

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 **8.3**
 File # **20 .25 B 83**

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: **Napa Ca.**Date: **01/21/06**Prime Contractor: **Kiewit, FCI, Manson, (KFM) Joint Venture**

NCR #39

Submitting Contractor: **Trans Bay Steel****Type of problem:**

Welding **Concrete** **Other**
Welding: **Curing:** **Procedural:** **Bridge No.:** #34-0006
Joint fit-up: **Coating:** **Other:** **Component:** # Cast in Steel Shell Casings:
Procedural: **Procedural:** Welding was being performed by an unqualified welder

Description of Non-Conformance: Caltrans Quality Assurance Inspector (QA) Roscoe Dixon observed an unqualified welder Mark Dennis Pacheco, performing welding of grout beads on the inside diameter (ID) of the cast in steel shell casing piece mark S133. The QA inspector informed the Quality Control Inspector (QC) Scott Martel, that the welding operator was not on the current list of qualified welders, The QC inspector then asked the QA inspector if this was a request to stop welding. The QAI Inspector's reply was that the intent was to inform the QC Inspector that the welding not being done in conformance with the Special Provisions of the contract and D1.1 2002. Mr. William Kavicky arrived at the workstation and stated that he did not see anything wrong with the welding being performed as long as the qualified welder Carlos Perez who was observing the operation did not leave the area. Mr. Kavicky also requested that a statement about the quality of the welds be included in this report. The three welds placed by Mr. Pacheco were measured and meet the required minimum height and width of 12mm X 18mm, and appear to meet the weld quality requirements per the contract drawings. The work is still in progress, and neither the QC inspector, nor the QA Inspector have accepted these welds of this date. D1.1-2002 Section 4.1.2 Performance Qualification of Welding Personnel. Welders, welding operators and tack welders to be employed under this code, and using the shielded arc welding (SMAW), submerged arc welding (SAW), gas metal arc welding (GMAW), gas tungsten arc welding (GTAW), flux cored arc welding (FCAW), electroslag welding (ESW), or electrogas welding (EGW) processes, shall have been qualified by the applicable tests as described in Part C of this section

Applicable reference: Contract Special Provisions Sec. 8-3 Welding Quality Control Sec. H. D1.1 Sec.4.1.2**Who discovered the problem:** QA**Name of individual from Contractor notified:** William Kavicky, President of Trans Bay Steel**Time and method of notification:** 01/21/06 1100 hours**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative**Time and method of notification:** 01/23/06, via a telephone conversation with the SMR**QC Inspector's Name:** Scott Martel**Was the QC Inspector aware of problem:** YES**Contractor's proposal to correct the problem:** None at this time

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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: Roscoe Dixon *Roscoe Dixon* Quality Assurance Inspector

Reviewed By: Mahlon Lindenmuth *Mahlon Lindenmuth* Lead QA Inspector

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES
MATERIALS ENGINEERING AND TESTING SERVICES

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Contract #: **04-0120E4**
City **SF** Rte **80** PM **8.3**
File # **20 .25 B 83**

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: **Napa Ca.**

Date: **01/21/06**

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

NCR #39

Submitting Contractor: **Trans Bay Steel**

Type of problem:

Welding <input checked="" type="checkbox"/>	Concrete <input type="checkbox"/>	Other <input type="checkbox"/>	
Welding: <input type="checkbox"/>	Curing: <input type="checkbox"/>	Procedural: <input type="checkbox"/>	Bridge No.: #34-0006
Joint fit-up: <input type="checkbox"/>	Coating: <input type="checkbox"/>	Other: <input type="checkbox"/>	Component: # Cast in Steel Shell Casings:
Procedural: <input checked="" type="checkbox"/>	Procedural: <input type="checkbox"/>	<u>Welding was being performed by an unqualified welder</u>	

Description of Non-Conformance: Caltrans Quality Assurance Inspector (QA) Roscoe Dixon observed an unqualified welder Mark Dennis Pacheco, performing welding of grout beads on the inside diameter (ID) of the cast in steel shell casing piece mark S133. The QA inspector informed the Quality Control Inspector (QC) Scott Martel, that the welding operator was not on the current list of qualified welders, The QC inspector then asked the QA inspector if this was a request to stop welding. The QAI Inspector's reply was that the intent was to inform the QC Inspector that the welding not being done in conformance with the Special Provisions of the contract and D1.1 2002. Mr. William Kavicky arrived at the workstation and stated that he did not see anything wrong with the welding being performed as long as the qualified welder Carlos Perez who was observing the operation did not leave the area. Mr. Kavicky also requested that a statement about the quality of the welds be included in this report. The three welds placed by Mr. Pacheco were measured and meet the required minimum height and width of 12mm X 18mm, and appear to meet the weld quality requirements per the contract drawings. The work is still in progress, and neither the QC inspector, nor the QA Inspector have accepted these welds of this date. D1.1-2002 Section 4.1.2 Performance Qualification of Welding Personnel. Welders, welding operators and tack welders to be employed under this code, and using the shielded arc welding (SMAW), submerged arc welding (SAW), gas metal arc welding (GMAW), gas tungsten arc welding (GTAW), flux cored arc welding (FCAW), electroslag welding (ESW), or electrogas welding (EGW) processes, shall have been qualified by the applicable tests as described in Part C of this section

Applicable reference: Contract Special Provisions Sec. 8-3 Welding Quality Control Sec. H. D1.1 Sec.4.1.2

Who discovered the problem: QA

Name of individual from Contractor notified: William Kavicky, President of Trans Bay Steel

Time and method of notification: 01/21/06 1100 hours

Name of Caltrans Engineer notified: Mark Vilcheck, Structure Representative

Time and method of notification: 01/23/06, via a telephone conversation with the SMR

QC Inspector's Name: Scott Martel

Was the QC Inspector aware of problem: YES

Contractor's proposal to correct the problem: None at this time

002924 JAN 27 06 RECEIVED

QUALITY ASSURANCE - NONCONFORMANCE REPORT

(Continued, Page 2 of 2)

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: Roscoe Dixon

Quality Assurance Inspector

Reviewed By: Mahlon Lindenmuth

Lead QA Inspector

RECEIVED
002924 JAN 27 8

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

April 3, 2007

Attn: Mr. Kevin Carpenter
Welding Quality Control Manager

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

Letter No. 05.003.01-003018

Subject: Closing of Resolved Piling Fabrication NCRs

Dear Kevin,

Two non-conformances related to fabrication of piling for Pier T1 and Pier E2 are listed below, including their status.

- NCR dated January 21, 2006 (Unqualified Welder Performing Grout Beads): Kiewit-FCI-Manson (KFM) Submittal 932, Revision No. 00, which provided the welder qualifications, is hereby approved. As there is no further fabrication work on piling to be performed, future non-conformances of this nature are no longer a concern. This NCR is considered to be resolved.
- NCR dated April 8, 2006 (Unapproved QC Technician Performing MT): KFM Submittal No. 589, Revision No. 01, which provided the certifying authority of 3D UT, was "approved-as-noted" by the Department's Letter No. 1607, dated July 27, 2006. This NCR 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

file: 05.003.01, 09.006.03, 55.0589, 55.0932

Memorandum

*Flex your power!
Be energy efficient!*

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

Date: November 8, 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 FOR TRANS BAY STEEL (TBS) RESPONSE TO NCRs

The Materials Engineering and Testing Service (METS) has reviewed the following submittals requesting to close Nonconformance Reports (NCRs) regarding the fabrication of the E2 and T1 Steel Piling in Napa, CA. Please find the following comments regarding NCRs:

Submittal Number	Date Submitted	Description	Approved/Rejected	Notes
932-00	09/27/06	TBS Response to NCR 039	Rejected	1
933-00	09/27/06	TBS Response to NCR 006	Approved	2
934-00	09/27/06	TBS Response to NCR 003	Approved	3
992-00	10/17/06	TBS Response to NCR 110	Approved	4
983-00	10/16/06	TBS Response to NCR 108	Rejected	5
984-00	10/16/06	TBS Response to NCR 111	Approved	6
985-00	10/14/06	TBS Response to NCR 054	Approved	7
987-00	10/16/06	TBS Response to NCR 095	Approved	8

Notes:

1. The Department issued NCR 039 on January 1, 2006, in order to document the Contractor's use of an unapproved welder working under supervision on

the steel piling for the E2/T1 Foundations Project. Although, the welder has since qualified in accordance with the contract Special Provisions (March 8, 2006) and the Contractor has provided the NDT reports for the grout beads deposited by the unapproved welder; the issue of using welders who have not passed the required qualification testing still stands without recourse by the Contractor.

After numerous meetings between the Contractor and the Department regarding this issue, including involvement from the Fabrication, Action, and Solution Team (FAST), OSM understands that Contract Change Order (CCO) 039 has been drafted to address the use of a welder training program at TBS. OSM also understands that this CCO is still being negotiated with the Contractor as of the date of this memorandum. Thus, it is OSM's recommendation that this NCR remain open until the Department and the Contractor can come to an agreement regarding CCO 039. Should the CCO be agreed to by both parties, OSM recommends the closure of this NCR, and others documenting the same issue, be readdressed for closure. OSM will consider this issue to remain open until that time.

2. The Department issued NCR 006 on November 18, 2004, in order to document the Contractor's use of an unapproved welder attaching run-off tabs on pile section T-2. In accordance with the TBS letter dated September 22, 2006, the Nondestructive Testing Reports for the girth seams of this pile section appear to show the welds to be clear of rejectable indications in the areas where the runoff tabs were welded. Additionally, METS understands that the Contractor has not had systemic problems with allowing unqualified welders to perform welds on temporary members. METS considers this NCR to be resolved at this time.
3. METS takes no exception to the Contractor's response to State Letter 05.003.01-000890 (NCR 003) as the welder's continuity for the Flux Core Welding process (FCAW) was verified in the letter from TBS dated March 1, 2006 and approved in KFM Submittal 162-02.
4. The Department issued NCR 110 on August 9, 2006 in order to document Submerged Arc Welding (SAW) being performed without sufficient preheat on the long seam of pile can section D11. The welding being performed was also the production qualification for the welding operator involved. In accordance with the TBS letter dated October 16, 2006, the welders continue

to receive training regarding the use of proper preheat before welding the steel piling. As of the date of this memorandum, METS understands that the Contractor has addressed the issue as no recent issues have been documented regarding improper preheat.

Additionally, the Contractor mechanically tested the runoff tabs (which were extended in length per the agreement between the Department and the Contractor to allow production qualification testing to include mechanical testing requirement in the Special Provisions) which provided additional information to validate the soundness of the weld. METS considers this NCR to be resolved at this time; however, the Contractor should be advised that welders or welding operators who fail a production qualification test shall be retested in accordance with AWS D1.1-2002, Section 4.32.

5. The Department issued NCR 108 on July 24, 2006 in order to document the Contractor's use of an unapproved welder using Shielded Metal Arc Welding (SMAW) without an approved WPS on the backing ring of the stabbing guide on pile E2-8T. Although the SMAW welder was approved by the Department on September 25, 2006, contrary to the statements made in the TBS letter dated October 10, 2006, the WPS P-318-B-U4a 45mm was not submitted or approved on May 8, 2006. The Department initially received this WPS on July 31, 2006 as KFM Submittal 763-00 (TBS WQCP Addendum 48) and was rejected by State Letter 05.003.01-002047 on October 4, 2006. The same WPS was resubmitted as KFM Submittal 982-00 (TBS WQCP Addendum 032) on October 16, 2006 and was rejected by the Department as it was identical to Submittal 763-00. METS will consider this NCR resolved when WPS P-318-B-U4a 45mm has been resubmitted and is approved by the Department.
6. The Department issued NCR 111 on August 14, 2006 in order to document an NDT technician's failure to record rejectable indications. In accordance with the final nondestructive testing reports, the girth seam weld GS-18 on Pile E216T was reexamined by an approved Ultrasonic Testing (UT) Technician with an approved UT procedure. The documentation for this reexamination has been verified by METS in the Certificate of Compliance for the E2-16T. Additionally, TBS has indicated (both verbally and through the letter dated July 21, 2006 and October 16, 2006) they have counseled Mr. Berchel White regarding the proper methods for performing UT inspection on the long seam and girth seams of the piles. METS understands that Mr. White will no

longer work on the long seams and considers this NCR to be closed at this time. However, METS reserves the right to readdress this issue should Mr. White has similar issues in the future.

7. The Department issued NCR 054 on August 14, 2006 in order to document an NDT technician's failure to record rejectable indications on girth seam GS-8 of Pile E2-7T. In accordance with the final nondestructive testing reports, the girth seam weld was reexamined by an different Ultrasonic Testing (UT) Technician. The documentation for this reexamination has been verified by METS in the Certificate of Compliance for the E2-7T.

Additionally, TBS has indicated in their letter dated October 10, 2006 they have counseled Mr. Steve Pacheco about this issue and METS agrees that no further issues have occurred regarding this technician. METS considers this NCR to be resolved at this time.

8. The Department issued NCR 095 on June 5, 2006, in order to document a welder who was welding out of position on the girth seam joint pile can sections D-11 to E-11. As stated by the TBS letter dated October 10, 2006, welding in the overhead position is not a part of the production plan and this instance should be an isolated occurrence. TBS also notified their welding personnel of this issue and METS agrees that this has not become a systemic issue. METS considers this NCR to be resolved at this time; however, METS reserves the right to readdress this issue should it become a problem again in the future.

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

cc: Rafael Bolon
Tom Shimada
Jim Cochran



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 27-Sep-06
 Time 2:13 PM

Dated: 27-Sep-2006

SUBMITTAL No: KFM-SUB-000932

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: TBS
 Sub/Supplier No:

Subject: Trans Bay Steel Response to NCR Generated by State Letter 767

Special Provis. (SP) REF: 08-3.01

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	22-Sep-06	1	TBS NCR Response		0	Pending	9

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 : 04-Oct-2006

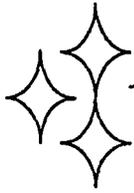
Submitted By: **Chris Webb**

(KFM Staff Member – Originator of Transmittal)

Checked & Sent By:

SBunter

Contract Admin/DCS Staff



TRANS BAY STEEL, CORP.

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

Date September 22, 2006

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

Reference: SAS Foundation E2-T1 Contract #
Subject: NCR-7 (Caltrans Letter 767 of 2-6-06) Close Out

Attn: Chris Webb

Please request that the Engineer issue a letter to close NCR-7 in light of the following measures taken and or events which have occurred:

Trans Bay Steel submitted welding operator qualifications for Mr. Pacheco on KFM-SUB-358 Rev 1 to which the State responded on Caltrans Letter 929 on 3-21-06 approving his qualification.

Our success in avoiding events of a similar nature is now a matter of record.

William M. Kavicky.
Trans Bay Steel Corp.

Cc:

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. Chris Webb

February 6, 2006

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

Letter No. 05.003.01-000767

Subject: NCR - Trans Bay Steel, 01/21/06 (Unqualified Welder Performing Grout Beads)

Dear Christopher,

The Department issued a Non-conformance Report (NCR) at Trans Bay Steel, Inc., on January 21, 2006. The NCR was generated when QA observed an unqualified welder, Mr. Mark Dennis Pacheco, performing welding of grout beads on the inside diameter of pile section S133. QA notified the QC inspector, Mr. Scott Martel, of this non-conformance.

This NCR is considered to be outstanding. Please describe what measures the contractor will take to resolve this NCR and to avoid the use of unqualified welders in future production work.

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: 2/6/06	CO/JOB: 364-4347
ROUTED BY: SBH	NO: 04-0120E4
TO:	SPECIAL NOTES:
INTERNAL KFM COPIES TO:	
EXTERNAL COPIES TO:	
SCANNED (Y) N	FILED TO: C+ Letter 767

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03

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

March 21, 2006

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

Letter No. 05.003.01-000929

Subject: Response to Submittal No. 358, Revision No. 01 (Trans Bay Steel WQCP Addendum 23 – Addition of Welders)

Dear Christopher,

The Department has reviewed KFM Submittal No. 358, Revision No. 01, dated March 9, 2006, which provided six (6) additional welding operators (SAW) certifications, and three (3) additional welders (FCAW) certifications for inclusion in the WQCP of the Trans Bay Steel Corp. (TBS). The Department hereby approves Submittal No. 358, Revision No. 01, pursuant to Section 8-3.01, "Welding," of the Special Provisions. An approved stamped copy of the WQTRs for the following individuals is attached:

Submerged Arc Welding Operators	
Welder ID No.	Welder Name
8040	Mr. Brian Peterson
0736	Mr. Raul Petergrina
2773	Mr. Mark Pacheco
7445	Mr. Eulalio Hernandez
9036	Mr. Suphan Baukham
9030	Mr. Sathapom Pornsririsak
Flux Cored Arc Welders	
Welder ID No.	Welder Name
3666	Mr. William McHaney
6995	Mr. William Nichols
0141	Mr. William Rodriguez

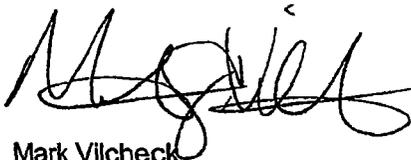
SAS FOUNDATIONS E2/T1 PROJECT KIEWIT / FCI / MANSON, A JV	
DATE	3/21/06
CO/JOB: 364-4347	
ROUTED BY	SBV
NO: 04-0120E4	
TO: C. Webb	SPECIAL NOTES:
INTERNAL KFM COPIES TO:	
EXTERNAL COPIES TO:	
SCANNED	Y/N FILED TO: SUB 358 R1

Letter No. 05.003.01-000929
Kiewit-FCI-Manson
Page 2 of 2

In addition, the documentation submitted for FCAW welder Mr. John Motto-Ross is acceptable. Mr. Motto-Ross is hereby approved to perform FCAW in all positions except overhead.

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

Attachment: Approved TBS Weider Certifications (22 pages)

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.002.05, 55.358



TRANS BAY STEEL, CORP.

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

Rec'd
3/8/06
gaw

March 8, 2006

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

Reference: E2/T1 Foundations # 04-0120E4

Subject: Addendum #25 to the WQCP E2 T1 Piling

Attn: Chris Webb

The following Welders are being re-submitted for your review and approval.

SAW Welders

1. Brian Petersen 8040
2. Raul Peregrina 0736
3. Mark Pacheco 2773
4. Eulalio Hernandez 7445
5. Suphan Baukham 9036
6. Sathaporn Pornsririrak 9030

FCAW Welders

1. William Mchaney 3666
2. Willaim Nichols 6995
3. Willaim Rodriguez 0141

<input checked="" type="checkbox"/>	APPROVED
<input type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	NOT APPROVED
Pursuant to Section 5-1.02 of the Standard Specifications State of California DEPARTMENT OF TRANSPORTATION Division of Structures Office of Structure Construction	
Signed	<i>[Signature]</i>
	Structure Representative
	MAR 21 2006
Date	

This is the response to State Letter 000876 with the following bullet points.

1. The certifications were tested using a FCM procedure and the welders will be submitted at a later date with the bend results for fracture critical work. However this particular submittal is for D1.5 only qualifies the welders by RT and allows them to work on a D1.1 and D1.5 project. Sorry for the confusion.
2. The certifications now reflect single and multiple electrodes as stated in the WPS.
3. Better copies of the RT reports are now submitted.
4. The RT report for S. Pornsririrak has been corrected.

WELDER AND WELDING OPERATOR QUALIFICATION RECORD

Welder or welding operator's name Mark Pacheco Identification no. 2773
 Welding process SAW Manual _____ Semiautomatic _____ Machine X
 Position IG Single Wire X Multiple Wire X

In accordance with procedure specification no. A-146 SAW (FCM)
 Material specification A-709 Gr.HPS 70W
 Thickness 25mm Thickness range this qualifies Unlimited

FILLER METAL

Specification no. AWS A5.23-97 Classification F9A4-ENi5-G-H2 Flux MIL800-HPNi
 Describe filler metal (if not covered by AWS specification) _____

Is backing used? YES
 Filler metal diameter and trade name 4mm Flux for submerged arc or gas for gas metal arc or flux
Lincolnweld LA-85 cored arc welding Lincolnweld MIL800-HPNi Flux

VISUAL INSPECTION (9.21.1)

Appearance Good Undercut None Piping porosity None
 Test Witnessed by: John Page, TBS/CWI
 Test Witnessed by: Bill West Caltrans Lot# B40-003-06

Guided Bend Test Results

Type	Result	Type	Result

Test conducted by _____ Laboratory test no. _____
 per _____ Test date APPROVED
 Test Witnessed by: _____ Filler Test Results APPROVED AS NOTED
 Appearance _____ Fillet size NOT APPROVED
 Fracture test root penetration _____ Macroetch _____
 Test conducted by _____ Pursuant to Section 5-1.02
 per _____ Laboratory test no. _____
 of the Standard Specifications

RADIOGRAPHIC TEST RESULTS

Film Identification	Results	Remarks	Film Identification	Results	Remarks
<u>2773</u>	<u>Acceptable</u>		<u>2773</u>	<u>Acceptable</u>	
<u>M. Pacheco</u>					

Test witnessed by Caltrans Lot# B40 Date MAR 21 2006
 per AWS D1.5-96 (FCM)

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 ANSI/MSHTO/AWS D1.5, (1996) Bridge Welding Code.
 (year)

Trans Bay Steel Corporation
 1025 Kaber Road
 Napa, Ca. 94558

Manufacturer or Contractor Trans Bay Steel Corp.
 Authorized By [Signature]
 Date 1/20/06

T. C. INSPECTION, INC.

124 Parker Avenue
 Redwood City, CA 94061
 Office: (650) 799-0305
 Fax: (650) 245-1728

DATE: 1-20-06
 TEL. NO.: 11806-01
 CUSTOMER: CWI / Transbay Street
 ADDRESS: 1025 Kaiser Rd.
Walpa CA 94538

LOCATION: Walpa CA
 JOB NUMBER: 04-012024
 ITEM DESCRIPTION: Welded Oval / Machine Area

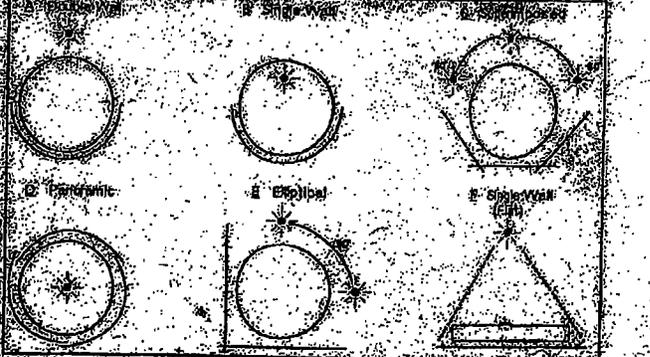
CUSTOMER'S P.O. # _____
 INSPECTION TYPE: _____

AMOUNT: _____
 DATE OF INSPECTION: _____
 INSPECTOR: _____

INSPECTION METHOD: _____
 REFERENCE: _____

WELDING PROCEDURE: _____
 WELDING POSITION: _____

WELDING MATERIAL: _____
 GEOMETRIC UNIFORMITY: _____
 NO. OF FILM PER CROSS SECTION: _____
 VIEWING (Spot): _____
 MAGNIFICATION: _____
 DEVELOPER: _____



SEAMING NO. MEAS.	WELD NO.	PLANO.	POS.	REF.	DATE	COMMENTS
101	01	1	1			E. Hex. Machine Area
102						
103						
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DEFECTS:
 A - Cracks
 B - Surface
 C - Cracks
 D - Surface
 E - Cracks
 F - Surface
 G - Cracks
 H - Surface
 I - Cracks
 J - Surface
 K - Cracks
 L - Surface
 M - Cracks
 N - Surface
 O - Cracks
 P - Surface
 Q - Cracks
 R - Surface
 S - Cracks
 T - Surface
 U - Cracks
 V - Surface
 W - Cracks
 X - Surface
 Y - Cracks
 Z - Surface

Inspector: Clark Rayburn
 Date: 1-20-06

REPORT: T. C. Inspection, Inc. assumes no responsibility for errors or omissions in this report. Small errors are the responsibility of the customer.



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 09-Mar-06
 Time 1:54 PM

Dated: 09-Mar-2006
 To: Pedro Sanchez
 Caltrans - SAS E2/T1 Foundation Project
 333 Burma Road
 Oakland CA 94607
 Phone: 510-286-0538 Fax:

SUBMITTAL No: KFM-SUB-000358 Rev: 01
 Co/Job # 364-4347
 Contract # 04-0120E4
 Sub/Supplier: TBS
 Sub/Supplier No:

Subject: Trans Bay Steel WQCP Addendum 23 - Addition of Welders

Special Provis. (SP) REF: 08-3.01
 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	08-Mar-06	1	TBS Welder Qualifications -- Response to SL-876		0	Pending	

These are transmitted as checked below:

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

Remarks:

Attached re-submittal addresses concerns raised in SL-876.

CC:

Please review / approve by : 16-Mar-2006

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

Checked & Sent By:
 Contract Admin/DCS Staff