

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



Contract #: 04-0120E4
Cty SF Rte 80 PM 13.4/13.8
File # 45 .25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Kiewit Offshore Services (KOS)

Date: March 13, 2006

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

NCR # 063

Submitting Contractor: KOS

Type of problem:

- Welding Concrete Other Heat Straightening Procedure
- Welding: Curing: Procedural: Bridge No.: 34-0006L/R
- Joint fit-up: Coating: Other: Component: T-1 Footing/Bottom Plate
Assembly joining piece #'s P37A & P38A
- Procedural: Procedural:

Description of Non-Conformance: KOS performed heat straightening of bottom plate assembly joining P37A and P38A in an effort to remove distortion with out prior approval from the Engineer. Following are digital photographs that illustrate KOS in the process of heat straightening the identified bottom plate assembly.



QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)



Applicable reference: AWS D1.5 (2002) Section 3.7.3

Who discovered the problem: Caltrans QA Inspector David Flygare

Name of individual from Contractor notified: George Barnhill, KOS Quality Control Representative (QC)

Time and method of notification: Verbal with George Barnhill on March 13, 2006 at approximately 1730 hours.

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: 03/14/06 at approximately 0840 hours via email

QC Inspector's Name: Eloy Gonzales

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: Unknown as of this time.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: David Flygare

Quality Assurance Inspector

Reviewed By: Mahlon Lindenmuth

Lead QA Inspector

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Contract # : 04-0120E4
Cty SF Rte 80 PM 13.8
File # 45.25A

QUALITY ASSURANCE - NONCONFORMANCE RESOLUTION

Location: Ingleside, Texas

Date: July 17, 2006

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

NCR#63

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:

Welding **Concrete** **Other** **Heat Straightening Procedure**

Welding: **Curing:** **Procedural:**

Joint fit-up: **Coating:** **Other:**

Procedural: **Procedural:**

Bridge No. 34-0006L/R **Component** T1 Foundation Footing

Date nonconformance report was written: March 13, 2006

Description of Non-Conformance: KOS performed heat straightening without the approval of the Engineer.

Contractor's proposal to correct the problem: KFM Submittal 690, Revision 0 has been submitted and approved by Caltrans.

Corrective action taken: None

Did corrective action require Engineer's approval? Yes No

If so, name of the Engineer providing approval: Mark Vilcheck, per Caltrans state letter **Date:** 7-17-06
05.003.01-001531

Is Engineer's approval attached: Yes No

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: Mary Madere

Quality Assurance Inspector

Reviewed By: Robert Cuellar & Keith Hoffman

QA Reviewer and Branch Senior

Memorandum

*Flex your power!
Be energy efficient!*

COMPLETED

To: MARK VILCHECK
Structure Representative
333 Burma Road
Oakland, CA 94607

Date: June 30, 2006
File: 04-0120E4
E2/T1 Foundations

From: RYAN T. SMITH
Structural Materials Representative
Quality Assurance and Source Inspection Branch
Office of Structural Materials

KFM SUBMITTALS 685-00, 686-00, 687-00, 688-00, 689-00, 690-00 – KIEWIT OFFSHORE SERVICES (KOS) RESPONSE TO NCRs

The Office of Structural Materials has reviewed the following submittals requesting to close Nonconformance Reports (NCRs) regarding the fabrication of the T1 Pile Cap in Ingleside, TX. Please find the following comments regarding NCRs:

Submittal Number	Date Submitted	Description	Approved / Rejected	Notes
685-00	06/27/06	KOS Response to NCR 75	Approved	1
686-00	06/27/06	KOS Response to NCR 94	Approved	2
687-00	06/27/06	KOS Response to NCR 90	Rejected	3
688-00	06/27/06	KOS Response to NCR 87	Approved	4
689-00	06/27/06	KOS Response to NCR 61	Approved	5
690-00	06/27/06	KOS Response to NCR 63	Approved	5

Notes:

1. As indicated in the KOS letter dated June 20, 2006 (KFM Submittal 685-00), the welder in question was qualified for the welding process and position as indicated in State Letter 1073. The Contractor has since implemented a verification system to not let welders perform work until

prior approval by the Department. OSM considers NCR 075 to be resolved at this time.

2. As indicated in the KOS letter dated June 2, 2006, this issue was discussed in the conference call that took place between Caltrans, KFM, KOS, and Wazel on June 1, 2006. The Quality Control (QC) Inspector in question was reassigned to a different area in the KOS yard. Furthermore, OSM understands that the QC inspector received additional counseling on the AWS D1.5-2002 Code and projects specifications. OSM considers NCR 094 to be resolved at this time.
3. The subject submittal contains insufficient information to resolve the nonconformance. As indicated in the KOS letter dated June 21, 2006, the weld access hole (snipe) was welded out by KOS welders but has since been restored by KOS. The nonconformance shall be resolved when the Contractor provides Nondestructive Testing data of the area in question performed in accordance with AWS D1.5 2002, Section 6.7.3.
4. As indicated in KOS letter dated June 21, 2006, Caltrans has instructed KOS to leave the fifteen (15) welded-out stiffener snipes in their existing locations. It is the State's opinion that removing the snipes would prove more deleterious to the structure than leaving the weld access areas in the welded condition. The Contractor has inspected the snipes and found no cracks. OSM considers NCR 87 resolved at this time.
5. As indicated in KOS letter dated June 21, 2006, KOS performed heat straightening on bottom plate assemblies P37B and P38B (NCR 61) and P37A and P38A (NCR 63) without Engineering approval. Per conversation held with the Contractor on April 13, 2006, the Contractor has been allowed to perform four applications of heat, provided that a dimensional verification of the distortion removed is performed after two applications of heat. Furthermore, KFM Submittal 501-00, contains a revised Heat Straightening Request Procedure which outlines the updated HSR review procedures. OSM considers NCRs 61 and 63 to be resolved at this time.

Mark Vilcheck
June 30, 2006
Page 3

If you have any questions, or would like to discuss the issues, please call me at (858) 232-6799.

cc: Rafael Bolon
Tom Shimada
Patryk Pich
Robert Cuellar

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

333 Burma Rd.
Oakland, CA 94607
(510) 286-0538, (510) 286-0550 fax



Kiewit-FCI-Manson, JV
220 Burma Rd.
Oakland, CA 94607

Attn: Mr. Christopher Villa
Deputy Project Director

April 20, 2006

Contract No. 04-0120E4
04-SF-80-13.4, 13.8
SAS T1 & E2 Foundations
SFOBB-ESSSP

Letter No. 05.003.01-001048

Subject: Response to Submittal No. 468, Revision No. 00 (KOS Heat Straightening Request (HSR-005)),
Submittal No. 468, Revision No. 01 (KOS Heat Straightening Request (HSR-005) –
Request for Additional Heating) and
Submittal No. 468, Revision No. 02 (KOS Heat Straightening Request (HSR-005) -Request for
Additional Heating - Revised Form)

Dear Christopher,

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 468, Revision No. 00, dated April 10, 2006, which provided Heat-Straightening Request (HSR) No. 05 from Kiewit Offshore Services (KOS). Regarding this Submittal, the Department has the following comments:

1. The Contractor shall limit the number of applications of heat to two applications.
2. Please provide information regarding the amount of pre-cambering that will be used prior to welding.
3. Please address what measures the Contractor will employ to prevent similar instances from occurring in the future.

To confirm the verbal approval that the Department provided on April 10, 2006, the Department hereby approves ("Approved and Noted") Submittal No. 468, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions.

The Department has also reviewed KFM Submittal No. 468, Revision No. 01, dated April 11, 2006, which provided a request for additional heating for HSR No. 05 from KOS. Regarding this Submittal, the Department has the following comments:

1. Please explain why the initial HSR repair failed to remove any distortion.
2. Provide a list of the steps that the Contractor is taking to ensure that the additional heating requested will result in a successful repair.
3. Please address what measures the Contractor will employ to prevent similar instances from occurring in the future.

The Department cannot approve Submittal No. 468, Revision No. 01, at this time.

KEIWIT OFFSHORE
RECEIVED

APR 25 2006

PKS
SERVICES, LTD.

Distribution:

Phil Sechler
Mike Brown
Mayra Zuniga
George Barnhill
John Berggren-KFM

"Caltrans improves mobility across California"

21103 CN - 0118

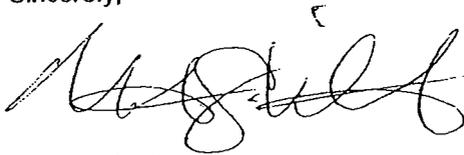
Finally, the Department has reviewed Kiewit-FCI-Manson Submittal No. 468, Revision No. 02, dated April 12, 2006, which provided a revised request for additional heating for HSR No. 05 from KOS. Regarding this Submittal, the Department has the following comments:

1. During the conversation between the Contractor and the Department of April 13, 2006, KOS personnel indicated that some deformation was resolved during the initial application of heat. Please include these adjusted deformation readings.
2. The Contractor shall limit the number of applications of heat to four applications.

To confirm the verbal approval that the Department provided on April 11, 2006, the Department hereby approves ("Approved and Noted") Submittal No. 468, Revision No. 02, pursuant to Section 8-3.01, "Welding," of the Special Provisions.

If you have any questions or need additional information, please contact Mark Vilcheck at 510-286-0526.

Sincerely,



Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.010.04, 55.468

SKYWAY-BAY BRIDGE PROJECT	
DATE	4/20/06
REQUESTED BY	SKM
TO	
INTERNAL KFM COPIES TO:	
EXTERNAL COPIES TO:	
SCANNED: (Y) N	FILED TO: Sub 468

468R1
468R2



Kiewit

2440 Kiewit Road
Ingleside, Texas 78362
Phone: 361-775-4300

Kiewit Offshore Services, Ltd.

TRANSMITTAL

No. 00127

KOS Job: 21103

PROJECT: T1 Tower Footing
Kiewit/FCI/Manson

REF: WQCP Addendum #18

ATTN: Chris Webb

DATE: 4/20/2006

WE ARE SENDING:	SUBMITTED FOR:	ACTION TAKEN:
<input type="checkbox"/> Shop Drawings	<input checked="" type="checkbox"/> Approval	<input type="checkbox"/> Approved as Submitted
<input type="checkbox"/> Letter	<input checked="" type="checkbox"/> Your Use	<input type="checkbox"/> Approved as Noted
<input type="checkbox"/> Prints	<input type="checkbox"/> As Requested	<input type="checkbox"/> Returned After Loan
<input type="checkbox"/> Change Order	<input type="checkbox"/> Review and Comment	<input type="checkbox"/> Resubmit
<input type="checkbox"/> Plans		<input type="checkbox"/> Submit
<input type="checkbox"/> Samples		<input type="checkbox"/> Returned
<input type="checkbox"/> Specifications	SENT VIA: <input checked="" type="checkbox"/> Attached	<input type="checkbox"/> Returned for Corrections
<input type="checkbox"/> Other:	<input type="checkbox"/> Separate Cover Via:	<input type="checkbox"/> Due Date:

DRAWING NO.	REV.	COPIES	DATE	DESCRIPTION
	9		4/20/2006	WQCP Addendum #18

Remarks:

Signed: 
George Barnhill



Chris Webb
QCM KFM JV.
Oakland, CA

Date: 04/20/06

Subject: WQCP Addendum #18

Chris,

Attached are nine (9) copies of WQCP Addendum #18. Please forward to the appropriate parties. If you have any questions, I can be reached at (361) 775-4420 or cell (361) 385-0189.

Regards,

A handwritten signature in cursive script, appearing to read 'George Barnhill'.

George Barnhill
QCM KOS
Ingleside, TX

Cc: Scott Cheney
Mike Brown



Subject:

Changes to Caltran's T1 Footing – WQCP**UPDATED**

Apr 20, 2006

Contract No. 04-0120E4, SAS T1 Foundations**Section/Tab****Action / Pages effected / changes**

Section 1, Tab E

(QC Organization Chart)

REPLACE this section.

Revised chart, adding new CWI - Douglas Aguilar

Section 1, Tab G

(QCM/CWI/CAWI Qualifications
and Certifications)

ADD to this section.

New CWI Inspector's resume and certificate – Douglas Aguilar

Section 1, Tab P-3

(Heat Straightening Request)

ADD to this section.

Heat Straightening Procedure Submittal Process

Addendum 18
Replace this section

Section 1, Tab E

(Organization Chart)

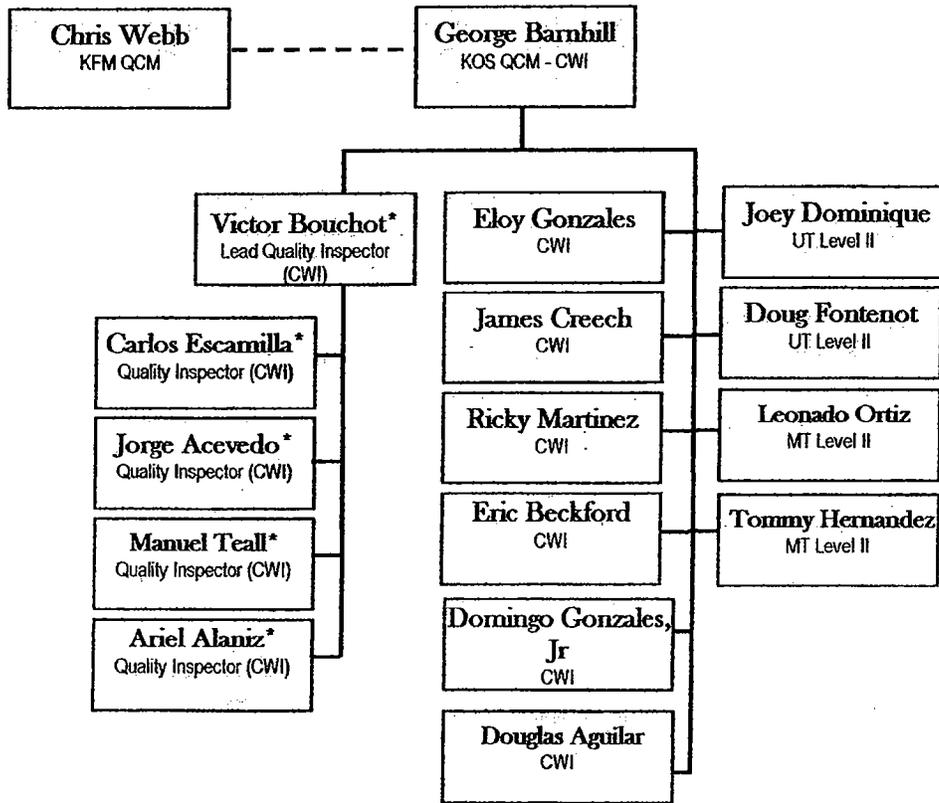


Kiewit

Revision # 6

Subject to Change

KOS Quality Organizational Chart For T1 Tower Footing San Francisco Oakland Bay Bridge



* Will be used when needed.

Note: All new inspectors added to project will be submitted to Caltrans as an Addendum

Addendum 18
Add to this section

Section 1, Tab G

**(QCM/CWI/CAWI Qualifications and
Certifications)**

WALZEL

TECHNICAL SERVICES

PERSONAL DATA

Name: Douglas Aguilar

EDUCATION

Baseline Data (Weld Inspection) – Portland, TX
Coastal Bend College (Advanced Welding/Fabrication/Layout)

CERTIFICATION

CWI Certification #04100171

SUMMARY

Certified Welding Inspector with welding background and experience in the industrial construction field including Production Platforms, Refinery Turnarounds, Shutdowns, & Maintenance.

EMPLOYMENT

All-Tech Inspection Visual Inspector Various visual inspection projects including Conoco Philips Refinery turnaround in Borger, TX	12/05 to Present
Ridlehuber Construction 1 st Class Structural Welder Welding and visual inspection and general maintenance of completed work	05/05 to 11/05
All-Tech Inspection Visual Inspector Inspection for refinery turnarounds.	2005
Kiewit 1 st Class Structural Welder Perform welding for various new construction and repair projects being located at facility in Ingleside, TX	12/02 to 04/04
Johnson Manufacturing 1 st Class Structural Perform various welding projects in Victoria, Tx.	03/01 to 11/02



American Welding Society

Certifies That
WELDING INSPECTOR
Douglas C Aguilar

Has complied with the requirements of Section 6.1 of the AWS Standard for
Qualification and Certification of Welding Inspectors, QC-1:96

with X, without eye correction, color blind

James C. Moore
AWS President

AWS Certification Chair



04100171
Certificate Number
October-07
Re-certify by

WALZEL TECHNICAL SERVICES
PERSONNEL TRAINING AND CERTIFICATION

EYE EXAMINATION RECORD

ATTACHMENT G

THIS VISION CERTIFICATION IS TO CERTIFY THAT Douglas Aguilar
HAS NATURAL OR CORRECTED NEAR-DISTANCE ACUITY IN AT LEAST ONE EYE,
AND IS CAPABLE OF READING A MINIMUM OF JEAGER NUMBER 1
OR EQUIVALENT TYPE OF SIZE LETTERS AT A DISTANCE OF NOT LESS THAN 12
INCHES (30.5 CM) ON A STANDARD JEAGER TEST CHART. HE/SHE IS ALSO
CAPABLE OF DISTINGUISHING AND DIFFERENTIATING CONTRAST BETWEEN
COLORS USED IN THE MAJOR NDE METHODS.

RESULTS

1. NEAR-DISTANCE ACUITY: WITHOUT J- _____ WITH J- 1+
CORRECTIVE LENS.
2. DISTANCE VISION: WITHOUT J- _____ WITH J- L 20/25 R 20/25
CORRECTIVE LENS.
3. COLOR VISION: PASSED WNL NO. PLATES 14

Gustavo Bedango

SIGNATURE OF ADMINISTRATOR

4-20-06

DATE

Douglas Aguilar

SIGNATURE OF WALZEL TECHNICIAN

4-20-06

DATE

THE ABOVE DATA MEETS THE REQUIREMENTS OF SNT-TC-1A

Addendum 18
Add to this section

Section 1, Tab P-3

(Heat Straightening Request)

T1 Footing Heat Straightening Procedure Submittal Process

- Submit heat straightening request via email to METS on-site representative (Robert Cuellar), and to KFM (Chris Webb, and John Berggren)
- The on-site METS representative is to review the heat straightening request and provide verbal approval to KOS' QCM (George Barnhill).
- All heat straightening is to follow KOS' Heat Straightening Procedure YP 5.1 contained in the WQCP.
- IF after heat straightening with (4) applications of heat, and the plate or weld joint requires further straightening, KOS is to submit and amended HSR to the on-site METS representative for additional heat applications. The heat straightening is on hold until the on-site METS representative gives verbal approval for additional heat straightening applications.
- For weekend approvals the on-site representative is to designate an alternate representative if he is unavailable.