



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 14-Aug-06  
Time 9:02 AM

Dated: 8/14/06

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

SUBMITTAL No: KFM-SUB-006992 Rev: 00  
Co/Job # 364-3726  
Contract # 04-012024  
Sub/Supplier: USI  
Sub/Supplier No:

Subject: USI - Close out letter for NCR 259

Special Provis. (SP) REF: 10-1.44  
Standard Spec. (SS) REF:

**RESUBMITTAL/SUPPLEMENTAL REF:**

We are sending the following attached items:  Attached  Via Fax

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

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	14-Aug-06	1	USI - Closeout Letter for NCR 259		0	Pending	5

**These are transmitted as checked below:**

- For Approval
- For Review/Comment
- Return For Correction
- For Your Use
- As Requested
- For Information

Remarks:

CC:

Please review / approve by : 21-Aug-2006

Submitted By: Dennis Winter  
(KFM Staff Member - Originator of Transmittal)

Checked & Sent By:   
Contract Admin/DCS Staff



**Universal Structural, Inc.**

April 3, 2006

Kiewit / FCI / Manson, JV (KFM)  
220 Burma Road  
Oakland, CA 94607  
Phone: (510) 419-0120  
Fax: (510) 839-0666

Attention: Paul Hegarty / Rich Bienek

Reference: SFOBB Skyway Project  
USI #23932 (NCR LTR# 259.040306)

Subject: Response to Caltrans State Letter# 5.03.1-009792  
KFM NCR# 259/Mets# 258

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. has received Caltrans State Letter #5.03.1-009792 dated March 23, 2006. Caltrans stated:

*"1. KFM'S quality control manager and onsite representatives allowed USI to weld closed ribs to deck panel pa304 utilizing parameters other than those qualified in the weld monitoring tests resulting in visible melt through and burn through on weld joints 2, 5, 8 and 9."*

There was no obvious cause of the problem at the time that these particular welds were completed. When comparing parameters for the WMT and the actual production weld, one possible cause could have been that the electrode position was slightly high on the web of the closed rib.

The extent of the melt through was investigated and was found to be within the first 1,000mm of deposited weld. These welds were started at the open end of the closed rib so there is a reasonable level of confidence that the melt through did not continue past the first internal diaphragm and into an area that can't be seen.

In order to prevent re-occurrence, USI welding supervision has met and discussed the importance of avoiding weld melt through. USI has instructed welders to pay closer attention, and what to pay attention to, based on the character of the melt through on deck panel Pa304.

The excessive melt through in the closed ribs on deck panel Pa304 has been ground out and blended to ensure that no gross notch remained. Re-inspection has taken place on deck panel Pa304 and has an acceptable status. Deck panel Pa304 is now considered to be in compliance with the contract specifications.

Please review attachments:

- Copy of - Caltrans State Letter # 5.03.1-009792
- Copy of - Caltrans Pre-Notification Letter dated 3/16/06

Please review and submit to Caltrans for a letter to close this NCR. If you have any questions or need further clarification, please contact me at your earliest possible convenience.

UNIVERSAL STRUCTURAL, INC.

SFOBB Skyway Project  
USI # 23932

April 5, 2006

Sincerely,  
**Universal Structural, Inc.**

A handwritten signature in black ink that reads "Nate Lindell". The signature is written in a cursive, slightly slanted style.

Nate Lindell  
QA Manager

**DEPARTMENT OF TRANSPORTATION**

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



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Be Energy Efficient!*

# COPY

March 23, 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 # 5.03.1-009792

*Subject: KFM/USI NCR No. 258: Utilizing Parameters Other Than Those Qualified in Weld Monitoring Tests*

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

This Non-Conformance Report (NCR) is issued by the Engineer to KFM as a result of your supplier, USI, for the following reason:

1. KFM's quality control manager and onsite representatives allowed USI to weld closed ribs to deck panel pa304 utilizing parameters other than those qualified in the weld monitoring tests resulting in visible melt through and burn through on weld joints 2, 5, 8 and 9.

This NCR will be tracked as KFM/USI NCR No. 258. KFM/USI was verbally notified of this NCR by Caltrans' METS on 03/16/06. Please review and address how you plan to resolve this NCR and bring your work back into compliance with our contract.

Should you have any questions, please contact David Wu at (510) 622-5104 or Patrick Lowry at (858) 344-2712.

Sincerely,

A handwritten signature in cursive script that reads "David Wu".

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

cc: P. Lowry, D. Coe, D. Wu, B. Chew, V. Iyer, I. Kwong, D. Salladay  
file: 5.03.1, 9.03.8

**DEPARTMENT OF TRANSPORTATION**  
DIVISION OF ENGINEERING SERVICES  
MATERIALS ENGINEERING AND TESTING 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  
FAX: (707) 649-5493

*Work was completed on 3/21. Caltrans should visually inspect on 3/23.*



Contract #: 04-01204  
Cty SF Rte 80 PM  
13.9/14/1.0.0/1.6.

File # 10 .25 B

**QUALITY ASSURANCE - NONCONFORMANCE REPORT**

**Location:** Universal Structural, Inc.

**Date:** 03-16-06

**Prime Contractor:** Kiewit/FCI/Manson (KFM) Joint Venture

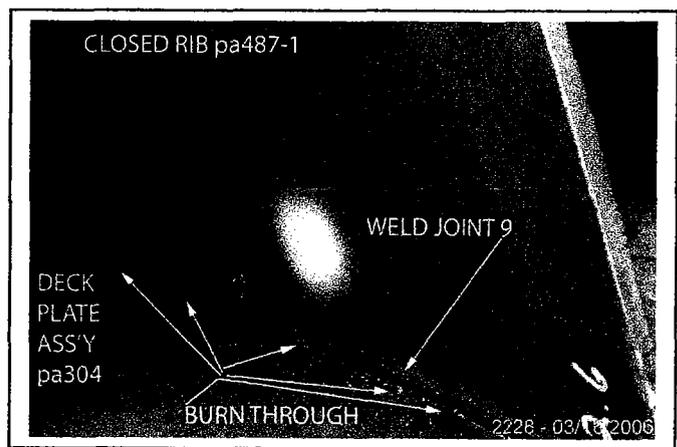
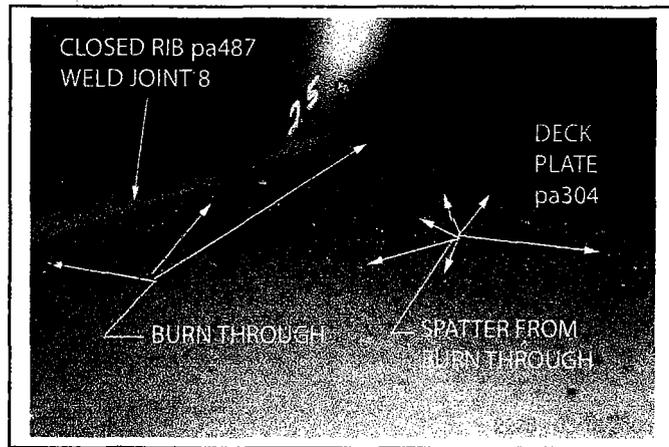
**NCR:** 258

**Submitting Contractor:** Universal Structural, Inc.

**Type of problem:**

<b>Welding</b>	<input checked="" type="checkbox"/>	<b>Concrete</b>	<input type="checkbox"/>	<b>Other</b>	<input type="checkbox"/>
<b>Welding:</b>	<input type="checkbox"/>	<b>Curing:</b>	<input type="checkbox"/>	<b>Procedural:</b>	<input type="checkbox"/>
<b>Joint fit-up:</b>	<input type="checkbox"/>	<b>Coating:</b>	<input type="checkbox"/>	<b>Other:</b>	<input type="checkbox"/>
<b>Procedural:</b>	<input checked="" type="checkbox"/>	<b>Procedural:</b>	<input type="checkbox"/>		

**Description of Non-Conformance:** As evidenced by visible melt-through and burn-through on Deck Panel pa304, weld joints 2, 5, 8 and 9, KFM's QCM on onsite representatives allowed USI to weld the closed-ribs to Deck Panel pa304 utilizing parameters other than those qualified in the Weld Monitoring Tests.



**Applicable reference:** *Special Provisions* Section 10-1.44, **Welding of Closed Ribs to Deck Plate**, Item C

**Who discovered the problem:** Patrick Lowry

**Name of individual from Contractor notified:** Universal Structural, Inc. Quality Control Inspector Peter Hale

**Time and method of notification:** Approximately 2100, verbally

**Name of Caltrans Engineer notified:**

**Time and method of notification:**

**QC Inspector's Name:** Peter Hale

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

**Contractor's proposal to correct the problem:** No proposal has been submitted at this time.

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# QUALITY ASSURANCE - NONCONFORMANCE REPORT

*(Continued, Page 2 of 2)*

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**Comments:** This report is for the purpose of determining general 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 Patrick Lowry, (858) 344-2712,, who represents the Office of Structural Materials for your project.

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Inspected By: Chuck Franco

Quality Assurance Inspector

Reviewed By: Dave McClary

Lead QA Inspector

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
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August 18, 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 # 5.03.1-010314

*Subject: Response to various KFM Submittals to Closeout USI Non-Conformance Reports*

Dear Mr. Zink,  
 Attention: Mr. Dennis Winter,

The Engineer has reviewed and takes no exceptions to the following submittals, which contain documents to closeout various Non-Conformance Reports (NCR):

<b>KFM-SUB #</b>	<b>Description</b>
6954	USI Documents Closing NCR 169 (METS NCR 159)
6955	USI Documents Closing NCR 181 (METS NCR 170)
6956	USI Documents Closing NCR 199 (METS NCR 188)
6959	USI Documents Closing NCR 244 (METS NCR 239)
6961	USI Documents Closing NCR 248 (METS NCR 243)
6963	USI Documents Closing NCR 251 (METS NCR 246)
6964	USI Documents Closing NCR 252 (METS NCR 247)
6965	USI Documents Closing NCR 253 (METS NCR 248)
6992	USI Documents Closing NCR 259 (METS NCR 258)

If you have any questions, please contact David Wu at (510) 622-5104 or Ady Velasco at (858) 344-8746.

Sincerely,

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

David Wu  
 Senior Bridge Engineer

For: Mr. Douglas Coe  
 Resident Engineer

cc: P. Lowry, D. Coe, V. Iyer, D. Wu, B. Chew, I. Kwong

file: 5.03.1