



**Quality Control - Southern Division
Non-Conformance Report**

NCR No. : XKT-2	
Page : 1	
Date : June 18, 2003	
Plant Location : XKT	

Contract No.: E988	04-012024	Drawing Reference Number :
Customer: KFM	Caltrans	Item Number : Top pile section E11E-6BB
Item Description: Preheat for temporary weld		
Job Description: San Francisco/Oakland Bay Bridge		

Description & Location:

Performing FCAW welding process of temporary alignment device while aligning groove weld connection for E4-128/F4-54 of pile section E11E-6BB.

Cause of Non-Conformance:

1. Welder failed to use the required preheat as per established XKT welding procedure XKTD15-00, dated March 14, 2000.
2. Failure to provide Caltrans Inspection the proper welding procedure required per Caltrans Special Provisions, sections 8-3.01 and 10-1.24 and CalTrans Standard Specifications sections 49-5.01-6.

Proposed Recommendation :

Date: 6/18/2003

XKT Quality Control monitor and verify welders are following requirements of preheat per welding procedure. XKT Quality Control is to verify and monitor that welders have in their possession the correct temperature temperature sticks for welding procedures being used.

XKT Quality Control is to verify welders are using the temperature sticks.

XKT to remove weld in question by gouging, removing weld and heat effected zone, fill gouged area using approved welding procedure and perform Magnetic Particle Inspection.

XKT Quality Control to verify welders have correct welding procedure at their work station.

XKT re-instructs welders on preheat requirements.

Magnetic Particle Inspection is use to verify soundness of areas in question.

XKT Quality Control verifies welders have correct welding procedure during course of welding.

Results of Corrective Action:

XKT removed weld in question by gouging, removing weld and heat effected zone, filled gouged area using approved welding procedure and performed Magnetic Particle Inspection of corrected area.

Remarks:

Rusty Williams, Ameron Quality Control Supervisor | Date June 18, 2003

NESCQ FABRICATORS

INSPECTION REPORT

DIV. OF **XRT ENGINEERING**

PHYSICAL: BLDG. 390, RAILROAD AVE., MARE ISLAND, VALLEJO, CA 94592 MAILING: P.O. BOX 152, VALLEJO, CA 94590 PHONE: (707) 562-2500

NO. _____
JOB NO. 7641

VENDOR: _____

CUSTOMER: Ameron

DRAWING NO.: E988-11B REVISION 1 IPC NO.: E11E-68B IP.O. NO.: -

DISCREPANCY: (BE SPECIFIC - MAKE SKETCH IF NECESSARY)

On pile E11E-68B weld f4-54/f4-128 fitter was tacking on alignment bars. C.T. Q.A. Bill West says fitter did not preheat, fitter said he did preheat. Ambient steel temperature was $\approx 65^{\circ}\text{F}$. A WPS was not posted in immediate area. The WPS was posted at 2 other fitting stations. These are temporary welds and would be removed prior to girth seam welding.

QUALITY CONTROL

SIGNATURE: [Signature] DATE: 6-19-03

CORRECTIVE INSTRUCTIONS:

1. Post WPS at fitting station. - Posted 6-19-03
2. Re instruct fitters on use of preheat WPS. Complete 6-19-03
3. 5 Kim HAZ, reweld and MAT. MAT report will be in final pile package.

PLANNING APPROVAL

SIGNATURE: [Signature] DATE: 6-23-03

DISCREPANCY CORRECTED

SIGNATURE: _____ DATE: _____

SHIP SUPERVISOR

SIGNATURE: _____ DATE: _____

ENGINEERING APPROVAL

SIGNATURE: [Signature] DATE: _____

QUALITY CONTROL APPROVAL

SIGNATURE: [Signature] DATE: _____

AUTHORIZED INSPECTOR

SIGNATURE: _____ DATE: _____

NESSCO FABRICATORS

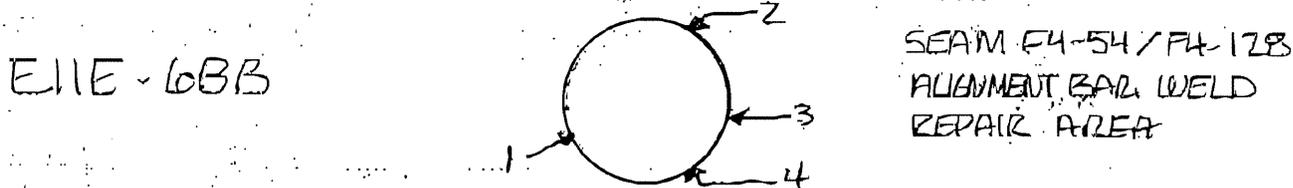
DIV. OF **XKT** ENGINEERING INC.



REPORT OF MAGNETIC PARTICLE EXAMINATION OF WELDS

Project: 7041 AMERON SFOBB
 Quality Requirements — Section No. D1.1. Par 6.10
 Reported To: _____

WELD LOCATION AND IDENTIFICATION SKETCH



Quantity: 4 Total Accepted: 4 Total Rejected: 0

Date	Weld Identification	Area Examined		Interpretation		Repairs		Remarks
		Entire	Specific	Accept	Reject	Accept	Reject	
6-23-03			✓		✓			REJECT
6-23-03	1		✓	✓				FINAL SEE ABOVE
6-23-03	2		✓	✓				SEE ABOVE
6-23-03	3		✓	✓				SEE ABOVE
6-23-03	4		✓	✓				SEE ABOVE

PRE-EXAMINATION

Surface Preparation: WIPE BRUSH AS NECESSARY

EQUIPMENT

Instrument Make: ECONDSPECT 100P Model: Y400 S. No.: 994255

METHOD OF INSPECTION

Dry Wet Visible Fluorescent

How Media Applied: POWDER ROLL

Residual Continuous True-Continuous

AC DC Half-Wave

Prods Yoke Cable Wrap Other _____

Direction for Field: Circular Longitudinal

Strength of Field: AC YOKE LIFTS 10LBS
 (Amper turns, field density, magnetizing force, number, and duration of force application.)

POST EXAMINATION

Demagnetizing Technique (If required): N/A

Cleaning (If required): N/A Marking Method: CHALK / PAINT STICK

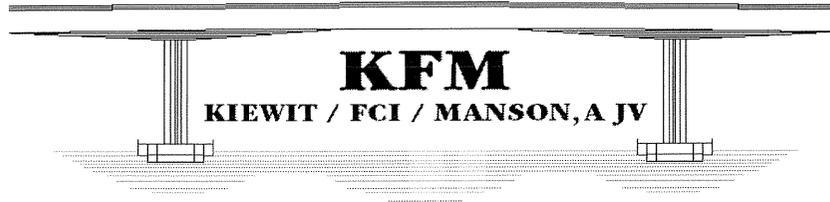
We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in accordance with the requirements of the American Welding Society ANSI/AWS D1.1, (2000) Structural Welding Code-Steel, year

Inspector: [Signature] Manufacturer or contractor: NESSCO

Level: IT Authorized By: [Signature]

Test date: 6-23-03 Date: 6-20-03

BLDG. 350 RAILROAD AVENUE • MARE ISLAND NAVAL SHIPYARD
 P.O. BOX 152 • VALLEJO, CA 94590
 (707) 557-2500 • FAX (707) 557-2565



P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

LETTER OF SUBMITTAL
KFM Skyway Project # 04-012024

Run Date 23-Jun-03
Time 11:11AM

Dated: 23-Jun-2003

SUBMITTAL No: KFM-SUB-001085

Rev: 00

To: Doug Coe
Caltrans-Skyway Project
345 Burma Road

Co/Job # 364-3726

Contract # 04-012024

Sub/Supplier: AME

Oakland CA 94607
Phone: Fax:

Sub/Supplier No:

Subject: Ameron NCR-XKT-2

Special Provis. (SP) REF: 08-3.01

Standard Spec. (SS) REF:

RESUBMITTALISUPPLEMENTALREF:

We are sending the following attached items: Attached

Via Fax

- Drawing
- Plans
- Samples
- Certificates of compliance
- Payroll
- Specs
- Change Order
- Schedule

- Prog. Pmt
- Calculations
- Copy of Letter
- Invoice

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	18-Jun-03	1	Ameron NCR No. XKT-2		0	Pending	1
02	20-Jun-03	1	XKT Inspection Report		0	Pending	1
03	23-Jun-03	1	MT Report		0	Pending	1

These are transmitted as checked below:

- For Approval
- For Review/comment
- Return For Correction
- For Your Use
- As Requested
- For Information

Remarks:

CC:

Please review / approve by : 30-Jun-2003

Submitted By:

Rich Bienek

(KFM Staff Member - Originator of Transmittal)

Checked & Sent By:

S. Bourke
Contract Admin/DCS Staff

RECEIVED
008156 JUN 24 03

9.07.3