

**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 #: 01.25B


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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**


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**Location:** OTD New Bay Bridge**Report No:** NCR-000110**Prime Contractor:** MCM Construction, Inc.**Date:** 11-Sep-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000110**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> Loss of Heat |                                       |

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

The QA inspector noted the CJP pile splice weld of pile E20R-Pile #2 did not maintain the minimum required preheat of 225F degrees continuously. QA observed that the bottom heating blanket of the splice weld had lost heat after lunch (lunch is at 2130 hrs). QA noted the temperature was approximately 195F degrees. The welder was not welding at the time. The blanket was replaced and the temperature was brought up to 225F degrees. The QA observed QC Joe Knoblauch performing MT testing on the total area (360 degrees) of the splice weld. No rejectable indications were noted by QC. After this, the welder was permitted to perform welding operations. The temperature of the splice weld was at or above 225F at the end of the shift. No other issues with heating blankets were observed.

**Applicable reference:**

AWS D1.1, table 3.2 Category C &amp; Special Provisions Section J of Steel Pipe Piling

**Who discovered the problem:** Caltrans QA Kevin Carpenter**Name of individual from Contractor notified:** Joe Knoblauch**Time and method of notification:** Approximately 2200 Hours**Name of Caltrans Engineer notified:****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:**

After heat was restored to 225F degrees, the QC performed a MT test on the splice weld.

**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 , 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:** Carpenter, Kevin

**Reviewed By:** Estabrook, James

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Contract #: 04-0120L4Cty: SF/ALA Rte: 80 PM: 1.6/2.7File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** OTD New Bay Bridge**Report No:** NCS-000106**Prime Contractor:** MCM Construction, Inc.**Date:** 22-Sep-2008**Submitting Contractor:** MCM Construction, Inc.**NCR #:** NCR-000110**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>Description:</b> |                           |

**Date the Non-Conformance Report was written:** 11-Sep-2008**Description of Non-Conformance:**

The QA inspector noted the CJP pile splice weld of pile E20R-Pile #2 did not maintain the minimum required preheat of 225F degrees continuously. QA observed that the bottom heating blanket of the splice weld had lost heat after lunch (lunch is at 2130 hrs). QA noted the temperature was approximately 195F degrees. The welder was not welding at the time. The blanket was replaced and the temperature was brought up to 225F degrees. The QA observed QC Joe Knoblauch performing MT testing on the total area (360 degrees) of the splice weld. No rejectable indications were noted by QC. After this, the welder was permitted to perform welding operations. The temperature of the splice weld was at or above 225F at the end of the shift. No other issues with heating blankets were observed.

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

After heat was restored to 225F degrees, the QC performed a MT test on the splice weld.

**Corrective action taken:**

See MCM-SUB-000747

**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:** Estabrook, James

Quality Assurance Inspector

**Reviewed By:** Fatemi, Mohammad

QA Reviewer