

**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-000104**Prime Contractor:** MCM Construction, Inc.**Date:** 23-Jul-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000104**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> 1.8 meter CISS pile
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Failure to maintain continuous preheat	

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

The QA Inspector noted the complete joint penetration pile splice of pile E-18R-3 did not maintain the minimum required preheat of 225 degrees F continuously. The QA Inspector determined the preheat temperature had dropped to 150 degrees F between location marks 90" to 160" on the bottom section in the weld area (less than 3" from where weld metal was being deposited).

**Applicable reference:**

Caltrans Special Provisions field welding note J

**Who discovered the problem:** Caltrans QA Inspector Rick Bettencourt**Name of individual from Contractor notified:** Welding Superintendent Chris Smith**Time and method of notification:** 0700 via phone notification**Name of Caltrans Engineer notified:** Caltrans Structure Materials Representative Mohammad Fatemi**Time and method of notification:** 1100 in person**QC Inspector's Name:** Kevin Scrivner**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Bring the base metal back up to the minimum required temperature and perform magnetic particle testing prior to the commencement of welding.

**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.

**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-000102**Prime Contractor:** MCM Construction, Inc.**Date:** 31-Jul-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000104**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:** 23-Jul-2008**Description of Non-Conformance:**

The QA Inspector noted the complete joint penetration pile splice of pile E-18R-3 did not maintain the minimum required preheat of 225 degrees F continuously. The QA Inspector determined the preheat temperature had dropped to 150 degrees F between location marks 90" to 160" on the bottom section in the weld area (less than 3" from where weld metal was being deposited).

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

Bring the base metal back up to the minimum required temperature and perform magnetic particle testing prior to the commencement of welding.

**Corrective action taken:**

The preheat blanket was replaced. The preheat was restored and the weld area was inspected by magnetic particle testing prior to welding. Reference MCM SUB-691 Rev.0.

**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