

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 # 20.25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: **Trans Bay Steel (TBS) - 1025 Kaiser Road Napa, CA**Date: **Tues. 05/09/2006**Prime Contractor: **Kiewit, FCI, Manson, (KFM) Joint Venture**NCR # **085**Submitting Contractor: **Trans Bay Steel (TBS)****Type of problem:**

| | | | | | | |
|----------------------|-------------------------------------|--------------------|--------------------------|--------------------|--------------------------|---|
| Welding | <input checked="" type="checkbox"/> | Concrete | <input type="checkbox"/> | Other | <input type="checkbox"/> | |
| Welding: | <input checked="" 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: E2 Permanent Steel Casing |
| Procedural: | <input checked="" type="checkbox"/> | Procedural: | <input type="checkbox"/> | | | |

Description of Non-Conformance: 1. TBS Quality Control allowed the in process welding of the inside diameter girth seam between pile segments designated E-5 to D-13 (E2-Top) with an unqualified welding operator. The welding operator, Sathaporn Pornsririsak (ID-9030) performed the SAW for the majority of the 3rd shift. There is no record of this individual performing a qualification test for the non standard joint (approximate 40 degree included groove angle) per the contract documents.

2. Additionally, the TBS QC inspector allowed the welding operator to weld without maintaining the required minimum preheat and interpass temperature of 110 degrees "C" (225 degrees F) at any location along the weld joint.

Applicable reference: AWS D1.1, 2002, section 1.4.2 and section 6.4.1. and the Special Provisions, Section 8-3.01**Who discovered the problem:** OSM Quality Assurance Inspectors Mike Garcia and Mike Foerder**Name of individual from Contractor notified:** QC Inspector Kurt Lightner and TBS QCM Bill Kroplin**Time and method of notification:** 05-09-06 verbally at approximately 0200 and 0930, respectively.**Name of Caltrans Engineer notified:** Mark Vilcheck, Structure Representative**Time and method of notification:** May 10, 2006 via email at approximately 2015 hours**QC Inspector's Name:** Kurt Lightner**Was the QC Inspector aware of problem:** NO**Contractor's proposal to correct the problem:** None at 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: Mike Garcia

Quality Assurance Inspector

Reviewed By: Robert Mertz

Lead QA Inspector



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 18-Aug-06
 Time 11:13 AM

Dated: 18-Aug-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-000811 Rev: 00
 Co/Job # 364-4347
 Contract # 04-0120E4
 Sub/Supplier: TBS
 Sub/Supplier No:

Subject: Trans Bay Steel Response to NCR Issued by State Letter 1179

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 type="checkbox"/> WQCP and/or Addenda |
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Progress Estimate Request | <input type="checkbox"/> Weekly Weld Reports |
| <input checked="" 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 | 17-Aug-06 | 1 | TBS Letter | | 0 | Pending | 1 |
| 02 | 08-Jun-06 | 1 | MT Report | | 0 | Pending | 1 |

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:

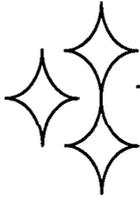
The attached documents respond to an NCR Issued by State Letter 1179 on Trans Bay Steel. They are also in response to State Letter 1551, which lists unresolved non-conformances that resulted in a Blue Tag release of Pile Tops 1 and 2.

CC:

Please review / approve by : 24-Aug-2006

Submitted By: Chris Webb
 (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 17, 2006

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

Reference: SFOBB E2T1 Contract# 04-0120E4

Subject: Response to NCR Issued by State Letter 1179

Attn: Chris Webb

Caltrans State Letter 1179, dated May 12, 2006, notified Trans Bay Steel of an NCR for neglecting to perform a root MT prior to welding additional passes on the stabbing guide fillet weld for can P14.

TBS ground the fillet weld down to the root pass and performed the MT inspection. The MT report is attached.

This incident should not reoccur as all remaining stabbing guide fillet welds will be made with a single pass.

TBS considers this issue resolved.


William M. Kavicky
Trans Bay Steel Corporation

Cc. Paul Hegarty
George Atkinson

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

September 6, 2006

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

Letter No. 05.003.01-001814

Subject: Response to Submittal No. 811, Revision No. 00 (Trans Bay Steel Response to NCR Issued by State Letter 1179)

Dear Lee,

The Department has reviewed Kiewit-FCI-Manson Submittal No. 811, Revision No. 00, dated August 18, 2006, which responded to the Department's Letter No. 1179 dated May 12, 2006, which notified KFM of a Non-conformance Report (NCR) for Trans Bay Steel (TBS) dated May 8, 2006. The Department hereby approves Submittal No. 811, Revision Nos. 00, pursuant to Section 8-3.01, "Welding," of the Special Provisions. The NCR for TBS dated May 8, 2006, is considered to be resolved.

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

Sincerely,

<<< ORIGINAL SIGNED >>>

Mark Vilcheck
Structure Representative

For: Pedro J. Sanchez
Resident Engineer

cc: P. Sanchez
M. Woods
R. Smith

file: 05.003.01, 09.006.03, 55.811