

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-000013
Date: 20-Jan-2009
NCR #: -0011

Type of problem:

| | | | |
|---------------------|-------------------|---|--|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: ETI - Strongback Gusset Plates |
| Procedural | Procedural | Descriptor: No QC during welding, deviating from shop drawings | |

Reference Description: Welding with out Quality Control Inspectors present and not fabricating per approved shop drawings.

Description of Non-Conformance:

Stinger Welding personnel fit up, tack and fillet welded seven strongback gusset plate assemblies without Quality Control. Some of these gusset plates are Fracture Critical. The assemblies include: A260, A261, B261, A262, B262, A263 and B263. The QC Inspectors present at Stinger Welding were not aware of the fabrication of these parts. There are no records of the inspection and approval of these assemblies / welds. These gusset plates and gusset plates A258, B258, A259, B259 and B260 do not conform to the approved shop drawings. The hole spacing, edge distances and stiffener spacing deviate from drawings by up to 24mm.

Applicable reference:

AWS D1.5 Section 6.5, Inspection of Work and Records, AWS D1.5 Section 12.16, Stinger Welding's approved WQCP Section K - 8.2.2.3, Contract Special Provisions sec. 8.3.

Who discovered the problem: Scott Croff and Andrew Webster, QA Inspectors

Name of individual from Contractor notified: Gary Gardner, Stinger's QC Manager

Time and method of notification: verbal notification, 1300 hours, Jan. 20th, 2009.

Name of Caltrans Engineer notified: Karen Wang

Time and method of notification: Wednesday January 21st, 1400 hours

QC Inspector's Name: Rolando Caldera, Mark Bauers, Ray Hightower

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Unknown.

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 of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Inspected By: Croff,Scott

QA Inspector

Reviewed By: Levell,Bill

QA Inspector

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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-000011
Date: 07-May-2009
NCR #: -0011

Type of problem:

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|---------------------|-------------------|---------------------|---------------------------|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: |
| Procedural | Procedural | Description: | |

Date the Non-Conformance Report was written: 20-Jan-2009**Description of Non-Conformance:**

Stinger Welding personnel fit up, tack and fillet welded seven strongback gusset plate assemblies without Quality Control. Some of these gusset plates are Fracture Critical. The assemblies include: A260, A261, B261, A262, B262, A263 and B263. The QC Inspectors present at Stinger Welding were not aware of the fabrication of these parts. There are no records of the inspection and approval of these assemblies / welds. These gusset plates and gusset plates A258, B258, A259, B259 and B260 do not conform to the approved shop drawings. The hole spacing, edge distances and stiffener spacing deviate from drawings by up to 24mm.

Contractor's proposal to correct the problem:

The contractor proposes 100% MT in addition to VT on completed welds and to scrap B259.

Corrective action taken:

The QC Inspectors conducted 100% MT on brackets A260, A261, A262, B262, A263 & B263. Bracket B259 was scrapped and the remaining brackets were approved in RFI for use as-built. QA verification was also conducted on the acceptable brackets.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** William Casey **Date:** 02-Feb-2009**Is Engineer's approval attached?** Yes No Reference 215-RFI-353.00058-01 for additional information.**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.

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| Inspected By: Croff, Scott | Quality Assurance Inspector |
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| Reviewed By: Levell, Bill | QA Reviewer |
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