



P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

Request for Information (RFI) Report
KFM Skyway Project # 04-012024

Run Date 12-Oct-05
Time 2:41 PM

Dated: 12-Oct-2005

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

RFI No: KFM-RFI-001567 Rev: 00
Co/Job # 364-3726
Contract # 04-012024
Sub/Supplier: TBS
Sub/Supplier No:

Date Requested By: 27-Oct-2005

Group: SUP

Subject: Response to CTL 8359: TBS NCR #28

Drawing No. Ref:

Specification Ref: 10-1.44

Other:
Resubmittal/Supplement Ref:

Description (Attachments As Needed):

Please see the attached letter from Trans Bay Steel and respond.

Potential Time Impact? No

Potential Cost Impact? No

Schedule Activity ID#:

General Explanation of Potential Impact (If Required):

Response (Attachments As Required):

Answered By:

Date Answered:

CC:

Prepared By: Kevin Rozendaal

Originator

Reviewed By:

Reviewed By:

CCO Manager

Submitted By:

Contract Admin/DCS Staff



For questions and/or comments:

Please contact the KFM Originator listed above at (510) 419-0120

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TRANS BAY STEEL, CORP.

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

October 12, 2005

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

Reference: SFOBB Skyway Contract# 04-012024

Subject: NCR #28: Welding w/o Minimum Preheat

Attn: Rich Bienek

Trans Bay has received State Letter 8359 which issues NCR #28 for welding without minimum preheat. Trans Bay takes preheat very seriously, and to demonstrate that, Trans Bay called a meeting between Bill Kavicky, Kevin Rozendaal, QA Bert Madison, and Trans Bay welders Oudalay Chindavong and Art Murphy on 7/27/05 to discuss the issue.

The NCR centered on the fact that the weld grooves were at proper preheat, but that the area of preheat did not extend to 100mm on each side of the groove, as required by AWS D1.5. The AWS code was reviewed, and all parties understood the code and how to apply it in the future. Bill Kavicky made it clear that Trans Bay's welders must be the first line of defense in matters of quality, and that preheat must be maintained prior to and during welding. The two welders agreed to focus on maintaining preheat on all future welds. Additionally, Trans Bay held a shop-wide quality meeting to discuss preheat and again reinforce that preheat be maintained prior to and during welding.

Since this NCR was issued on 7/28/05, there have been no new recorded incidents of welding without minimum preheat. Additionally, all four cans identified in State Letter #8359 have passed ultrasonic testing. Trans Bay believes that NCR #28 can be closed. Does the State concur?


William M. Kavicky
Trans Bay Steel Corporation

cc. Kevin Rozendaal

Memorandum

*Flex your power!
Be energy efficient!*

To: DOUG COE
Resident Engineer
SFOBB Skyway Office
345 Burma Road
Oakland, California 94607

Date: October 17, 2005

File: 04-012024 SFOBB
East Span Skyway
File 1.5, 1.40

From: KEITH HOFFMAN
Branch Senior
Bay Area Branch
Office of Structural Materials
Materials Engineering and Testing Services
Divisions of Engineering Services

KH

(Signed w/ permission
by Annyle Carno)

Subject: KFM RFI # 1549, 1550, 1559, 1566, 1567 and 1569

The Office of Structural Materials has reviewed KFM RFI# 1549 regarding CCO#48 conduit support at pipe beam, KFM RFI # 1550- Material for Substation Floor Embed Retrofit, per CCO 75, KFM RFI # 1559- Temporary Tower 24" Diameter x 1/2" Wall Pipe Pile, RFI # 1566, regarding precast fender system plastic lumber insert for module 1B-1 and 1B-2, RFI # 1567 regarding response to CTL 8359, TBS NCR#28 and RFI # 1569 TBS RFI-LTR-044: UT of repair areas. Our comments and recommendations to the subject RFIs are presented in the attached report.

If you have any questions, or would like to discuss the issue, please call the Structural Materials Representative Venkatesh Iyer at (858) 967-6363.

Attachments

RECEIVED
045041 OCT 28 05

October 17, 2005

PROJECT INFORMATION

04-012024
SFOBB - Skyway

SUBJECT

KFM RFI # 1549- CCO#48 Conduit Support at Pipe Beam
KFM RFI # 1550- Material for Substation Floor Embed Retrofit, per CCO 75
KFM RFI # 1559- Temporary Tower 24" Diameter x 1/2" Wall Pipe Pile
KFM RFI # 1566- Precast Fender System Plastic Lumber Insert for Module 1B-1 and 1B-2
KFM RFI # 1567- Response to CTL 8359, TBS NCR#28
KFM RFI # 1569- TBS RFI-LTR-044: UT of Repair Areas

DISCUSSION

Our office has received and reviewed the subject RFIs and has compiled the following comments.

COMMENTS

KFM RFI # 1549- CCO#48 Conduit Support at Pipe Beam

KFM's subcontractor ESE, referring to drawing AS-33, inquires if the 6 mm fillet weld on the support clip attaching to the stiffener ring of the pipe beam is fracture critical? They also ask if it would be acceptable to instead drill and tap to attach these clips to the stiffener ring?

OSM understands that there is no such welding detail in the approved drawings and a state letter has already been generated to the contractor.

KFM RFI # 1550- Material for Substation Floor Embed Retrofit, per CCO 75

For CCO 7, retrofit work, KFM's supplier was not able to locate any stainless steel angles of L127 x 89 x 19 mm to be attached in between the present embed plates. Therefore KFM is proposing to make the angle by welding two plates together.



OSM does not have any objection with this proposal as long as welding is performed in accordance with D 1.6, 1999 and approved WQCP. OSM defers the structural suitability to Design.

OSM assumes that the Contractor has checked availability of alternate sizes of available angle shapes for consideration by Design.

KFM RFI # 1559- Temporary Tower 24" Diameter x 1/2" Wall Pipe Pile

Mill certificates are not available for the 24" Diameter x 1/2" Wall Pile that KFM is proposing to use for all Temporary Tower Piling. KFM has provided the tensile test and chemical analysis results for certain samples and they are asking if any additional testing is desired?

OSM has reviewed the submitted test results and has following comments.

1. Sample #1 does not meet the minimum elongation requirement for ASTM A 252 grade 3 by approximately 0.8%. The calculations are shown below in the table below.

Sample Nos.	#1	#2	#3	#4
Wall Thickness (in.)	0.521	0.513	0.524	0.514
Min % Elongation in 2in*	26.7	26.4	26.8	26.4
Actual % Elongation	25.5	35	31	31

- *Calculated as per formula $E = 32t + 10$, for ASTM A 252, Grade 3*

2. ASTM 252 refers to requirement of weights per unit length which should not vary more than 15% over or 5% under its theoretical weight specified in section 11 (ASTM A 252). As the results of weight per unit length are missing, it is not possible to verify if this requirement is met.

KFM RFI # 1566- Precast Fender System Plastic Lumber Insert for Module 1B-1 and 1B-2

KFM requests approval to relocate one pre-drilled counter sunk hole in the recycled reinforced plastic lumbers 1B-1 and 1B-2. The inserts were misaligned by 26mm.

OSM has no objection to this proposal and defers to Design.

KFM RFI # 1567- Response to CTL 8359, TBS NCR#28

In response to METS NCR regarding welding without minimum preheat; KFM subcontractor TBS has demonstrated improved preheats with no new recorded incidents of welding without preheats and requests closing of the NCR.

OSM considers the response adequate and will resolve the NCR following a response by the Engineer to the Contractor.

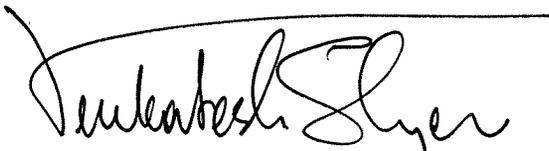


KFM RFI # 1569- TBS RFI-LTR-044: UT of Repair Areas

KFM subcontractor TBS asks for clear direction on NDT to be performed after the repairs. They inquire whether it should be limited to repair areas only or it should be performed on the entire weld.

OSM expects the NDT to be performed in accordance with AWS D 1.5 1996, which requires the re-examination to be performed in the areas of repair.

If you have any questions, or would like to discuss the issue, please call the Structural Materials Representative Venkatesh Iyer at (858) 967-6363.



Venkatesh S. Iyer, Ph.D., P.E.
Structural Materials Representative
Division of Engineering Services
Materials, Engineering and Testing Services
Office of Structural Materials

Document Number CAL 0056

DEPARTMENT OF TRANSPORTATION

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



*Flex Your Power
Be Energy Efficient!*

October 17, 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 # 5.03.1-008971

Subject: Response to RFI No. 1567: TBS NCR No. 28

Dear Mr. Zink,
Attention: Rich Bienek,

We received KFM RFI No. 1567 regarding the closeout of Trans Bay Steel's (TBS) Non-Conformance Report (NCR) No. 28. This NCR was issued to TBS for welding without the required minimum preheat. Since each of the welds identified in this NCR has passed Ultrasonic Testing, the State considers this NCR to be resolved.

If you have any questions regarding this matter, please call Mark Woods at (510) 622-5107.

Sincerely,

<<< ORIGINAL SIGNED >>>

Mark Woods
Senior Bridge Engineer

For: Mr. Douglas Coe
Resident Engineer

cc: D. Coe, M. Woods, D. Wu, B. Chew, D. Wright, V. Iyer, H. El-Natur
file: 5.03.1, 9.07.11