

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: Ingleside, Texas

Date: 7-25-06

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

NCR #109

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:

- Welding [X] Concrete [] Other []
Welding: [] Curing: [] Procedural: []
Joint fit-up: [X] Coating: [] Other: []

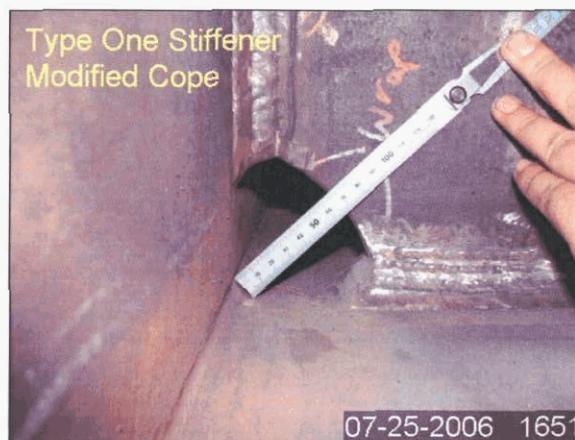
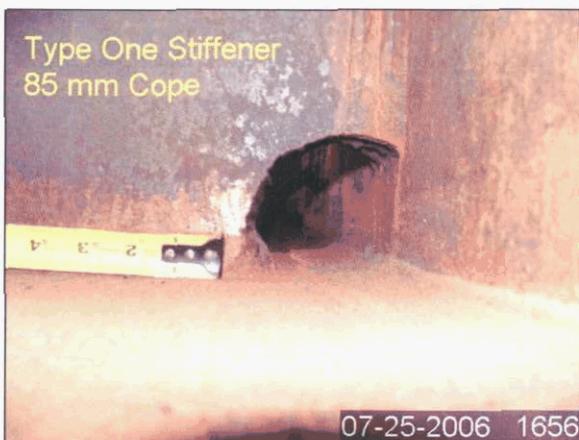
Bridge No.: #34-0006L/R

Component: #Type I and II stiffeners:

Per Diaphragm Plate P61-2: P292-19 and P292-20
Per Diaphragm Plate P91-1/P96-1: P291-2, P291-4,
P291-6, P291-8, P291-10, P253-1, P253-3, P253-5,
P253-7, P253-9, P253-11, P253-13, and P253-15.

Procedural: [X] Procedural: []

Description of Non-Conformance: KOS Quality Control (QC) Inspectors have allowed the production teams to modify weld access openings ("snipes") on fifteen (15) multiple type one and type two stiffener plates joining diaphragm plates P61-2, P96-1 and P91-1 without prior approval. The snipes were modified into cope holes with radii varying from approximately 60 mm to 85 mm. Below are digital photographs illustrating the above discrepancy.



RECEIVED
004590 JUL 28 09

Applicable reference: Approved Shop Drawings for Type 1 and Type 2 stiffeners on sheets S272, S281 and S253 Revision 2.

Who discovered the problem: Caltrans Quality Assurance Inspector Gregory Bertlesman

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

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Time and method of notification: Verbal with Mr. Barnhill at 1000 on 07-26-2006.

Name of Caltrans Engineer notified: Mark Vilcheck, Structural Representative

Time and method of notification: July 28, 2006, 11:35 via telephone conversation

QC Inspector's Name: Mr. George Barnhill, Mr. Ronald Deets, Mr. Eloy Gonzales & Mr. James Creech

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: Unknown

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: Gregory Bertlesman

Quality Assurance Inspector

Reviewed By: Robert Cuellar

Lead QA Inspector

RECEIVED
004590 JUL 28 2006

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. Lee Zink
Project Director

February 7, 2007

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

Letter No. 05.003.01-002790

Subject: Response to Submittal No. 1104, Revision No. 00 (KOS Response to METS NCR 109)

Dear Lee,

The Department has reviewed Kiewit-FCI-Manson (KFM) Submittal No. 1104, Revision No. 00, dated November 20, 2006, which responded to the Department's Non-conformance Report (NCR) No. 109. The Department's Letter No. 1628, dated July 31, 2006, notified KFM of the NCR for Kiewit Offshore Services (KOS) dated July 25, 2006. The Department hereby approves Submittal No. 1104, Revision No. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for KOS dated July 25, 2006, is considered to be resolved.

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
J. Duxbury

file: 05.003.01, 09.006.03, 55.1104

Memorandum

*Flex your power!
Be energy efficient!*

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

COMPLETED

Date: January 19, 2007
File: 04-0120E4
E2/T1 Foundations

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

KFM SUBMITTAL 1104-00 –KIEWIT OFFSHORE SERVICES (KOS) RESPONSE TO NONCONFORMANCE REPORTS 109

The Office of Structural Materials (OSM) has reviewed the KFM Submittal 1104-00, dated November 20, 2006. In this submittal the Contractor is requesting to close the METS Nonconformance Report (NCR) 109, regarding the Fabricator's modification of the weld access areas on multiple Type I and Type II stiffeners in the T1 footing box.

As stated in the Contractor's response to the NCR 109, dated November 15, 2006, the Department approved the Contractor's request to increase the size of the weld access area from a 50mm "sniped" edge to a coped hole not to exceed 65mm in radius (KFM-RFI-313) on October 18, 2006. As indicated on the sketch provided in KFM Submittal 1104-00, the Contractor cut 19 weld access areas (7 x P253 and 6 x P291 in Area A, 2 x P281 and 2 x P271 in Area C, 1 x P271 and 2 x P270 in Area G) larger than the specified 60mm radius. METS personnel have verified that the weld access areas on the 19 stiffener plates referenced above were cut between 70-98mm in radius. The Contractor is requesting for the Department to accept these areas in their existing condition and close the NCR.

Since the Contractor has completed the cutting of the weld access areas in the Type I/II stiffeners, METS takes no exception to the Contractor's request to leave the 19 weld access areas in their existing condition provided that the Design Team verifies the loss in the length of weld does not adversely affect the performance of the affected 19 Type I/II stiffeners. If the Design Team also takes no exception, METS considers NCR 109 to be closed.

Mark Vilcheck
January 19, 2007
Page 2

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. Lee Zink
Project Director



October 18, 2006

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

Letter No. 05.003.01-002111

Distribution:

- Phil Sechler
- Mike Brown
- Mayra Zuniga
- George Barnhill
- John Berggren-KFM
- Brenda Porter
- Michael Schaferman

Subject: Response to RFI No. 313, Revision No. 00 (KOS RFI-070 Top Stiffener Copes over 65mm)

Dear Lee,

RFI No. 313, Revision No. 00, pertains to the Contractor's request to accept previously cut top stiffener copes greater than 65mm in radius at the Pier T1 footing. Regarding this RFI, the Department takes no exception to the 19 enlarged copes, which range from 70mm to 98mm in radius, at the stiffener locations referenced in this RFI. Please note that the Department's Letter No. 1668 accepts Contractor's proposal to enlarge stiffener copes to a radius of 60mm and not 65 mm as stated in this RFI. The Contractor shall identify and report stiffeners for which the copes are larger than 60mm. In addition, the Contractor shall implement corrective actions in the fabrication procedure such that no cope with radius larger than 60mm will be cut.

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

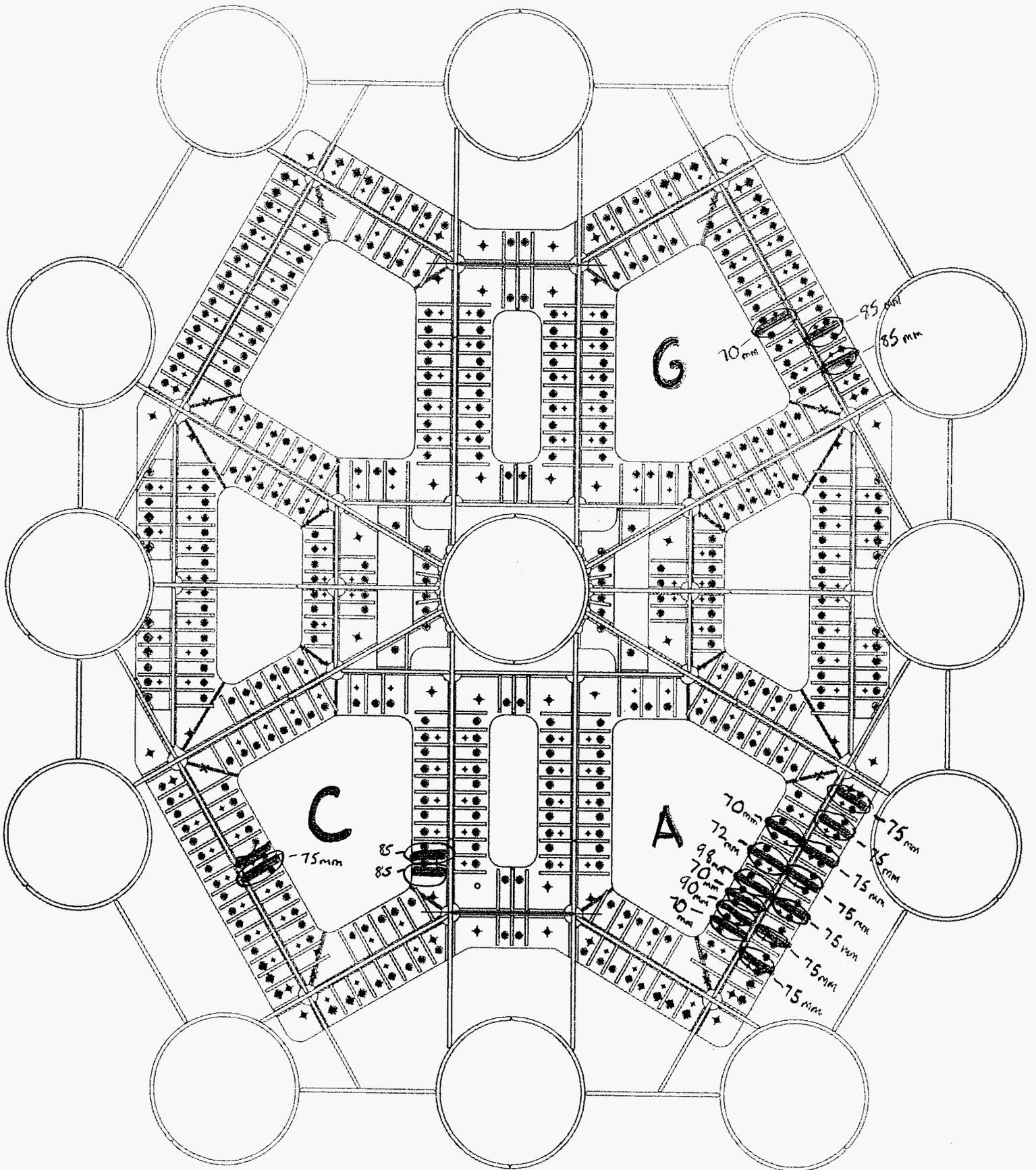
SAS FOUNDATIONS E2/T1 PROJECT	
KIEWIT / FCI / MANSON, A JV	
DATE: 10/18/06	CO/JOB: 364-4347
ROUTED BY: SBY	NO: 04-0120E4
TO: G. ATKINSON	SPECIAL NOTES:
INTERNAL KFM COPIES TO:	
EXTERNAL COPIES TO:	
SCANNED: (Y) N	FILED TO: RFI 313

cc: P. Sanchez
M. Woods
J. Duxbury

file: 05.003.01, 56.313

21103CN-0592

10p Stiffener Lapes > 65 mm



Kiewit Offshore Services, Ltd.

REQUEST FOR INFORMATION

No. 070

2440 Kiewit Road
Ingleside, Texas 78362

Phone: (361)-775-4300

TITLE: Stiffener Copes >65mm

DATE: 9/28/2006

PROJECT: T1 Tower Footing

JOB: 21103

TO: Attn: George Atkinson
Kiewit/FCI/Manson
220 Burma Road
Oakland, CA 94607
Phone: 510-627-1000

WORK STARTED:
WORK COMPLETED:
ANSWER REQUIRED: 10/5/2006
ANSWER RECEIVED:

Fax: 510-832-1456

REQUEST:

KOS is requesting approval for previously cut top stiffener copes greater than 65mm. This includes all the copes to date that were enlarged for welding access. KOS is no longer cutting copes greater than 65mm. Is this acceptable? See attached sheet for location and size of copes.

Requested By: Kiewit Offshore Services, Ltd.

Signed:  **Date:** 9/28/06
Mike Brown

ANSWER:

State letter
05.003.01-002111

Answered By: Kiewit/FCI/Manson

Date: _____

Signed: _____
George Atkinson

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

Time and method of notification: Verbal with Mr. Barnhill at 1000 on 07-26-2006.

Name of Caltrans Engineer notified: Mark Vilcheck, Structural Representative

Time and method of notification: July 28, 2006, 11:35 via telephone conversation

QC Inspector's Name: Mr. George Barnhill, Mr. Ronald Deets, Mr. Eloy Gonzales & Mr. James Creech

Was the QC Inspector aware of problem: Yes

Contractor's proposal to correct the problem: Unknown

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: Gregory Bertlesman

Quality Assurance Inspector

Reviewed By: Robert Cuellar

Lead QA Inspector

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: Ingleside, Texas

Date: 7-25-06

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

NCR #109

Submitting Contractor: Kiewit Offshore Services (KOS)

Type of problem:
Welding **Concrete** **Other**
Welding: **Curing:** **Procedural:**
Joint fit-up: **Coating:** **Other:**

Bridge No.: #34-0006L/R

Component: #Type I and II stiffeners:

Per Diaphragm Plate P61-2: P292-19 and P292-20

Per Diaphragm Plate P91-1/P96-1: P291-2, P291-4,

P291-6, P291-8, P291-10, P253-1, P253-3, P253-5,

P253-7, P253-9, P253-11, P253-13, and P253-15.

Procedural: Procedural:

Description of Non-Conformance: KOS Quality Control (QC) Inspectors have allowed the production teams to modify weld access openings (“snipes”) on fifteen (15) multiple type one and type two stiffener plates joining diaphragm plates P61-2, P96-1 and P91-1 without prior approval. The snipes were modified into cope holes with radii varying from approximately 60 mm to 85 mm. Below are digital photographs illustrating the above discrepancy.



Applicable reference: Approved Shop Drawings for Type 1 and Type 2 stiffeners on sheets S272, S281 and S253 Revision 2.

Who discovered the problem: Caltrans Quality Assurance Inspector Gregory Bertlesman

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



Kiewit

Chris Webb
QCM KFM JV.
Oakland, CA

Date: 11/15/2006

Subject: Response to NCR #109

Chris:

Caltrans NCR #109 stated that KOS Quality Control (QC) Inspectors have allowed the production teams to modify weld access openings ("snipes") on fifteen multiple type one and type two stiffener plates joining diaphragm plates P61-2 and P91-1 without prior approval. The snipes were modified into cope holes with radii varying from approximately 60mm to 85mm.

KOS wrote Request For Information # 070 (KFM #313) on 9/28/2006, requesting approval for previously cut top stiffeners copes greater than 65mm. This includes all the copes to date that were enlarged for welding access. ~~KOS is no longer cutting copes greater than 65mm. Is this acceptable? See attached sheet for location and size of copes.~~

The State responded to the RFI on 10/18/2006 stating RFI No. 313 (KOS RFI #070) Revision No. 00, pertains to the Contractor's request to accept previously cut top stiffener copes greater than 65mm in radius at the Pier T1 footing. Regarding this RFI, the Department takes no exception to the 19 enlarged copes, which range from 70mm to 98mm in radius, at the stiffener locations referenced in this RFI. Please note that the Department's Letter No. 1668 accepts Contractor's proposal to enlarge stiffener copes to a radius of 60mm and not 65mm as stated in this RFI. The Contractor shall identify and report stiffeners for which the copes are larger than 60mm. In addition, the Contractor shall implement corrective actions in the fabrication procedure such that no cope with a radius larger than 60mm will be cut.

KOS has implement corrective action to the fabrication procedure to insure the no addition copes larger than 60mm will be cut without prior approval from the Engineer.

KOS is requesting the State to close this NCR. *the 109 based on KOS RFI 070 and state letter*

Regards, *number 2111.*

George Barnhill
George Barnhill
QCM KOS
Ingleside, TX

Cc: Scott Cheney, Mike Brown

with state letter number 2111.

Caltrans takes no exception to the enlarged copes. In addition state letter 2111 the state also requests



Kiewit

November 15, 2006

Chris Webb
QCM KFM JV.
Oakland, CA

Subject: Response to NCR #109

Chris:

Caltrans NCR #109 stated that KOS Quality Control (QC) Inspectors have allowed the production teams to modify weld access openings ("snipes") on fifteen multiple type one and type two stiffener plates joining diaphragm plates P61-2 and P91-1 without prior approval. The snipes were modified into cope holes with radii varying from approximately 60mm to 85mm.

KOS wrote a Request for Information #070 (KFM #313) on September 28, 2006, requesting approval for previously cut top stiffeners copes greater than 65mm. This includes all the copes to date that were enlarged for welding access.

The State responded to the RFI on October 18, 2006, with State Letter 2111. Caltrans takes no exception to the enlarged copes. In addition, the State also requests the contractor implement corrective actions in the fabrication procedure that no cope with a radius longer than 60mm will be cut.

KOS has implemented corrective action to the fabrication procedure to insure the no addition copes larger than 60mm will be cut without prior approval from the Engineer.

KOS is requesting the State to close NCR #109 based on KOS RFI #070 and State Letter 2111.

Regards,

George Barnhill
QCM KOS
Ingleside, TX

cc: Scott Cheney
Mike Brown



Kiewit

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

TRANSMITTAL

No. 00609

Kiewit Offshore Services, Ltd.

KOS Job: 21103

PROJECT: T1 Tower Footing
Kiewit/FCI/Manson

REF: Response to NCR#109

ATTN: Chris Webb

DATE: 11/15/2006

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	SENT VIA:	<input type="checkbox"/> Returned
<input type="checkbox"/> Specifications	<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
-------------	------	--------	------	-------------

	4		11/15/2006	Response to NCR #109
--	---	--	------------	----------------------

Remarks:

Signed: 
George Barkhill



P.O. BOX 23223 Oakland, CA 94623
 Phone (510) 419-0120 / Fax (510) 832-1456

LETTER OF SUBMITTAL
SAS Foundations E2/T1 Project

Run Date 20-Nov-06
 Time 1:11 PM

Dated: 20-Nov-2006

SUBMITTAL No: KFM-SUB-001104

Rev: 00

To: **Pedro Sanchez**
 Caltrans - SAS E2/T1 Foundation Project
 333 Burma Road
 Oakland CA 94607
 Phone: 510-286-0538 Fax:

Co/Job # 364-4347
 Contract # 04-0120E4
 Sub/Supplier: KOS
 Sub/Supplier No: 609

Subject: KOS Response to METS NCR 109

Special Provis. (SP) REF: 08-3.01

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 checked="" type="checkbox"/> WQCP and/or Addenda |
| <input checked="" 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	15-Nov-06	1	NCR Response		0	Pending	8

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 : 27-Nov-2006

Submitted By: Chris Webb
 (KFM Staff Member - Originator of Transmittal)

Checked & Sent By: 
 Contract Admin/DCS Staff