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

Date the Non-Conformance Report was written: 01-May-2008**Description of Non-Conformance:**

The QA Inspector observed welder Danny Arnett preparing to weld a temporary attachment onto the lower pile casing at E21L pile #9. The QA Inspector noted that no welding parameter verification was done prior to striking an arc on the pile casing. The welding machine was apparently set at a substantially higher current than required by approved WPS MCM-SMAW-003G and the electrode created a 1/4" deep, 1/2" diameter crater in the base metal of the pile casing. The QC Inspector Joe Knoblauch was present and acknowledged that the base metal repair will require the Engineer's approval.

Contractor's proposal to correct the problem:

Repair the damaged base metal as a critical weld repair.

Corrective action taken:

The base metal damage was repaired as a critical weld repair (CWR #14). In addition the MCM welder was terminated. (Reference MCM-SUB-00562-R01)

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.

Inspected By: Levell, Bill

Quality Assurance Inspector

Reviewed By: Fatemi, Mohammad

QA Reviewer