KFM
KIEWIT / FCI / MANSON, A JV

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

Co/Job # 364-3726
Contract # 04-012024
Sub/Supplier: USI
Sub/Supplier No:

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

B471
5-20-05

STATE OF CALIFORNIA-BUSINESS, TRANSPORTATION AND HOUSING AGENCY ARNOLD SCHWARZENEGGER, Governor
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 NCR 135

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 # 5.03.1-007810

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 W. 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, 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

Universal Structural, Inc
CRITICAL WELD REPAIR

DATE:	INITIATOR	DEPARTMENT:	CWR NUMBER:
May 3, 2005	Rick Westbrook	QC	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:

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	DATE	PLANT MANAGER	DATE
Keith Stephenson	5/3/05	Ralph Seeley	5/3/05

DISPOSITON COMPLETED:

FINAL REVIEW DATE MAY 12 2005

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

RECEIVED
1100
MAY 04 2005
BY:

UNIVERSAL STRUCTURAL INC.

ULTRASONIC TEST REPORT

REPORT IDENTIFICATION																		
JOB # 23932																		
DRAWING # A2 A/G																		
ITEM # Pa 7 / Pa 8 Girder 2 A Final																		
EQUIP. Krautkramer																		
MODEL USN-50 SER.# 600742																		
TRANSDUCER:																		
225 Mhz	0.6 Size	0/70 Type	1089 Ser #															
Couplant: Cellulose Paste																		

ACCEPTANCE STANDARD
AASTO/AWS D1.5-1996
TABLE 9.1

VISUAL ACCEPTANCE PRIOR TO NDE
☑ Yes ☐ No

CUSTOMER IDENTIFICATION
PROJECT: OAKLAND BAY BRIDGE
CUSTOMER: KFM/AJV
BRIDGE: 34-0006L/R
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

LEVEL II TECHNICIAN ROGER W. FIFE — 5/11/2005 **DATE**

USI QCM, REVIEW - K. STEPHENSON — MAY 12 2005 **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