



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

**LETTER OF SUBMITTAL**  
**KFM Skyway Project # 04-012024**

Run Date 01-Aug-06  
 Time 3:46 PM

Dated: 8/2/06

SUBMITTAL No: KFM-SUB-006953 Rev: 00

To: Doug Coe  
 Caltrans-Skyway Project  
 345 Burma Road  
 Oakland CA 94607  
 Phone: Fax:

Co/Job # 364-3726  
 Contract # 04-012024  
 Sub/Supplier:  
 Sub/Supplier No:

Subject: NCR 31 Close Out

Special Provis. (SP) REF:  
 Standard Spec. (SS) REF:  
 RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items:  Attached  Via Fax

- |  |  |  |
|--|--|--|
| <input type="checkbox"/> Contract Plans/Specs  | <input type="checkbox"/> Certs of Compl./Samples   | <input type="checkbox"/> Working Drawings    |
| <input type="checkbox"/> Drawings/Calculations | <input type="checkbox"/> Schedule                  | <input type="checkbox"/> WQCP and/or Addenda |
| <input type="checkbox"/> Change Order          | <input type="checkbox"/> Progress Estimate Request | <input type="checkbox"/> Weekly Weld Reports |
| <input type="checkbox"/> Copy of Letter        | <input type="checkbox"/> Payroll Information       | <input type="checkbox"/> CWR Procedure       |

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	01-Aug-06	1	NCR 31 Close Out		0	Pending	1
02	17-Jan-06	1	State Letter # 5.03.1-009434		0	Pending	1
03	19-Apr-06	1	State Letter # 5.03.1-009914		0	Pending	1
04	24-May-06	1	UT Report		0	Pending	2

These are transmitted as checked below:

- |  |   |  |
|--|---|--|
| <input checked="" type="checkbox"/> For Approval | <input type="checkbox"/> For Review/Comment | <input type="checkbox"/> Return For Correction |
| <input type="checkbox"/> For Your Use            | <input type="checkbox"/> As Requested       | <input type="checkbox"/> For Information       |

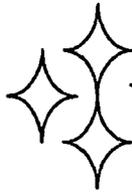
Remarks:

CC:

Please review / approve by : \_\_\_\_\_

Submitted By: Paul Hegarty  
 (KFM Staff Member – Originator of Transmittal)

Checked & Sent By:   
 Contract Admin/DCS Staff



## **TRANS BAY STEEL, CORP.**

1025 KAISER ROAD, NAPA, CA 94558  
TELEPHONE: (707)259-0777 FAX: (707)259-1072

August 1, 2006

Kiewit/FCI/Manson A JV  
P.O. Box 23223  
Oakland, Ca 94623

**Reference:** SFOBB Skyway Contract # 04-012024

**Subject:** NCR 31 Close Out

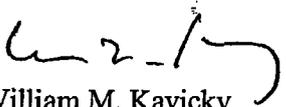
**Attn:** Dennis Winter

Trans Bay Steel is in receipt of State Letter 9434 which reported SAW welding by unqualified unapproved welding operators on BEN-7 and BES-7.

Please request that the Engineer issue a letter to close the NCR in light of the following measures taken and or events which have occurred:

1. Both welding operators were working under the direct supervision of a certified and approved welding operator and have since been qualified and approved by the Engineer. See attached Caltrans Letter 9914 in response to KFM-SUB-2359R88 (TBS WQCP addendum 76).
2. Mr. Hernandez no longer works with Trans Bay Steel.
3. See attached final acceptable NDE reports for BEN-7 (CWS Fixed section) and BES-7 (CWN Fixed section).

Please do not hesitate to call this office for any clarification which will enable closure of this matter.

  
William M. Kavicky.  
Trans Bay Steel Corp.

Cc:

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

January 17, 2006

KFM, a JV  
220 Burma Road  
Oakland, CA 94607

Contract: 04-012024  
04-SF, Ala-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project  
State Letter # 5.03.1-009434

*Subject: TBS NCR No. 31: Unapproved SAW Welding Operators*

Dear Mr. Zink,  
Attention: Mr. Lee Zink,

This Non-Conformance Report (NCR) is being issued to KFM's subcontractor, Trans Bay Steel (TBS), for two welders performing submerged arc welding (SAW) without having been tested (qualified) or approved.

On January 12<sup>th</sup>, 2006, Mark Pacheco was performing SAW operations on pipe beam section BEN-7. On January 13<sup>th</sup>, 2006, Eudalio Hernandez was performing SAW operations on pipe beam section BES-7. Neither of these welders have been qualified or approved.

Please review and propose corrections to resolve this NCR. If you have any questions, please call David Wu at (510) 622-5104.

Sincerely,

<<< ORIGINAL SIGNED >>>

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, D. Wu, M. Woods, B. Chew, D. Wright, V. Iyer, H. El-Natur  
file: 5.03.1, 9.07.11

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

April 19, 2006

KFM, a JV  
220 Burma Road  
Oakland, CA 94607

Contract: 04-012024  
04-SF, Ala-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project  
State Letter # 5.03.1-009914

*Subject: Response to KFM Submittal No. 2359 R88: TBS WQCP Addendum 76*

Dear Mr. Zink,  
Attention: Dennis Winter,

We reviewed KFM Submittal No. 2359 Rev. 88, "Transbay Welding Quality Control Plan – Addendum #76", in accordance with Section 8-3.01 of the Special Provisions, and it is approved.

The following six welding operators are approved for SAW (FCM):

Brian Peterson (Welder ID 8040)  
Raul Peregrina (0736)  
Mark Pacheco (2773)  
Eulalio Hernandez (7445)  
Suphan Baukham (9036)  
Sathaporn Pornsririsak (9030)

The following three welders are approved for FCAW (FCM):

William McHaney (Welder ID 3666)  
William Nichols (6995)  
William Rodriguez (0141)

If you have any questions regarding this matter, please call David Wu at (510) 622-5104.

Sincerely,

<<< ORIGINAL SIGNED >>>

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

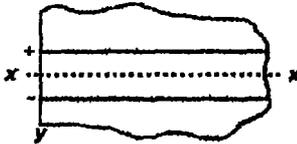
cc: D. Coe, D. Wu, M. Woods, B. Chew, D. Wright, V. Iyer  
file: 5.03.1, 55.2359

**ULTRASONIC INSPECTION REPORT**

Project Skyway Project ~ Pipe Hinge Beams ~ 04-012024 TBS # 7665 (CCO 160)

Quality Requirements Section 9, Table 9.1 & 9.2

Calibration Block Serial No. 05-8146



Line Number	Indication Number	Material Thickness	Angle°	From Face	Leg 1	Decibels				Discontinuity			Discontinuity Evaluation	Remarks		
						Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular Distance	Depth From A Face			Distance	
															a	b
1		100	0	A	1		25								BEN-7 Long Seam Weld #13 Lamination Scan UT OK	
2		100	60	A	1		50						390		BEN-7 Long Seam Weld #13 Bottom 1/4 Longitudinal Scan UT OK R2	
3		100	60	A	1		50						2370		BEN-7 Long Seam Weld #13 Bottom 1/4 Longitudinal Scan UT OK R2	
		100	70	A	1		46						480		BEN-7 Long Seam Weld #13 Middle 1/2 Longitudinal Scan UT OK R2	
5		100	70	A	1	73	54	10	9	20	153	50	0 +20	1780		BEN-7 Long Seam Weld #13 Middle 1/2 Transverse Scan Recordable Indication
6		100	70	A	1	71	54	13	4	20	185	60	0 +20	2125		BEN-7 Long Seam Weld #13 Middle 1/2 Transverse Scan Recordable Indication
7		100	70	A	1	70	54	11	4	20	170	55	0 +20	2453		BEN-7 Long Seam Weld #13 Middle 1/2 Transverse Scan Recordable Indication
8		100	70	A	1	73	54	11	8	30	166	54	-5 +25	2210		BEN-7 Long Seam Weld #13 Middle 1/2 Transverse Scan Recordable Indication
9		100	60	A	1		45									BEN-7 Long Seam Weld #13 Bottom 1/4 Transverse Scan UT OK
10		100	60	B	1		45							1390		BEN-7 Long Seam Weld #13 Top 1/4 Longitudinal Scan UT OK R2
11		100	60	B	1		45									BEN-7 Long Seam Weld #13 Top 1/4 Transverse Scan UT OK
12																
13																

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in conformance with the requirements of AWS D1.5, ( 1996 ) Bridge Welding Code-Steel.

Test Date Wednesday, May 24, 2006

Manufacturer or Contractor \_\_\_\_\_

Inspected by Steve Pacheco  

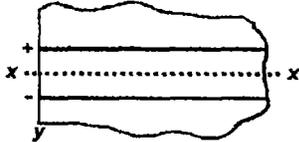

Authorized by \_\_\_\_\_

**ULTRASONIC INSPECTION REPORT**

Project Skyway Project ~ Pipe Hinge Beams ~ 04-012024 TBS # 7665 (CCO 160)

Quality Requirements Section 9, Table 9.1 & 9.2

Calibration Block Serial No. 05-8146

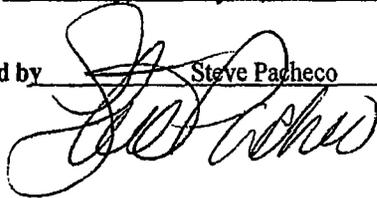


Line Number	Indication Number	Material Thickness	Angle	From Face	Leg 1	Decibels				Discontinuity				Discontinuity Evaluation	Remarks	
						Indication level	Reference level	Attenuation factor	Indication rating	Length	Angular Distance	Depth From A Face	Distance			
													a			b
1		100	0	A	1	—	25	—	—	—	—	—	—	—	BES-7 Long Seam Weld 13 Lamination Scan UT OK	
2		100	60	A	1	—	49	—	—	—	—	—	1160	—	BES-7 Long Seam Weld 13 Bottom 1/4 Longitudinal Scan UT OK R/1	
3		100	60	A	1	—	31	—	—	—	—	—	—	—	BES-7 Long Seam Weld 13 Bottom 1/4 Transverse Scan UT OK	
4		100	70	A	1	—	32	—	—	—	—	—	—	—	BES-7 Long Seam Weld 13 Middle 1/2 Longitudinal Scan UT OK	
5		100	70	A	1	—	32	—	—	—	—	—	—	—	BES-7 Long Seam Weld 13 Middle 1/2 Transverse Scan UT OK	
6		100	60	B	1	—	31	—	—	—	—	—	2390	—	BES-7 Long Seam Weld 13 Top 1/4 Longitudinal Scan UT OK R/1	
7		100	60	B	1	—	31	—	—	—	—	—	—	—	BES-7 Long Seam Weld 13 Top 1/4 Transverse Scan UT OK	
8																
9																
10																
11																
12																
13																

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in conformance with the requirements of AWS D1.5, ( 1996 ) Bridge Welding Code-Steel.

Test Date Tuesday, February 14, 2006

Manufacturer or Contractor \_\_\_\_\_

Inspected by Steve Pacheco  


Authorized by \_\_\_\_\_

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

January 11, 2007

KFM, a JV  
220 Burma Road  
Oakland, CA 94607

Contract: 04-012024  
04-SF, Ala-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project  
*State Letter # 5.03.1-010733*

*Subject: Response to KFM Submittal No. 6953: TBS NCR 31 Close Out*

Dear Mr. Zink,  
Attention: Dennis Winter,

We received KFM Submittal No. 6953 regarding the close out of Non-Conformance Report (NCR) number 31 at Trans Bay Steel (TBS). TBS NCR 31 was issued for two welding operators, Mark Pacheco and Eudalio Hernandez, performing submerged arc welding (SAW) operations prior to approval.

Both Mr. Pacheco and Mr. Hernandez were approved as SAW welding operators in State letter 9914. Also, each of the welds in question, the longitudinal seams of cans BEN-7 and BES-7, were 100% cleared by both Ultrasonic Testing and Magnetic Particle testing. The State considers NCR 31 to be resolved.

If you have any questions regarding this matter, please call David Wu at (510) 622-5104.

Sincerely,

**<<< ORIGINAL SIGNED >>>**

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, D. Wu, M. Woods, B. Chew, V. Iyer  
file: 5.03.1, 55.6953, 9.07.11