

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 #: 04-0120R4
 Cty: SF Rte: 80 PM: 12.6,13.2
 File #: 81.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000019
Date: 20-Mar-2009
NCR #: -0013

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: East Tie In
Procedural	Procedural	Descriptor: FCM Gusset Plate at South Truss Vertical A112A	

Reference Description: Damaged/gouged gusset plate during heat straightening.

Description of Non-Conformance:

Welding distortion was noted on welded FCM gusset plate to the South Truss Vertical A112A. Stinger Welding attempted heat straightening to correct the distortion. During heat straightening of this gusset plate pbk112 from the underside, the plate was overheated gouging/damaging the plate. Stinger QC Mark Bauers was monitoring the application of localized heat. Four applications of localized heat were conducted on the same location on the gusset plate. On the fourth pass, there was burning/gouging and discoloration of the plate occurred per QC record. The applied heat exceeded the maximum temperature that is specified in the approved HSR procedure as evidenced by the burning/gouging and discoloration of the plate. It is noted that their approved procedure requires each application of heat to be 13mm from the previously heated area and this apparently did not occur.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Applicable reference:

AWS D1.5 Section 3.7.3 and 12.12. and Stinger Heat Straightening Request 1055 Portal Gussets -1 Rev. 0

Who discovered the problem: Dean Fonseca

Name of individual from Contractor notified: Rolando Caldera

Time and method of notification: 1000 Hrs. Verbal

Name of Caltrans Engineer notified:

Time and method of notification:

QC Inspector's Name: Mark Bauers

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.

Inspected By: Lizardo, Joselito

Inspector

Reviewed By: Mehta, Jinesh

SMR

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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-000009
Date: 08-Apr-2009
NCR #: -0013

Type of problem:

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-Mar-2009**Description of Non-Conformance:**

Welding distortion was noted on welded FCM gusset plate to the South Truss Vertical A112A. Stinger Welding attempted heat straightening to correct the distortion. During heat straightening of this gusset plate pbk112 from the underside, the plate was overheated gouging/damaging the plate. Stinger QC Mark Bauers was monitoring the application of localized heat. Four applications of localized heat were conducted on the same location on the gusset plate. On the fourth pass, there was burning/gouging and discoloration of the plate occurred per QC record. The applied heat exceeded the maximum temperature that is specified in the approved HSR procedure as evidenced by the burning/gouging and discoloration of the plate. It is noted that their approved procedure requires each application of heat to be 13mm from the previously heated area and this apparently did not occur.

Contractor's proposal to correct the problem:

They requested to use the material as is. Reference submittal 215-SUB.00292-110 for additional information.

Corrective action taken:

Stinger Welding, Inc had made an evaluation by performing hardness test on the affected gusset plate pbk112A and compared it to the non-affected gusset plate pbh112A. The average hardness taken from the affected area was 152.55 HBLD whereas the non-affected area was 159.2 HBLD. Comparing both hardness readings, there were minor differences between the two areas. Although blisters, slight gouging and discoloration of the plate were observed, these appear to be superficial. Stinger Welding, Inc suggested not to do any further repair to the burned gusset plate and they request to use as it is.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Bill Casey **Date:****Is Engineer's approval attached?** Yes No**Comments:**

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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
