

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

**Request for Information (RFI) Report**  
**KFM Skyway Project # 04-012024**

*Run Date* 27-May-03  
*Time* #Name?

Dated: 23-May-2003

To: Doug Coe  
Caltrans-Skyway Project  
345 Burma Road  
Oakland CA 94607  
Phone: (510) 622-5100 Fax: (510) 622-5165

RFI No: KFM-RFI-000688 Rev: 00  
Co/Job # 364-3726  
Contract # 04-012024  
Sub/Supplier: KOS  
Sub/Supplier No: 00069R1

Date Requested By: 30-May-2003

Group: FND

Subject: KOS RFI #69R1 - Answer to NCR 47 & 48

Drawing No. Ref:

Specification Ref: 08-3.01

Other:

Resubmittal/Supplement Ref:

**Description (Attachments As Needed):**

Please See Attached KOS RFI #69 and Respond.  
Also, KFM requests that the welds identified in KOS RFI #69 for welds in Quality Issues Log Item #130 and #131 be accepted as welded and tested.

Potential Time Impact? No

Potential Cost impact? No

Schedule Activity ID#:

General Explanation of Potential Impact (If Required):

**Response (Attachments As Required):**

Answered By:

Date Answered:

**CC:**

Prepared By: George Atkinson

Originator

Reviewed By:

  
F Scott Hanson

Reviewed By:

  
John Hassard

Submitted By:

  
Contract Admin/DCS Staff

RECEIVED  
007450 MAY 27 8

# Kiewit Offshore Services

# REQUEST FOR INFORMATION

P.O. Box K  
INGLESIDE, Texas 78362

Phone: 361-775-4300

No. 00069

*Rev A*

**TITLE:** Answer to NCR 47 & 48

**DATE:** 5/9/2003

**PROJECT:** SFOBB Footing Fabrication

**JOB:** 3657

**TO:** Attn: George Atkinson  
Kiewit/FCI/Manson  
220 Burma Road  
Oakland, CA 94649  
Phone: 510-419-0120

**STARTED:**

**COMPLETED:**

**REQUIRED:** 5/10/2003

## REQUEST:

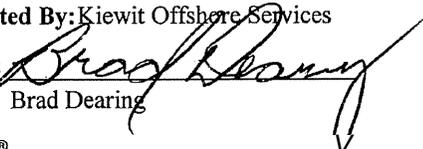
Two weld repairs on Footing 10E were completed with inadequate preheats as identified by Caltrans QA (Quality Issues Log #'s 130 and 131). Each repair has been documented in attached NCR's 3657-47 and 3657-48.

In both cases the repairs were UT tested and MT tested seven days after repairs were made and found to meet acceptance criteria.

KOS proposes these repairs be accepted as performed.

Please advise.

Requested By: Kiewit Offshore Services

Signed:   
Brad Dearing

Date: 5/15/03

Expedition ©

## ANSWER:

Answered By: Kiewit/FCI/Manson

Date: \_\_\_\_\_

Signed: \_\_\_\_\_  
George Atkinson



# NON-CONFORMANCE REPORT

NCR No: 3657-47

Job No.: Caltrans 3657

Date: 5/6/2003

Client: Caltrans

Drawing/Sketch No.: \_\_\_\_\_ Rev.: \_\_\_\_\_

Specification/Code: AWS D1.5 1996 Section 6

Attachment	
Yes	<input checked="" type="checkbox"/>
No	<input type="checkbox"/>

Non-Conformance: Welder stencil TN was observed repairing a weld on SP205 to Pier Socket I near Pile Sleeve B2 on footing E10 East with the pre-heat temperature less than 200 degrees versus the required 275 degrees.

Disposition: The weld pre-heat was brought up to 275 degrees and welding continued on the repair. The repair will be UT and MT tested 100 %. KOS to write an RFI to accept as welded.

### Disposition Approvals

Brad Kearny 5/8/03  
Project Manager/Date  
Robert Cuellar 5/9/2003  
Client Rep./Date  
**CALTRANS**

Ben Bert  
Fabrication Manager/Date  
Greg Beil 5/6/03  
KOS QCM/Date

Tom Melton 5/8/03  
Project Supt./Date

### Verification of Disposition Accomplished

Brad Kearny 5/8/03  
Project Manager/Date  
Client Rep./Date

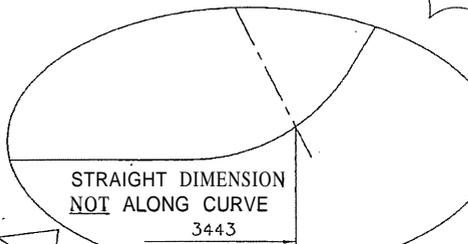
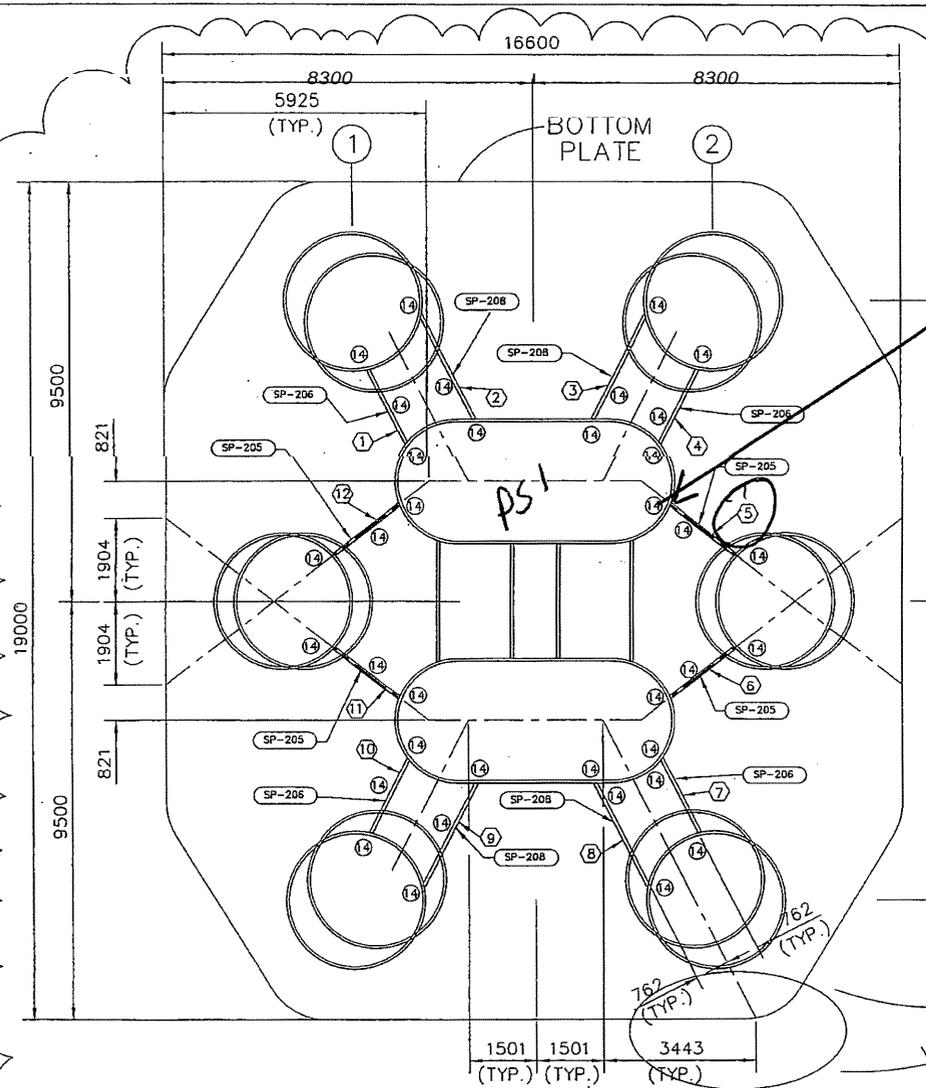
Ben Bert  
Fabrication Manager/Date  
Greg Beil 5/6/03  
KOS QCM/Date

Tom Melton 5/8/03  
Project Supt./Date

Distribution  
Fabrication Mgr.      Project Mgr      General Supt.      QCM      QC File

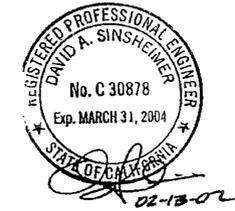
NCR # 47 WELD  
LOCATION

DIST.	COUNTY	ROUTE	KILOMETER	POST	TOTAL PROJECT
04	SF, Alq	80	13.9/14.3	0.0/1.6	
PREPARED FOR THE					BRIDGE NO.
STATE OF CALIFORNIA					34-0006L/1
DEPARTMENT OF TRANSPORTATION					
KIEWIT/FCI/MANSON a JV					
CONTRACT NO.					04-012024
NOTE: MATERIAL GRADES					
1. TYPE I = A-709 Gr. 50T1					
2. TYPE II = A709 Gr 50T1 (THROUGH THICKNESS)					
KEY					
○ INDICATES PC#					
□ INDICATES CODE SYM					
⬡ INDICATES WELD#					
○ INDICATES DETAIL#					
⊛ SEE PART SKETCH					



As a representative of Kiewit Engineering Co., I certify that the footing shop fabrication drawings to which my stamp is affixed accurately conforms to the specifications and the dimensional requirements of design drawings sheet 483R1 of 978 through sheet 493R1 of 978 revision date 5/28/02 provided under C-1 Trans Contract No 04-012024 and drawings or instructions for installation provided by Kiewit/FCI/Manson JV

PIER # \_\_\_\_\_



PIER E7 THRU E14  
16 FOOTINGS TOTAL

PIER SOCKET CASING W/ SHEAR PLATES  
(1 REQ'D PER FOOTING)

ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SHOWN

C.A.D. FILENAME  
C:\SHOP DWG SD-LWOC-17

REV.	DATE	REVISION	BY
2	12/3/02	REF'D DIM'S TO BOTTOM PLATE	SLB
1	9/10/02	GENERAL REVISIONS	LRod
0	7/16/02	ISSUED FOR CONSTRUCTION	TG



JOB NO:	3657
ACCT NO:	
DRAWN BY:	ADR
CHK'D BY:	TG/DB
PL THK:	
PL GRADE:	
SCALE:	NTS
DATE:	05/12/02

SAN FRANCISCO OAKLAND BAY BRIDGE EAST SPAN SEISMIC SAFETY PROJECT			
SKYWAY STRUCTURES			
LARGE FOOTING W/O CONCRETE			
PIER SKT CASING W/SHEAR PLTS			
REF. DWG SHY. NO.	TOTAL SHYS.	24	REV. 2
005			
DISREGARD PRINTS BEARING EARLIER REVISION DATES	SHEET	OF	
	17	24	

E10-EAST

NCR-2657-47  
2/8

HCR 3657-47  
3/8

# WALZEL Services

PO Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 4/6/03  
Report No. UT 649  
Page 1 of 2

Customer Kiewit Offshore Services, Ltd.      DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd.      Project Name Caltrans SFOBB  
Job No. 3657      Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT		
Instrument Sonatest #1401503C		<input type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand		
Longitudinal		<input type="checkbox"/> AC	<input type="checkbox"/> DC	Type		
Shear 2.25 MHz		<input type="checkbox"/> Residual	<input type="checkbox"/> Continuous	Batch No.		Florescent Minutes
Size 1.0 Round	Size 5/8"	Equipment		Penetrant		
Type Aero Tech.	Type Tech.	Procedure		Remover		
Couplant Cellulose	Angle 045°-70°	Code		Developer		
Procedure 31.5 - 1996	Code D1.5 - 1996			Procedure		Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
W-5	1828	SP-205 @ 2B + PS-1 (Base Plate)		X	E-10-EAST (SO-Liner-17)
W-5	5460	SP-205 @ 2B + PS-1 (To Pier Socket)		X	
INITIAL UT REPORT @ 4/6/03					

Total mm inspected - **7228**  
Total mm accepted - **3573**  
Total mm rejected - **3654**

Examination Performed By Joe Vicars      Accepted By George Barnhill  
Joe Vicars      George Barnhill

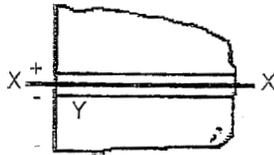
NCR 3657-47  
418

Annex VII/193

REPORT OF ULTRASONIC TESTING OF WELDS

Project Caltrans KOS #3657

Report no. UT



Weld identification SP-205 @ 2B + PS-1

Material thickness 76

Weld joint AWS T

Welding process Flux Core

Quality requirements - section no. Table 6.3

Remarks Page 2 of 2

Line number	Indication number	Transducer angle	From Face	Leg*	Decibels				Discontinuity					Discontinuity evaluation	Remarks
					Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular distance (sound path)	Depth from "A" surface	Distance			
												a	b		
1	1	70	A	1	73	62	7	+4	254	104	35	0	0"	C	SP-205 @ 2B + PS-1
2	2	70	A	1	73	62	7	+4	1422	104	35	0	431	C	(W-S) Base Plate
3															
4															
5	1	45	A	1	68	60	3	+5	50	50	50	-20	50	A	SP-205 @ 2B + PS-1
6	2	45	A	1	68	60	3	+5	50	50	50	-20	914	A	(W-S) Top Flange Section
7	3	45	A	1	68	60	3	+5	50	50	50	-20	1295	A	
8	4	45	A	1	68	60	3	+5	863	50	50	-20	2032	A	
9	5	45	A	1	68	60	3	+5	762	50	50	-20	3042	A	
10	6	45	A	1	68	60	3	+5	203	50	50	-20	4749	A	
11															
12															
13															
14															
15															
16															
17															
18															
19															
20															
21															
22															
23															
24															
25															
26															

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 Section 6, Part F of ANSIIAASHTOIAWS 01.5, (1996) Bridge Welding Code.

Test Date 4/6/03

Manufacturer or Contractor KOS

inspected by Joe Vicars

Authorized by George Barnhi

Date 4/10/03

Notes:

- In order to attain Rating "d"
    - With instruments with gain control, use the formula a-b-c=d.
    - With instruments with attenuation control, use the formula b-a-c=d.
    - A plus or minus sign must accompany the "d" figure unless "d" is equal to zero.
  - Distance from X is used in describing the location of a weld discontinuity in a direction perpendicular to the weld reference line.
  - Distance from Y is used in describing the location of a weld discontinuity in a direction parallel to the weld reference line. The figure is attained by measuring the distance from the "Y" end of the weld to the beginning of said discontinuity.
  - Evaluation of Retested Repaired Weld Areas must be tabulated on a new line on the report form. If the original report form is used, R<sub>n</sub> shall prefix the indication number. If additional forms are used, the R number shall prefix the report number.
- \*Use Leg I, II or III. See glossary of terms (Annex V).



**INSPECTION REPORT**

INSPECTION DETAILS	JOB NO.:	CLIENT:	PIECE / PART / COMPONENT	DRAWING / SPECIFICATION
	3657	Caltrans	SP-205	E-10
INSPECTION RESULTS	<p>Welder welding with temperature less than 200 degrees on Repair on Shear plate SP-205 Pier Socket #1 Pile Shear B-2 location. TN is the welder stencil W#5</p>			
	<p>The preheat temperature was brought up to 275 degrees and welding was continued. The weld was welded out and the weld was visual inspected and 100% UT will be performed. C.F.G-20</p>			
	Satisfactory Inspection Results		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	If not satisfactory, explain in the Comment Section of this report.
COMMENTS	<p> </p> <p> </p> <p> </p>			
	Inspector / Date: 4-9-03	Witness / Date: *		Distribution:
	Ronald Williams	* If Required		

Weld Repair w/o Proper Preheat Noted @ 4-9-03

NCR 3657-47  
6/8

# WALZEL Services

O Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 4/16/03  
Report No. WT711R  
Page 1 of 2

Customer Kiewit Offshore Services, Ltd. DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBB  
Job No. 3657 Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT		
Instrument Sonatest #1401503C		<input type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand		
Longitudinal		<input type="checkbox"/> AC	<input type="checkbox"/> DC	Type		
2.25 mHz	Shear 2.25 mHz	<input type="checkbox"/> Residual	<input type="checkbox"/> Continuous		Batch No.	Florescent Minutes
Size 1.0 Round	Size 5/8"	Equipment		Penetrant		
Type Aero Tech.	Type Tech.	Procedure		Remover		
Couplant Cellulose	Angle 45 70	Code		Developer		
Procedure	Code	Code		Code		

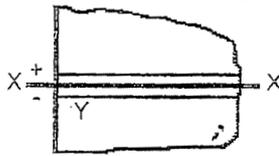
ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
W-2R1		SP-208 @ C-1 (To Base Plate)		X	E-10-EAST (SD-LWOL-17)
J-8R1		SP-208 @ A-2 (To Base Plate)	✓		Clear Rpt # 648
J-8R1		SP-208 @ A-2 (To Pier Socket)		X	
J-5R1		SP-205 @ B-2 (To Base Plate)	✓		Clear Rpt # 649
J-5R1		SP-205 @ B-2 (To Pier Socket)	✓		Clear Rpt # 649
J-9R2		SP-208 @ A-1 (To Base Plate) Pier Socket	✓		Clear Rpt # 670R, 649
<div style="border: 1px solid black; border-radius: 50%; padding: 10px; display: inline-block;">                     WT CLEARING REPAIRS - 4/16/03                      7-days after repairs made                 </div>					
Total mm inspected - Total mm accepted - 1 mm rejected - 150					

Examination Performed By Joe Vicars Accepted By George Barnhill  
Joe Vicars George Barnhill

REPORT OF ULTRASONIC TESTING OF WELDS

Project Caltrans KOS #3657

Report no. UT 711R



Weld identification W-2 R1

Material thickness 76

Weld joint AWS T

Welding process Fine Line

Quality requirements - section no. Table 6.3

Remarks E-10-EAST

Page 2 of 2

Line number	Indication number	Transducer angle	From Face	Leg*	Decibels				Discontinuity				Discontinuity evaluation	Remarks	
					Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular distance (sound path)	Depth from "A" surface	Distance			
												a			b
R1 R1 1	1	45	A	1	66	60	1	+5	50	50	50	0	1574	A	SP-208 @ C-1
2	2	45	A	1	66	60	1	+5	50	50	50	0	2209	A	W-2 R1 (To BS PL)
R2 5	1	45	A	1	66	60	1	+5	50	50	50	0	4724	A	SP-208 @ A2 W-2 R1 (To Pipe Socket)
6															
7															
8															
9															
10															
11															
12															
13															
14															
15															
16															
17															
18															
19															
20															
21															
22															
23															
24															
25															
26															

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 Section 6, Part F of ANSI/AASHTO/AWS D1.5, (1996) Bridge Welding Code.

Test Date 4/16/03  
 Inspected by Joe Vicars

Manufacturer or Contractor KOS  
 Authorized by George Barnhill  
 Sec

Date 4/16/03

- Notes:
- In order to attain Rating "d"
    - (A) With instruments with gain control, use the formula a-b-c=d.
    - (B) With instruments with attenuation control, use the formula b-a-c=d.
    - (C) A plus or minus sign must accompany the "d" figure unless "d" is equal to zero.
  - Distance from X is used in describing the location of a weld discontinuity in a direction perpendicular to the weld reference line.
  - Distance from Y is used in describing the location of a weld discontinuity in a direction parallel to the weld reference line. This figure is attained by measuring the distance from the "Y" and on the weld to the beginning of said discontinuity.
  - Evaluation of Retested Repaired Weld Areas must be tabulated on a new line on the report form. If the original report form is used, R<sub>n</sub> shall Prefix the indication number. If additional forms are used, the R number shall prefix the report number.
- \*Use Leg I, II or III. See Glossary of terms (Annex V).

NCR 3657-47  
818

# WALZEL Services

Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 5-8-03  
Report No. MT/102  
Page 1 of 1

Customer Kiewit Offshore Services, Ltd. DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBB  
Job No. 3657 Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT		
Instrument		<input checked="" type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand		
Longitudinal	Shear	<input checked="" type="checkbox"/> AC	<input type="checkbox"/> DC	Type		
	mHz	<input type="checkbox"/> Residual	<input checked="" type="checkbox"/> Continuous	Florescent Minutes		
Size	Size	Ten Pound Lift Okay.		Penetrant	Batch No.	
Type	Type	Equipment Electrospec X-Yoke		Remover		
Couplant	Angle	Procedure WMT-200		Developer		
Procedure	Code	Code AWS D1.5-1996		Procedure		Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
		E-10-E Sp 205 to P.S. Z/B-2 Sleeve NCR # 3657-47	/		
		Sp 208 to P.S. Z/C-2 Sleeve NCR # 3657-48	/		
<div style="border: 1px solid black; border-radius: 50%; padding: 10px; display: inline-block;">           ADDITIONAL MT CHECK            FOR NCR - 1 MONTH AFTER            REPAIRS MADE.         </div>					
Total mm inspected - Total mm accepted - Total mm rejected -					

Examination Performed By Tommy Hernandez Accepted By George Barnhill



# NON-CONFORMANCE REPORT

NCR No.: 3657-48

Job No.: Caltrans 3657

Date: 5/6/2003

Client: Caltrans

Drawing/Sketch No.: \_\_\_\_\_ Rev.: \_\_\_\_\_

Specification/Code: AWS D1.5 1996 Section 6

Attachment	
Yes	<input checked="" type="checkbox"/>
No	<input type="checkbox"/>

Non-Conformance: Welder stencil DXQ was observed repairing a weld on SP208 to Pier Socket 1 near Pile Sleeve C2. on footina E 10 East with the ore-heat temperature less than 200 degrees versus the required 275 degrees.

Disposition: The weld pre-heat was brought up to 275 degrees and welding continued on the repair. The repair will be UT and MT tested 100 %. KOS to write an RFI to accept as welded.

### Disposition Approvals

<u>Bragg</u> <u>5/8/03</u> Project Manager/Date	<u>Ben</u> <u>5/6/03</u> Fabrication Manager/Date	<u>Jimmy</u> <u>5/8/03</u> Project Supt./Date
<u>Robert</u> <u>5/7/2003</u> Client Rep./Date <u>CALTRANS</u>	<u>James</u> <u>5/6/03</u> KOS QCM/Date	

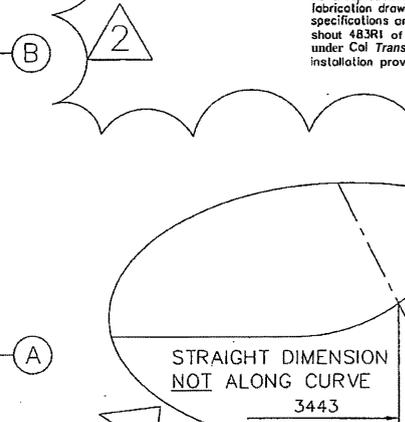
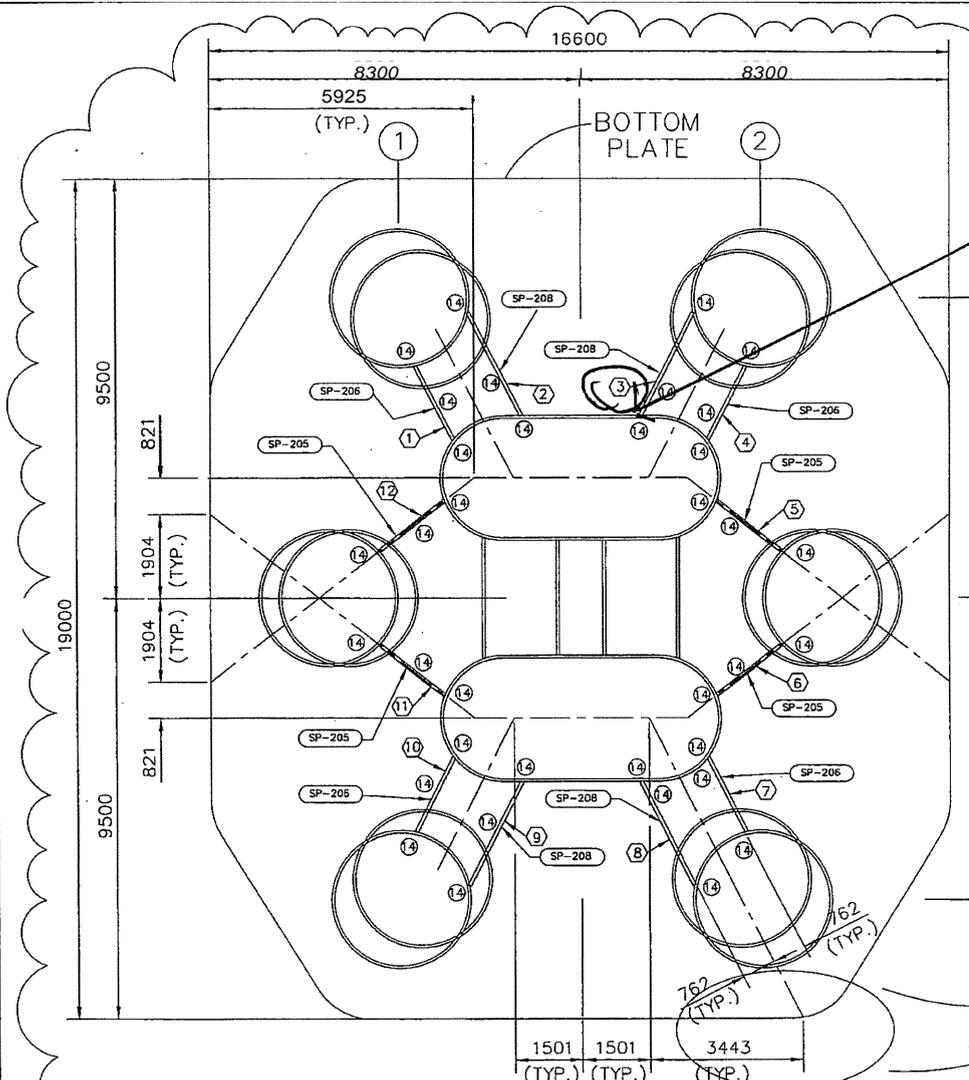
### Verification of Disposition Accomplished

<u>Bragg</u> <u>5/18/03</u> Project Manager/Date	<u>Ben</u> <u>5/6/03</u> Fabrication Manager/Date	<u>Jimmy</u> <u>5/8/03</u> Project Supt./Date
<u>Robert</u> <u>5/18/03</u> Client Rep./Date	<u>James</u> <u>5/6/03</u> KOS QCM/Date	

Distribution  
 Fabrication Mgr.      Project Mgr      General Supt.      QCM      QC File

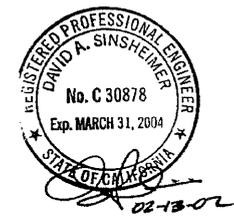
NCR # 48 WELD  
LOCATION

DIST	COUNTY	ROUTE	KILOMETER	POST	TOTAL PROJECT
04	SF, Alca	80	13.9/14.3	0.0/1.6	
PREPARED FOR THE <b>STATE OF CALIFORNIA</b>					BRIDGE NO.
DEPARTMENT OF TRANSPORTATION					34-0006L/1
PROJECT CONTRACT NO. 04-012024					KIEWIT/FCI/MANSON a JV.
NOTE: MATERIAL GRADES					
1. TYPE I= A-709 Gr. 50T1					
2. TYPE II= A709 Gr 50T1(THROUGH THICKNESS)					
KEY					
○ INDICATES PC#					
□ INDICATES CODE SYM					
⬡ INDICATES WELD#					
○ INDICATES DETAIL#					
* SEE PART SKETCH					



PIER # \_\_\_\_\_

As a representative of Kiewit Engineering Co. I certify that the footing shop fabrication drawings in which my stamp is affixed accurately conforms to the specifications and the dimensional requirements of design drawings sheet 483R1 of 978 through sheet 493R1 of 978 revision data 5/28/02 provided under Cal Trans Contract No 04-012024 and drawings or instructions for installation provided by Kiewit/FCI/Manson, JV



PIER E7 THRU E14  
16 FOOTINGS TOTAL

PIER SOCKET CASING W/ SHEAR PLATES  
( 1 REQ'D PER FOOTING )

ALL DIMENSIONS ARE IN  
MILLIMETERS UNLESS OTHERWISE SHOWN

SAN FRANCISCO OAKLAND BAY BRIDGE EAST SPAN SEISMIC SAFETY PROJECT	
JOB NO: 3657	
SKYWAY STRUCTURES	
ACCT NO:	
DRAWN BY: ADR	
CHK'D BY: TG/DB	
PL THK:	
PL GRADE:	
SCALE: NTS	DISREGARD PRINTS BEARING
DATE: 05/12/02	EARLIER REVISION DATES
REF. DWG. SHT. NO. 005	TOTAL SPTS. 24
	REV. 2
	SHEET 17
	OF 24

REV.	DATE	REVISION	BY
2	12/3/02	REF'D DIM'S TO BOTTOM PLATE	SLB
1	9/10/02	GENERAL REVISIONS	LRod
0	7/16/02	ISSUED FOR CONSTRUCTION	TG



C.A.D. FILENAME  
C:\SHOP DWG SD-LWOC-17

NCR 3657-48  
2/9



### INSPECTION REPORT

	JOB NO.:	CLIENT:	PIECE / PART / COMPONENT	DRAWING / SPECIFICATION
INSPECTION DETAILS	3657	Caltrans	SP-208	E-10
	<p>Welder welding with temperature less than 200 degrees on Repair. Welder was welding on a Repair on Shear Plate SP-208 Pier socket #1 Pier Sleeve C-2 location Stencil DXR W#3</p>			
INSPECTION RESULTS	<p>The preheat temperature was brought up to 275 degrees and welding was continued. The weld was welded out and the weld was visual inspected and 100% UT will be performed. CFE-20</p>			
	<p>Satisfactory Inspection Results    Yes <input checked="" type="checkbox"/>    No <input type="checkbox"/></p>			<p>If not satisfactory, explain in the Comment Section of this report.</p>
COMMENTS	<p>Inspector/ Date: <u>4-9-03</u>    Witness / Date: * _____    Distribution: _____</p> <p><i>Ronald Williams Jr.</i>    * If Required</p>			
	<p>REPAIR w/o PROPER PREHEAT NOTED ON 4/9/03</p>			

# WALZEL Services

PO Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 4/5/03  
Report No. UT 648  
Page 1 of 2

Customer Kiewit Offshore Services, Ltd. DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBB  
Job No. 3657 Job instructions Par \_\_\_\_\_

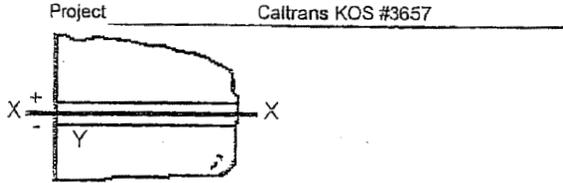
ULTRASONIC		MAGNETIC PARTICLE		PENETRANT	
Instrument Sonatest #1401503C		<input type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand	
Longitudinal		<input type="checkbox"/> AC	<input type="checkbox"/> DC	Type	
2.25 MHz	Shear 2.25 MHz	<input type="checkbox"/> Residual	<input type="checkbox"/> Continuous	Batch No.	Florescent Minutes
Size 1.0 Round	Size 5/8"	Equipment		Penetrant	
Type Aero Tech.	Type Tech.	Procedure		Remover	
Couplant Cellulose	Angle <u>0.45, 70</u>	Code		Developer	
Procedure	Code			Procedure	Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
W-8	2387	SP-708 @ 2A (Base Plate)		X	E-10-East (SD-100-17)
W-8	5400	SP-208 @ 2A (To Pier Socket)		X	
W-3	2387	SP-204 @ C2 (Base Plate)		X	
W-3	5400	SP-708 @ C2 (To Pier Socket)		X	
<p>ORIGINAL REPORT OF DEFECTS @ 4-5-03</p>					

Total mm inspected - 15575  
Total mm accepted - 3415  
all mm rejected - 12160

Examination Performed By Joe Vicars Accepted By George Barnhill  
Joe Vicars George Barnhill

REPORT OF ULTRASONIC TESTING OF WELDS



Report no. UT 649  
 Weld identification SP-208  
 Material thickness 76  
 Weld joint AWS T  
 Welding process TAB-6.3  
 Quality requirements - section no. Flux Core  
 Remarks Page 2 of 2

Line number	Indication number	Transducer angle	From Face	Leg*	Decibels				Discontinuity				Discontinuity evaluation	Remarks	
					Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular distance (sound path)	Depth from "A" surface	Distance			
												a			b
1	1	70	A	1	72	62	5	+5	2387	76	25	0	0	C	(W-8) SP-208 @ 2A
2															Base Plate
4	1	45	A	1	68	60	3	+5	1280	50	50	-20	0	A	SP-208 @ 2A (W-8)
5	2	45	A	1	68	60	3	+5	92	50	50	-20	1925	A	To Pier Socket
6	3	45	A	1	68	60	3	+5	584	50	50	-20	3962	A	
7	4	45	A	1	68	60	3	+5	50	50	50	-20	4724	A	
8															
9															
10	1	70	A	1	72	62	5	+5	2387	76	25	0	0	C	SP-208 @ C2 (W-3)
11															Base Plate
12															
13	1	45	A	1	68	60	3	+5	5400	50	50	-20	0	A	SP-208 @ C2 (W-3)
14															To Pier Socket
15															
16															
17															
18															
19															
20															
21															
22															
23															
24															
25															
26															

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 Section 6, Part F of ANSI/AASHTO/AWS D1.5, (1996) Bridge Welding Code.

Test Date 4/5/09 Manufacturer or Contractor KOS  
 Inspected by [Signature] Authorized by [Signature]  
 George Barnhill  
 Date 4/6/09

- Notes:
- In order to attain Rating "d"
    - With instruments with gain control, use the formula a-b-c=d.
    - With instruments with attenuation control, use the formula b-a-c=d.
    - A plus or minus sign must accompany the "d" figure unless "d" is equal to zero.
  - Distance from X is used in describing the location of a weld discontinuity in a direction perpendicular to the weld reference line.
  - Distance from Y is used in describing the location of a weld discontinuity in a direction parallel to the weld reference line. This figure is attained by measuring the distance from the "Y" end of the weld to the beginning of said discontinuity.
  - Evaluation of Retested Repaired Weld Areas must be tabulated on a new line on the report form. If the original report form is used, R<sub>n</sub> shall Prefix the indication number. If additional forms are used, the R number shall prefix the report number.
- \*Use Leg I, II or III. See glossary of terms (Annex V).

Figure VII-6 - Form VII-11 - Report of Ultrasonic Testing of Welds

NCR 3657-48  
6/9

# WALZEL Services

PO Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-885-776-0078 • Fax 1-888-220-3077

Date 4/17/03  
Report No. UT 710R  
Page 1 of 2

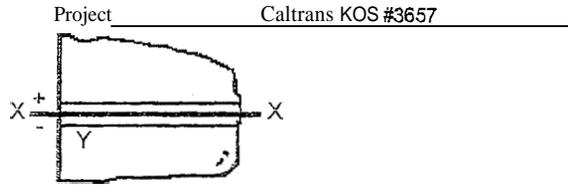
Customer Kiewit Offshore Services, Ltd. DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBB  
Job No. 3657 Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT	
Instrument Sonatest #1401503C		<input type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand	
Longitudinal		<input type="checkbox"/> AC	<input type="checkbox"/> DC	Type	
2.25 MHz	Shear 2.25 MHz	<input type="checkbox"/> Residual	<input type="checkbox"/> Continuous	Batch No.	Florescent Minutes
Size 1.0 Round	Size 5/8"	Equipment		Penetrant	
Type Aero Tech.	Type Tech.	Procedure		Remover	
Couplant Cellulose	Angle 45, 70	Code		Developer	
Procedure D1.5 - 1996	Code D1.5 - 1996	Code		Procedure	Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
J3R1		SP-204 @ C-2 (To Base Plate)	/		E-10-EAST (Clears Lpt # 64)
J3R1		SP-204 @ C-2 (To Pier Socket)		X	↓
<p>2ND REPORT ON DEFECT REPAIR NOTE - REPAIRS NOT CLEARED</p>					
Total mm inspected -					
Total mm accepted -					
mm rejected - 3274					

Examination Performed By Joe Vicars Accepted By George Barnhill  
Joe Vicars George Barnhill

REPORT OF ULTRASONIC TESTING OF WELDS



Report no. UT 710R  
 Weld identification U-3R1  
 Material thickness 76  
 Weld joint AWS  
 Welding process Flux Core  
 Quality requirements - section no. Table 6.3  
 Remarks Page 2 of 2

Line number	Indication number	Transducer angle	From Face	Leg*	Decibels				Discontinuity				Discontinuity evaluation	Remarks	
					Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular distance (sound path)	Depth from "A" surface	Distance			
												a			b
1	1	45	A	1	69	60	4	+5	1041	73	73	-20	0	A	SP-208 @ C-2
2	2	45	A	1	69	60	4	+5	304	63	63	-20	1854	A	U-3R1 (To Prev Socket)
3	3	45	A	1	67	60	2	+5	762	34	34	-20	2489	A	
4	4	45	A	1	68	60	3	+5	609	50	50	-20	3733	A	
5	5	45	A	1	67	60	2	+5	304	41	41	-20	4724	A	
6	6	45	A	1	67	60	2	+5	254	41	41	-20	5105	A	
7															
8															
9															
10															
11															
12															
13															
14															
15															
16															
17															
18															
19															
20															
21															
22															
23															
24															
25															
26															

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 Section 6, Part F of ANSI/AASHTO/AWS 01.5, (1996) Bridge Welding Code.

Test Date 4/17/03

Manufacturer or Contractor KOS

Inspected by [Signature]  
Joe Vicars

Authorized by [Signature]  
George Barnhill

Notes:

Date 4/12/03

- In order to attain Rating "d"
    - With instruments with gain control, use the formula  $a-b-c=d$ .
    - With instruments with attenuation control, use the formula  $b-a-c=d$ .
    - A plus or minus sign must accompany the "d" figure unless "d" is equal to zero.
  - Distance from X is used in describing the location of a weld discontinuity in a direction perpendicular to the weld reference line.
  - Distance from Y is used in describing the location of a weld discontinuity in a direction parallel to the weld reference line. This figure is attained by measuring the distance from the "Y" end of the weld to the beginning of said discontinuity.
  - Evaluation of Retested Repaired Weld Areas must be tabulated on a new line on the report form. If the original report form is used, R<sub>n</sub> shall prefix the indication number. If additional forms are used, the R number shall prefix the report number.
- \*Use Leg I, II or III. See glossary of terms (Annex V).

# WALZEL Services

PO Box 1817  
Aransas Pass, Texas 78335-1817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 9/26/03  
Report No. UT 749R  
Page 1 of 1

Customer Kiewit Offshore Services, Ltd. DWG. No. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBE  
Job No. 3657 Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT	
Instrument Sonatest #1401503C		<input type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand	
Longitudinal		<input type="checkbox"/> AC	<input type="checkbox"/> DC	Type	
2.25 MHz	Shear 2.25 MHz	<input type="checkbox"/> Residual	<input type="checkbox"/> Continuous	Batch No.	Florescent Minutes
Size 1.0 Round	Size 5/8"	Equipment		Penetrant	
Type Aero Tech.	Type Tech.	Procedure		Remover	
Couplant Cellulose	Angle 45 70	Code		Developer	
Procedure D1.5 - 1996	Code D1.5 - 1996			Procedure	Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
4-3R2		SP-208 @ C-2 (To Pier Socket)	/		E-10-EAST Clears Rpt # 7108, 648
1-9R2		SP-208 @ A-1 (To Pile Sleeve)	/		Clears Rpt # 3661, 370R
2-10R		PS-2 To Base Plate	/		Clears Rpt # 709
1-10R2		PS-1 To Base Plate	/		Clears Rpt # 7228, 664
-15R1		Padeye @ A-1 (SP-204A)	/		Clears Rpt # 721
1-15R1		Padeye @ C-2 (SP-204A)	/		Clears Rpt # 721

Total mm inspected -  
mm accepted -  
mm rejected -

\* REPAIRS CLEARED 17 DAYS AFTER INITIAL REPAIR w/ LOW PREHEAT.

Examination Performed By Joe Vicars Accepted By George Barnhill  
Joe Vicars George Barnhill

NCR 3657-48  
919

# WALZEL Services

Box 1817  
Aransas Pass, Texas 783354817  
Phone 1-888-776-0078 • Fax 1-888-220-3077

Date 5-8-03  
Report No. MT/102  
Page 1 of 1

Customer Kiewit Offshore Services, Ltd. DWG. NO. \_\_\_\_\_  
Fabricator Kiewit Offshore Services, Ltd. Project Name Caltrans SFOBB  
Job No. 3657 Job Instructions Per \_\_\_\_\_

ULTRASONIC		MAGNETIC PARTICLE		PENETRANT	
Instrument		<input checked="" type="checkbox"/> Wet	<input type="checkbox"/> Dry	Brand	Visible
Longitudinal	Shear	<input checked="" type="checkbox"/> AC	<input type="checkbox"/> DC	Type	Florescent
mHz	mHz	<input type="checkbox"/> Residual	<input checked="" type="checkbox"/> Continuous		Minutes
Size	Size	T		Penetrant	
Type	Type	Equipment Electrospec X-Yoke		Remove	
Couplant	Angle	Procedure WMT-200		Developer	
Procedure	Code	Code AWS D1.5-1996		Procedure	Code

ITEM	QUANTITY	LOCATIONS & IDENTIFICATION	ACCEPTABLE		TYPE OF DEFECTS REMARKS
			Yes	No	
		E-10-E Sp 205 to P.S.Z / B-2 Sleeve NCR # 3657-47	/		
		Sp 208 to P.S.Z / C-2 Sleeve NCR # 3657-48	/		
<div style="border: 1px solid black; border-radius: 50%; padding: 10px; width: fit-content; margin: 0 auto;">           ADDITIONAL MT FOR NCR - 30 DAYS AFTER INITIAL REPAIR w/ LOW PREHEAT         </div>					

total mm inspected -  
total mm accepted -  
total mm rejected -

Examination Performed BY Tommy Hernandez Accepted BY George Barnhill

**DEPARTMENT OF TRANSPORTATION**

SFOBB – Skyway Project  
345 Burma Road  
Oakland, CA 94607  
Facsimile Number: (510) 622-5165



*Flex Your Power  
Be Energy Efficient!*

June 06, 2003

KFM, a JV  
P.O. Box 23223  
Oakland, CA 94623

Contract: 04-012024  
04-SF, Ala-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project

*State Letter # 5.03.1-001872*

*Subject: KOS RFI No.69R1*

Dear Mr. Skoro,  
Attention: Mr. Rich Bienek,

We received your Request For Information titled, "KOS RFI #69R1 - Answer to NCR 47 & 48," KFM-RFI-000688 Rev.00 on May 27, 2003. Based upon documentation provided, this RFI is approved. However, please be informed that insufficient preheat is not recommended or acceptable per AWS D1.5, and will not be accepted in the future.

If you have any questions regarding this matter, please call Mark Baker at (510) 774-6576.

Sincerely,

A handwritten signature in cursive script that reads "Mark Woods".

Mark Woods  
Foundation Structure Representative

For: Mr. Douglas Coe  
Resident Engineer

cc: M. Woods  
Y. Lin  
D. Coe  
V. Iyer  
M. Baker

file: 5.03.1, 56.0688, 9.03.2