

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 #: 04-0120R4Cty: SF Rte: 80 PM: 12.6,13.2File #: 81.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

Location: Coolidge, Arizona
Prime Contractor: C.C. Myers
Submitting Contractor: Stinger Welding

Report No: NCR-000010
Date: 29-Sep-2008
NCR #: NCR-000010

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Diagonal box A124A
Procedural	Procedural	Descriptor:	Welding out of position.

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

The QA Inspector observed Stinger Welding Inc. (SWI) welding personnel Rodrigo Acevez and Tomas Moreno perform welding between the following plates: pf124A, pa124A, pb124A on the diagonal box number A124A. The welding was being performed using the Welding Procedure Specification (WPS) number WPS-1055-SAW-5-F31 which was assigned for welding in the flat position and the welding operation was being performed in the horizontal position.

In addition to the above welds: the diagonal boxes A120A, A121A, A123A, A124A, A125A, A126A, A220A, A221A, A223A, A224A and A225A had been welded in the horizontal position using the flat position WPS.

Applicable reference:

Per special provisions. 8-3 Welding, The QC Inspector shall make certain the specifications and requirements of the Welding Procedure Specification (WPS) are met.

And AWS D1.5, 2002 requirements.

Who discovered the problem: Quality Assurance (QA) Inspector Ricardo Medina

Name of individual from Contractor notified: Quality Control Manager (QCM) Garry Gardner

Time and method of notification: 1830 hours by verbal communication

Name of Caltrans Engineer notified: Karen Wang

Time and method of notification: Tuesday Sept 30 09:30 am

QC Inspector's Name: Mark Bauers

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

None as of this time

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 Jinesh Mehta, 1-951-840-0541, who represents the Office

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

of Structural Materials for your project.

Inspected By: Medina,Ricardo

QA inspector

Reviewed By: Hager,Craig

QA Inspector

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 #: 04-0120R4Cty: SF Rte: 80 PM: 12.6,13.2File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**

Location: Coolidge, Arizona
Prime Contractor: C.C. Myers
Submitting Contractor: Stinger Welding

Report No: NCS-000008
Date: 20-Mar-2009
NCR #: NCR-000010

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: 29-Sep-2008**Description of Non-Conformance:**

The QA Inspector observed Stinger Welding personnel performing welding between the following plates: pf124A, pa124A, pb124A on the diagonal box number A124A. The welding was being performed using the Welding Procedure Specification (WPS) number WPS-1055-SAW-5-F31 which was assigned for welding in the flat position and the welding operation was being performed in the horizontal position. Additionally, the diagonal boxes A120A, A121A, A123A, A124A, A125A, A126A, A220A, A221A, A223A, A224A and A225A had been welded in the horizontal position using the flat position WPS.

Contractor's proposal to correct the problem:

Qualify the SAW WPS for 2F position welding.

Corrective action taken:

2F position fillet weld soundness tests were conducted. Third party QC witnessed the tests and coupon testing and accepted the test results. The WPS was revised and approved by the Engineer in the WQCP. Reference submittal 215-SUB.00292-68.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** William Casey **Date:** 12-Jan-2009**Is Engineer's approval attached?** Yes No Reference submittal 215-SUB.00285-01 for WQCP approval.**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 Jinesh Mehta, (707) 552-7715 (284), who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
----------------------	--------------	-----------------------------

Reviewed By:	Levell, Bill	QA Reviewer
---------------------	--------------	-------------