



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 19-Jan-05  
 Time 9:49 AM

Dated: 19-Jan-2005

SUBMITTAL No: KFM-SUB-003681

Rev: 00

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

Co/Job # 3643726  
 Contract # 04-012024  
 Sub/Supplier: USI  
 Sub/Supplier No:

Subject: **USI** - Documents Clearing W M **USI** NCR #40 (METS #26)

Special Provis. (SP) REF: 083.01  
 Standard Spec. (SS) REF:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items:  Attached

Via Fax

- |                                       |   |   |
|---------------------------------------|---|---|
| <input type="checkbox"/> Drawing      | <input type="checkbox"/> Plans                      | <input type="checkbox"/> Prog. Pmt      |
| <input type="checkbox"/> Samples      | <input type="checkbox"/> Certificates of Compliance | <input type="checkbox"/> Calculations   |
| <input type="checkbox"/> Payroll      | <input type="checkbox"/> Specs                      | <input type="checkbox"/> Copy of Letter |
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Schedule                   | <input type="checkbox"/> Invoice        |

| Item | Date      | Copies | Description   | Drawing No | Rev | Status  | Pages |
|------|-----------|--------|---|------------|-----|---------|-------|
| 01   | 19-Jan-05 | 1      | Letter of Transmittal #239  |            | 0   | Pending | 1     |
| 02   | 19-Jan05  | 1      | <b>USI</b> - Documents Clearing W M <b>USI</b> NCR #40 (METS #26) |            | 0   | Pending | 5     |

These are transmitted as checked below:

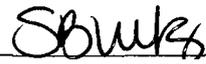
- |  |   |  |
|--|---|--|
| <input checked="" type="checkbox"/> For Approval | <input type="checkbox"/> For Review/comment | <input type="checkbox"/> Return For Correction |
| <input type="checkbox"/> For Your Use            | <input type="checkbox"/> As Requested       | <input type="checkbox"/> For Information       |

Remarks:

CC:

Please review/ approve by : 26-Jan-2005

Submitted By: Rich Bienek  
 (KFM Staff Member - Originator of Transmittal)

Checked & Sent By:   
 Contract Admin/DCS Staff

# Universal Structural, Inc.

a subsidiary of

HARDER MECHANICAL CONTRACTORS, INC.

604 S.E. Victory Avenue, Vancouver, WA. 98661

P.O. Box 1030, Vancouver, WA. 98666

Phone: Vancouver (360) 695-1261 - Portland (503) 227-2419

Fax: (360) 696-3590

## LETTER OF TRANSMITTAL

NO: 239

DATE: January 17, 2005

PROJECT: SFOBB Skyway Structure

JOB NO.: 23932

ATTENTION: Paul Hegarty / Rich Bienek

TO: KFM

220 Burma Road  
Oakland, CA 94607

WE ARE SENDING YOU

- |   |                                       |                                       |                                       |                                  |  |
|---|---------------------------------------|---------------------------------------|---------------------------------------|----------------------------------|--|
| <input type="checkbox"/> Shop Drawings  | <input type="checkbox"/> ATTACHED     | <input type="checkbox"/> Prints       | <input type="checkbox"/> Prints       | <input type="checkbox"/> Samples | <input type="checkbox"/> NCR Responses - Re-Submit |
| <input type="checkbox"/> Copy of letter | <input type="checkbox"/> Change order | <input type="checkbox"/> Change order | <input type="checkbox"/> Change order | <input type="checkbox"/> Plans   | <input type="checkbox"/> Specifications            |

| COPIES                      | ITEM           | DESCRIPTION / REMARKS   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
|-----------------------------|----------------|---|-------------------------|--|-----------------------------|--|---------------|----------------|------------|--------------|----------------|---------------|-------------------------|--|---------------------|--|------------------------|--|
| 1 Oriainal                  | NCR Response   | Caltrans State Letter # 5.03.01-004703<br>USI Letter # 40.01 1705<br>KFM NCR # 40   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| 1 Original                  | NCR Response   | Caltrans State Letter # 5.03.01-004976<br>USI Letter # 50.081304<br>KFM NCR # 50  |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
|                             |                | <table border="1"> <tr> <th colspan="2">SWAY-BAY BRIDGE PROJECT</th> </tr> <tr> <td colspan="2">KIEWIT / PCI / MANSON, A JV</td> </tr> <tr> <td>DATE: 1-19-05</td> <td>City: 364-3726</td> </tr> <tr> <td>ROUTED BY:</td> <td>T. JA 012024</td> </tr> <tr> <td>TO: RKH BIENEK</td> <td>SPECIAL NOTES</td> </tr> <tr> <td colspan="2">INTERNAL KFM COPIES TO:</td> </tr> <tr> <td colspan="2">EXTERNAL COPIES TO:</td> </tr> <tr> <td colspan="2">SCANNED: Y N FILED TO:</td> </tr> </table> | SWAY-BAY BRIDGE PROJECT |  | KIEWIT / PCI / MANSON, A JV |  | DATE: 1-19-05 | City: 364-3726 | ROUTED BY: | T. JA 012024 | TO: RKH BIENEK | SPECIAL NOTES | INTERNAL KFM COPIES TO: |  | EXTERNAL COPIES TO: |  | SCANNED: Y N FILED TO: |  |
| SWAY-BAY BRIDGE PROJECT     |                |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| KIEWIT / PCI / MANSON, A JV |                |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| DATE: 1-19-05               | City: 364-3726 |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| ROUTED BY:                  | T. JA 012024   |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| TO: RKH BIENEK              | SPECIAL NOTES  |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| INTERNAL KFM COPIES TO:     |                |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| EXTERNAL COPIES TO:         |                |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |
| SCANNED: Y N FILED TO:      |                |   |                         |  |                             |  |               |                |            |              |                |               |                         |  |                     |  |                        |  |

THESE ARE TRANSMITTED AS CHECKED BELOW

- For Approval   
  For your use   
  As Requested   
  FOR BIDS DUE \_\_\_\_\_

REMARKS: Mr. Hegarty & Mr. Bienek,  
Universal Structural, Inc. (USI) is in receipt of the above mentioned Caltrans State Letter's and the following attachments; with individual cover letters is USI's record of subsequent action taken.

Copy To: \_\_\_\_\_

Signed: \_\_\_\_\_

*Brad Murphy*  
Brad Murphy cc:SC

If enclosures are not as noted, kindly notify us at once.



# UNIVERSAL STRUCTURAL, INC.

January 17, 2004

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# 40.01 1705)

Subject: Response to Caltrans State Letter # 5.03.01-004703, DTD 06/08/2004  
KFM NCR #40

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004703, dated June 08, 2004. Caltrans stated **that:**  
**"USI's quality control program is not operating independent from production, ....."**

USI believes this NCR was submitted to Caltrans, however, in the possibility it was not, please review and act accordingly.

Please see the attached copy of USI's letter in response to this NCR. Also, attached is a copy of KFM's email discussing this issue.

If you have any questions or need further clarification, please contact me at your earliest possible convenience.

Sincerely,  
Universal Structural, Inc.

Brad Murphy  
Sales Manager

cc: Brad Young - USI  
file



Category III

HARDER MECHANICAL CONTRACTORS



**DEPARTMENT OF TRANSPORTATION**

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



Flex Your Power  
Be Energy Efficient!

June 08, 2004

KFM, a JV  
220 Burma Road  
Oakland, CA 94607

Contract: 04-012024  
04-SF, A1a-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project  
**State Letter # 5.03.1-004703**

**Subject: KFM/USI NCR No. 26: Failure of KFM's Quality Control Manager of Ensuring Adequate and Timely Quality Control at USI**

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

This Non-Conformance Report (NCR) is issued by the State to KFM/USI for the following reason:

1. USI's quality control program is not operating independent from production. The Manufacturing and Fabrication Qualification Audit, dated 11-14-02, was approved by the Engineer predicated on a quality control program independent from production. For example, Bryan Adams was acting in capacity as a welding foreman and Quality Control on 6/3/04.
2. The Contract Special Provisions (revised page 75) requires "A sufficient number of QC Inspector shall be provided to ensure continuous inspection when any welding is being performed for each welding operation and at each welding location." USI is in violation of the Contract. For example, the production staff is being used as Quality Control.
3. KFM's QCM is not adequately monitoring production of the closed rib to skin plate welds. USI's QC has not determined the overall quality and depth of penetration in the production welds. Despite eleven of twenty-three production monitoring tests failing as of 6/4/04, KFM's QCM has allowed USI to move forward with production welding without determining the quality of production welds completed to date. The Contract Special Provisions (revised page 76) states "The QCM shall be responsible directly to the Contractor for the quality of welding, including materials and workmanship, performed by the Contractor and subcontractors."

This NCR will be tracked as KFM/USI NCR No. 26. KFM was verbally notified of this NCR by Caltrans' METS on 06/07/04. 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.

Sincerely,

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, I. Khinsann, V. Iyer, D. Wu, S. Abbas, B. Chew, H. El-Natur, P. Lowry, I. Kwong

file: 5.03.1, 9.07.8

# UNIVERSAL STRUCTURAL, INC.



June 9, 2004

Mr. Paul Hegarty  
KFM  
220 Burma Road  
Oakland, California 94623

Re: METS NCR number: USI NCR No. 26  
State Letter 5.03.1-004703

Dear Mr. Hegarty:

This NCR refers to three issues:

- 1) *USI's quality control program is not operating independent from production.*
- 2) *USI does not have a sufficient number of QC inspectors to ensure continuous inspection when any welding is being performed. For example, production staff is being used as quality control.*

Answer: When shop personnel act as QC, they do so under my direction. These people are fully qualified as AWS Certified Welding Inspectors. They are referenced in our WQCP and have been approved. Presently their main duties, for your project, are to verify joint fit-up. When these people received their certifications from AWS, I spoke to each of them individually about the responsibilities and liabilities of being an inspector. It was made very clear that when they perform inspections, they answer to the quality department only. Note the QC organizational chart in the WQCP that shows the line of command for CWI inspectors. Non-CWI foremen may prioritize what gets looked at first, but they have no say as to the acceptance or rejection of an item. Each of these CWIs worked too hard to get certified to compromise their qualifications. They are very proud of their certifications, and rightfully so. The requirements for continuous inspection, in the special provisions, have been continually met throughout this project with no exception.

- 3) *KFM's QCM is not adequately monitoring production of the closed rib to skin plate welds. USI's QC has not determined overall quality and depth of penetration in production welds. Despite 11 of 23 Production Monitoring Tests failing as of 6/4/04, KFM's QCM has allowed USI to move forward with production welding without determining quality of production welds completed to date.*



Category III

HARDER MECHANICAL CONTRACTORS



UNIVERSAL STRUCTURAL, INC.

Answer: Monitoring is done in process for verifying the electrical parameters used for welding against the welding procedure specification. Weld monitoring tests are being performed prior to welding and at four-hour intervals after that. These are the ones referenced as being rejectable eleven of **23** times. The majority of the unacceptable tests were done prior to starting production welding for the purpose of setting up, so have nothing to do with production welds. We have found that when starting with a cold welding machine, the results are not as constant as when the machine has warmed up and has stabilized. In addition, we do not really think that the short sections are truly representative of the longer rib weld. This seems to be proven out by ultrasonic examination of the production rib welds.

As for the ultrasonic inspections, until yesterday, we did not ultrasonically test the welds, as they require pick-up and we do not have permission to repair weld these with the flux cored arc welding process. Visual acceptance is supposed to happen prior to nondestructive testing. We have since asked for the fifteen percent to be selected and we are ultrasonically testing, but will have to reexamine when the rework has been completed.

Sincerely,



Christopher Amonson  
Quality Assurance Mgr.

  
Corkey Bates

---

**To** Rich Bienek; Paul Hegarty

**Cc** James Gill

**Bcc**

**Subject:** SL4703 / NCR #26

**Attachments:**

Rich,

My thoughts on a response to above referenced Mets NCR:

1) The QC program and individual inspectors meet the Contract requirements of Special Provisions, Section 8-3.01, Welding. Individual QC Inspectors used on the production floor have all been previously approved by Caltrans via the WQCP. Mr. B. Adams was approved via KFM-SUB-2330R0 and Caltrans SL4561. Caltrans has offered no objective evidence that the current QC program is NOT independent of production control.

2) As defined by contract documents, only qualified personnel are used as QC Inspectors. QC Inspection is being performed as defined by the Special Provisions, Section 8-3.01, Welding, as evidenced by the weekly welding reports. Caltrans has not presented any specific evidence that USI has failed to meet the contract requirements.

3) Welding of the closed rib to skin plate welds are proceeding per the Special Provisions, Section 10-1.55, Steel Structures, subparagraph "Welding of Closed Ribs to Deck Plate". The welding quality, including materials and workmanship meet the above referenced Contract requirements.

My thoughts, take them or toss them. Thanks,  
CB

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

March 02, 2005

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 # 5.03.1-007015*

*Subject: Response to KFM-SUB-003681R00: USI Documents Clearing KFM USI NCR #40 (METS #26)*

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

The Engineer has reviewed KFM-SUB-003681R00: USI Documents Clearing KFM USI NCR #40 (METS #26). The Engineer takes exception to the Contractor's responses in KFM-SUB-3681. The use of production personnel as Quality Control inspector is not consistent with the contract requirements. Also, the Engineer has not received any information to indicate the weld monitoring tests conducted to date are not representative of production. However, the Engineer is satisfied the Contractor has taken subsequent steps that sufficiently address the Engineer's concerns expressed in State Letter #4703. The Engineer agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR No. 26 is resolved.

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

Sincerely,

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

David Wu  
Senior Bridge Engineer

For: Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, I. Khinsann, V. Iyer, D. Wu, S. Abbas, B. Chew, H. El-Natur, P. Lowry, I. Kwong

file: 5.03.1, 9.07.8