



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 05-Jan-05*  
*Time 3:17 PM*

Dated: 05Jan-2005

SUBMITTAL No: KFM-SUB-003570

Rev: 00

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

Co/Job # **364-3726**  
 Contract # 04912024  
 Sub/Supplier: **USI**  
 Sub/Supplier No:

Subject: **USI - KFM NCR #63 (METS #49) Closing Documents**

Special Provis. (SP) REF: **08-3.01**  
 Standard Spec. (SS) REF:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items:  Attached

Via Fax

- Drawing
- Samples
- Payroll
- Change Order

- Plans
- Certificates of Compliance
- Specs
- Schedule

- Prog. Pmt
- calculations
- Copy of Letter
- Invoice

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	05-Jan-05	1	USI - W M NCR #63 (METS #49) Closing Documents		0	Pending	5

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 : 12-Jan-2005

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

Checked & Sent By: *SPowik*  
 Contract Admin/DCS Staff





# UNIVERSAL STRUCTURAL, INC.

604 S E Victory Ave  
Vancouver, WA 98661

PO Box 1030  
Vancouver, WA 98666

Vancouver (360)695-1261  
Portland (503)227-2419  
FAX (360) 696 3590

December 15, 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# 63.121504)

Subject: Response to Caltrans State Letter # 5.03.1-005867  
KFM NCR # 63

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.1-005867, dated October 20, 2004, Caltrans stated that:

*"KFM performed welding using an electrode and WPS that has not been approved for this project. USI QCM, Keith Stephenson, informed Caltrans that weld joints 35, 36, 37, 38 and 39 on soffit plate pa19 (T-stiffener to closed rib CJP welds) were welded with an E81T-1 electrode. No WPS has been submitted to weld using this electrode. The correct electrode for these welds is E71T-1".*

USI was aware of this Occurrence (see copy of USI Internal NCR 04-73) and acted accordingly to resolve this NCR. The welds were removed, verified with etching and ground to bright metal and then welded with the E71T-1 electrode. When this was completed, the weld joints were then Ultrasonic Tested (see copy of Ultrasonic Test Report). Please submit this letter and attachments to Caltrans and request a letter to close this NCR.

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



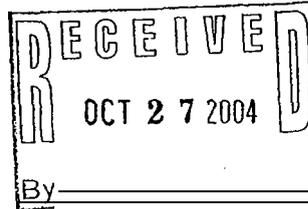
Category III

A Subsidiary of  
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!

October 20, 2004

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 # 5.03.1-005867

*KFM NCR 63*

**Subject: KFM/USI NCR No. 49: Welding Using An Incorrect Electrode**

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

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

1. KFM performed welding using an electrode and WPS that has not been approved for this project. USI QCM, Keith Stephenson, informed Caltrans that weld joints 35, 36, 37, 38 and 39 on soffit plate pa19 (T-stiffener to closed rib CJP welds) were welded with an E81T-1 electrode. No WPS has been submitted to weld using this electrode. The correct electrode for these welds is E71T-1.

**This NCR will be tracked as KFM/USI NCR No. 49. KFM/USI was verbally notified of this NCR by Caltrans' METS on 10/15/04. Please review and address how you plan to resolve this NCR and bring your work back into compliance with our contract.**

Soffitplate assembly, pa19, is rejected until a satisfactory **proposal** by the Contractor is received to bring the material back **into** conformance with the contract requirements. **Should you** have any questions, please contact David Wu at **(510) 622-5104**.

Sincerely,

*David Wu*

**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 NONCONFORMANCE REPORT

DATE: 10/14/04	INITIATOR: Mike Worby	DEPARTMENT: QC	NCR NUMBER: <b>04-73</b>
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING 19A/B	CODE/SPECIFICATION AWS D1.5 (96)
<p><b>NONCONFORMANCE:</b>  <b>Welding</b> took place on the "E" line of <b>Soffit</b> plate <b>pal 9</b>, with incorrect filler metals. E71T-1 is required and E81T-1 was used. Weld joints affected are 38, 39, 36, 37, and 35.</p>			
<p><b>RECOMMENDED DISPOSITION:</b>  Remove the welds. If there is <b>any</b> question that the entire weld was removed, verify with etching.  Grind the weld preparation areas to bright metal.</p>			
QA MANAGER Keith Stephenson	DATE 10/14/04	PROJECT MANAGER Brad Young	DATE 10/14/04
PLANT MANAGER Ralph Seeley	DATE 10/14/04	CUSTOMER Jim Gill	DATE
DISPOSITION COMPLETED			
QC	DATE	CUSTOMER	DATE
FINAL REVIEW			DATE 12/16/04

# UNIVERSAL STRUCTURAL INC.

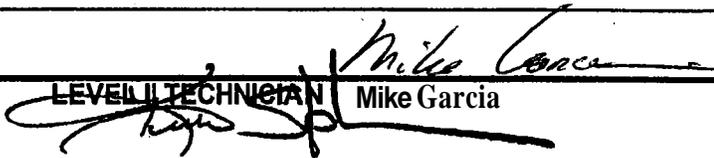
## ULTRASONIC TEST REPORT

<b>REPORT IDENTIFICATION</b>				<b>ACCEPTANCE STANDARD</b>				<b>CUSTOMER IDENTIFICATION</b>			
JOB # <u>23932</u>				ASSHTOIAWS D1.5 - 1996 TABLE 9.1				PROJECT: <u>OAKLAND BAY BRIDG</u>			
DRAWING# <u>100</u>											
ITEM# <u>PA100</u>				VISUAL ACCEPTANCE PRIOR TO NDE				CUSTOMER: <u>KFM / AJV</u>			
EQUIP.: <u>KRAUKRAMER</u>											
MODEL <u>USN58L</u>		SER.# <u>00Y65Y</u>		<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No				BRIDGE: <u>344-0006 UR</u>			
TRANSDUCER:											
<u>2.25</u>	<u>0.63</u>	<u>70</u>	<u>01171N</u>					CONTRACT: <u>04-012024</u>			
Mhz	Size	Type	Ser#								
Couplant: <u>Cellulose Paste</u>											

WELD PART ID	WJ #	WD	AREA	THICKNESS	ACCEPT	REJECT	TRANSDUCER ANGLE	LEG	INDICATION LEVEL	REFERENCE LEVEL	ATTENUATION FACTOR	INDICATION RATING	LENGTH	ANGULAR DISTANCE	DEPTH	DISTANCE FROM X	DISTANCE FROM Y
	35	13	100%	11mm	X		70	1,2		43.7							
	36	13	100%	11mm	X		70	1,2		43.7							
	37	13	100%	11mm	X		70	1,2		43.7							
	38	13	100%	11mm	X		70	1,2		43.7							
	39	13	100%	11mm	X		70	1,2		43.7							

Welding Process:  FCAW     SAW     SMAW     Other

Weld Joint Type:  T-Joint     Butt Joint     Corner Joint

 <b>LEVEL I TECHNICIAN</b> Mike Garcia	<b>11/2/2004</b> DATE
<b>USI QCM, REVIEW - K. STEPHENSON</b>	<b>NOV 10 2004</b> DATE

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

February 11, 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 # 5.03.1-006849*

*Subject: Response to KFM-SUB-003570R00: USI KFM NCR #63 (METS #49) Closing Documents*

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

The Engineer has reviewed KFM-SUB-003570R00: USI KFM NCR #63 (METS #49) Closing Documents. The Engineer agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR No. 49 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