

**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-000086**Prime Contractor:** MCM Construction, Inc.**Date:** 08-May-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000086**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> Shear rings at E-17L |
| <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 weld #6 for the shear ring to pile designated E17L-7 and weld #3 for the shear ring to pile designated E17L-1 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 prior to MCM welding personnel arriving on the job site in the morning. The QA Inspector was informed by the QC Inspector Dave Aultman both welds failed to maintain preheat the full length of the weld.

**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 Foreman Marco Torres**Time and method of notification:** 0900 in person**Name of Caltrans Engineer notified:** Caltrans Assistant Structures Representative Mark Baker**Time and method of notification:** 1130 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.

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# 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-000090**Prime Contractor:** MCM Construction, Inc.**Date:** 26-Jun-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000086**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:** 08-May-2008**Description of Non-Conformance:**

The QA Inspector observed weld #6 for the shear ring to pile designated E17L-7 and weld #3 for the shear ring to pile designated E17L-1 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 prior to MCM welding personnel arriving on the job site in the morning. The QA Inspector was informed by the QC Inspector Dave Aultman both welds failed to maintain preheat the full length of the weld.

**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:**

MT testing was performed after the weld was brought up to the required minimum preheat temperature and welding was resumed (Reference MCM-SUB-582R00).

**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