

**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 #: 11.25B


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


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**Location:** Vancouver, WA**Report No:** NCR-000014**Prime Contractor:** C.C. Myers**Date:** 11-Dec-2008**Submitting Contractor:** Thompson Metal Fabrication (TMF). Vancouver Wa.**NCR #:** NCR-000014**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> F31A, F31B, F12A pipe column assemblies
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Reference Description:** The QA Inspector randomly observed several non conforming issues directly related to the in process fabrication of the F31A, F31B and F12A pipe column assemblies.

**Description of Non-Conformance:**

The QA Inspector randomly observed several non conforming issues directly related to the in process fabrication of the F31A, F31B and F12A pipe column assemblies.

- 1.) The CARR Construction Inc. representatives were observed using excessive force during the fit up process of all three of the above identified pipe column assemblies. The QA Inspector noted CARR representatives were observed utilizing sledge hammers to force the box beam members to pre determined mach-mark areas. The QA Inspector observed 3-4mm base material dents caused by the hammering of the steel members.
- 2.) The CARR Construction representatives were observed by the Caltrans QA Inspectors utilizing mechanical force. The QA Inspector noted hydraulic rams were used to bend and distort the Fracture Critical Member (FCM) gusset plates associated with F31A, F31B and F12A pipe column assemblies. Significant deformation was observed on the near side gusset plate identified as pG64b which will be replaced due to excessive deformation.
- 3.) The QA Inspectors have repeatedly observed and noted arc strikes outside the weld joint at numerous locations within the F31A, F31B and F12A pipe column assemblies. Arc strikes have been brought to the contractor's attention on numerous occasions to where care should be taken to prevent arc strikes outside the area of permanent welds.

Contractor's proposal to correct the problem: It was determined by the CARR Construction to further eliminate any further potential quality issues, TMF has subcontracted Quality Control Personnel to 100% monitor all operations during assembly, tack welding and fit up at CARR Construction assembly yard.

**Applicable reference:**

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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AWS D1.5 2002 sections 3.10, 12.12, Standard Specifications 55-3.16

**Who discovered the problem:** Caltrans QA Inspector Rick Bettencourt

**Name of individual from Contractor notified:** TMF Project Manager Steve Williams

**Time and method of notification:** 0800 Verbal notification

**Name of Caltrans Engineer notified:** Karen Wang

**Time and method of notification:** 0800 Verbal notification

**QC Inspector's Name:** Don Bloom

**Was QC Inspector aware of the problem:** Yes No

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

Unknown at 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 of Structural Materials for your project.

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**Inspected By:** Bettencourt,Richard

QA Inspector

**Reviewed By:** Adame,Joe

Quality Assurance Inspector

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**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**


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**Location:** Vancouver, WA**Report No:** NCS-000003**Prime Contractor:** C.C. Myers**Date:** 18-Feb-2009**Submitting Contractor:** Thompson Metal Fabrication (TMF). Vancouver Wa.**NCR #:** NCR-000014**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-Dec-2008**Description of Non-Conformance:**

The QA Inspector randomly observed several non conforming issues directly related to the in process fabrication of the F31A, F31B and F12A pipe column assemblies.

1.) The CARR Construction Inc. representatives were observed using excessive force during the fit up process of all three of the above identified pipe column assemblies. The QA Inspector noted CARR representatives were observed utilizing sledge hammers to force the box beam members to pre determined mach-mark areas. The QA Inspector observed 3-4mm base material dents caused by the hammering of the steel members.

2.) The CARR Construction representatives were observed by the Caltrans QA Inspectors utilizing mechanical force. The QA Inspector noted hydraulic rams were used to bend and distort the Fracture Critical Member (FCM) gussets plates associated with F31A, F31B and F12A pipe column assemblies. Significant deformation was observed on the near side gusset plate identified as pG64b which will be replaced due to excessive deformation.

3.) The QA Inspectors have repeatedly observed and noted arc strikes outside the weld joint at numerous locations within the F31A, F31B and F12A pipe column assemblies. Arc strikes have been brought to the contractor's attention on numerous occasions to where care should be taken to prevent arc strikes outside the area of permanent welds.

Contractor's proposal to correct the problem: It was determined by the CARR Construction to further eliminate any further potential quality issues, TMF has subcontracted Quality Control Personnel to 100% monitor all operations during assembly, tack welding and fit up at CARR Construction assembly yard.

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

It was determined by the CARR Construction to further eliminate any further potential quality issues, TMF has subcontracted Quality Control Personnel to 100% monitor all operations during assembly, tack welding and fit

