



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 31-May-05
 Time 3:51 PM

Dated: 31-May-2005

SUBMITTAL No: KFM-SUB-004572

Rev: 00

To: Doug Coe

Co/Job # 364-3726

Caltrans-Skyway Project

Contract # 04-012024

345 Burma Road

Sub/Supplier: USI

Oakland CA 94607

Sub/Supplier No:

Phone: Fax:

Subject: USI - Documents Clearing NCR 135 (METS NCR 127)

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

Plans

Prog. Pmt

Samples

Certificates of Compliance

Calculations

Payroll

Specs

Copy of Letter

Change Order

Schedule

Invoice

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	26-May-05	1	USI - Documents Clearing NCR 135 (METS NCR 127)		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 : 07-Jun-2005

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

Checked & Sent By:
 Contract Admin/DCS Staff



UNIVERSAL STRUCTURAL, INC.

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

P.O. Box 1030
Vancouver, WA 98666

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

May 26, 2005

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# 135.052605)

Subject: Response to Caltrans State Letter #5.03.1-007810, DTD 05/18/05
KFM NCR #135

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. has received Caltrans State Letter #5.03.1-007810, dated May 18, 2005. Caltrans stated:

"KFM's quality control manager and onsite representatives allowed USI to deviate from kfm-sub-004352 (CWR 05-160R3 for Assembly 2A deck splice weld joint 1411, area 19). The critical weld repair indicates that the indication should be excavated to the depth indicated on the UT report (13.1 mm). The full thickness (16 mm) of the repair was removed. The extent in which this repair was performed was not approved by the Engineer."

With the failed attempt to repair these welds, USI was with the understanding that one repair attempt would be made from the closer side with FCAW. If that failed, a complete excavation would be performed and the excavation repaired with SAW against metal backing. USI apologizes for any misunderstanding, but maintains that this will be standard operation procedure for splice welds.

Please see copy of:

- Copy of USI's closing letter #05-160R3.051805
- Copy of USI's - CWR # 05-160R3
- Copy of USI's - Ultrasonic Test Report (WJ 1411, area 19)

Please review and submit to Caltrans for 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



Category III

A Subsidiary of
HARDER MECHANICAL CONTRACTORS



BL471
5-20-05

DEPARTMENT OF TRANSPORTATION

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



*Flex Your Power
Be Energy Efficient!*

May 18, 2005

KFM, a JV
220 Burma Road
Oakland, CA 94607

KFM NCR 135

Contract: 04-012024
04-SF, Ala-80-13.9/14.3, 0.0/1.6
SFOBB Skyway Project
State Letter # 5.03.1-007810

Subject: KFM/USI NCR No. 127: Deviating From the Submitted Critical Weld Repair

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

This Non-Conformance Report (NCR) is issued by the Engineer to KFM as a result of your supplier, USI, for the following reason:

1. KFM's quality control manager and onsite representatives allowed USI to deviate from kfm-sub-004352 (CWR 05-160R3 for Assembly 2A deck splice weld joint 1411, area 19). The critical weld repair indicates that the indication should be excavated to the depth indicated on the UT report (13.1 mm). The full thickness (16 mm) of the repair was removed. The extent in which this repair was performed was not approved by the Engineer.

This NCR will be tracked as KFM/USI NCR No. 127. KFM/USI was verbally notified of this NCR by Caltrans' METS on 05/11/05. 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 or Patrick Lowry at (858) 344-2712.

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, D. Salladay

file: 5.03.1, 9.07.8

UNIVERSAL STRUCTURAL, INC.

USI

UNIVERSAL STRUCTURAL, INC.

SUB OF HARDER MECHANICAL

May 18, 2005

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, USI LTR: CWR 05-160R3.051805
Subject: Response to Caltrans State Letter # (Pending)
KFM CWR # 05-160R3

Mr. Hegarty & Mr. Bienek,

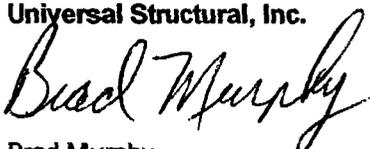
Universal Structural, Inc has not received Caltrans State Letter # (Pending)

Please review the attached information and submit to Caltrans for State Letter to close this CWR.

- Copy of Caltrans State Letter # (Pending)
- Copy of USI's – CWR Number: 05-160R3 (verbally OK on 5-6-05)
- Copy of USI's – Ultrasonic Test Report (Accept)

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



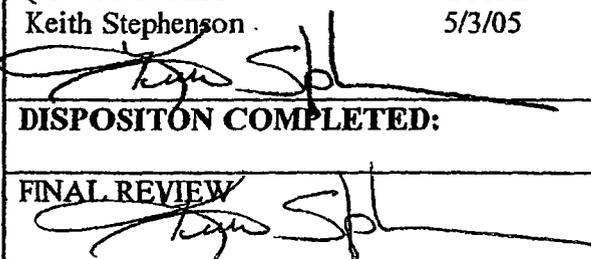
Category III

HARDER MECHANICAL CONTRACTORS

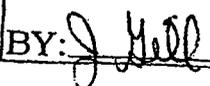


Universal Structural, Inc

CRITICAL WELD REPAIR

DATE: May 3, 2005	INITIATOR Rick Westbrook	DEPARTMENT: QC	CWR NUMBER: 05-160R3
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING A2 B/G	CODE/SPECIFICATION AWS D1.5
NONCONFORMANCE: An unacceptable indication was discovered on Girder 2A, Deck Plate PA7, on weld joint #1411 (area 19). The second attempt was unsuccessful in repairing rejectable indication. This repair has become critical due to the fact that this is a third time repair. Discontinuity location is shown on the attached UT report.			
RECOMMENDED DISPOSITION:			
<ol style="list-style-type: none"> 1. USI-QC to inform responsible craft personnel of the USI-QC procedures for proper welding and weld repair. 2. USI-QC to track & trend responsible welder(s). 3. Preheat to 150 degrees F for excavation if CAC-A is used. 4. Begin excavation at least one inch from the end of the indication towards the original repair to the depth indicated at the location of the repair, referenced on the UT report. 5. Grind to clean metal. 6. Call for inspection to check for location to confirm that discontinuity has been removed. 7. Perform informational MT on excavation to confirm that the indication has been eliminated. 8. Inform QA that weld repair is commencing. 9. Preheat per work procedure number 9.01 rev 4. 10. Weld using a previously approved FCM WPS for this project, being careful to tie stop and starts. 11. Post heat per work procedure number 9.01 rev 4. 			
QA MANAGER Keith Stephenson	DATE 5/3/05	PLANT MANAGER Ralph Seeley	DATE 5/3/05
DISPOSITION COMPLETED:			
FINAL REVIEW 			DATE MAY 12 2005

Comments: Verbal OK to proceed with repairs from Caltrans
5-6-05 Job

RECEIVED
 1100
 MAY 04 2005
 BY: 

UNIVERSAL STRUCTURAL INC.

ULTRASONIC TEST REPORT

REPORT IDENTIFICATION				ACCEPTANCE STANDARD				CUSTOMER IDENTIFICATION			
JOB #		23932		ASTO/AWS D1.5-1996 TABLE 9.1				PROJECT: OAKLAND BAY BRIDGE			
DRAWING #		A2 A/G									
ITEM #		Pa 7 / Pa 8 Girder 2 A Final		VISUAL ACCEPTANCE PRIOR TO NDE				CUSTOMER: KFM/AJV			
EQUIP.		Krautkramer									
MODEL		USN-50									
SER.#		600742		<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No				BRIDGE: 34-0006L/R			
TRANSDUCER:											
225	0.6	0/70	1089								
Mhz	Size	Type	Ser #								
Couplant: Cellulose Paste				CONTRACT: 04-012024							

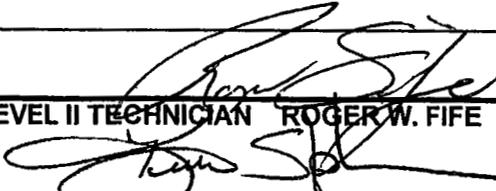
WELD PART ID	WJ #	WID	AREA (mm)	THICKNESS	ACCEPT	REJECT	TRANSDUCER ANGLE	LEG	INDICATION LEVEL	REFERENCE LEVEL	ATTENUATION FACTOR	INDICATION RATING	LENGTH (mm)	ANGULAR DISTANCE	DEPTH	DISTANCE FROM X	DISTANCE FROM Y
Pa 7 / Pa 8																	
	1411-18	50	300	16	X		70	1,2		40							
R-3	1411-19	50	300	16	X		70	1,2		40							
	1411-19	50	300	16	X		70	1,2		40							

REMARKS: Areas 18 and 20 were re-scanned due to repairs made in area 19.

Note: See CWR # 05-160R3 for Original Information.

Welding Process: FCAW SAW SMAW Other

Weld Joint Type: T-Joint Butt Joint Corner Joint

	5/11/2005
LEVEL II TECHNICIAN ROGER W. FIFE	DATE
	MAY 12 2005
USI QCM, REVIEW - K. STEPHENSON	DATE

DEPARTMENT OF TRANSPORTATION

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



*Flex Your Power
Be Energy Efficient!*

June 23, 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 # 5.03.1-008111

Subject: Response to KFM-SUB-004572R00, KFM-SUB-004573R00, KFM-SUB-004571R00, KFM-SUB-004574R00, KFM-SUB-004586R00, KFM-SUB-004587R00, KFM-SUB-004588R00

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

The Engineer has reviewed the following submittals and takes no exceptions:

- KFM-SUB-004572R00: USI Documents Clearing NCR 135 (METS NCR 127)
- KFM-SUB-004573R00: USI Documents Clearing NCR 136 (METS NCR 129)
- KFM-SUB-004571R00: USI Documents Clearing NCR 134 (METS NCR 121)
- KFM-SUB-004574R00: USI Documents Clearing NCR 109 (METS NCR 94)
- KFM-SUB-004586R00: USI Documents Clearing NCR 146 (METS NCR 135)
- KFM-SUB-004587R00: USI Documents Clearing NCR 145 (METS NCR 134)
- KFM-SUB-004588R00: USI Documents Clearing NCR 142 (METS NCR 131)

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, D. Salladay

file: 5.03.1, 9.06.8