



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 14-Aug-06
 Time 9:07 AM

Dated: 8/14/06

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

SUBMITTAL No: KFM-SUB-006993 Rev: 00
 Co/Job # 364-3726
 Contract # 04-012024
 Sub/Supplier: USI
 Sub/Supplier No:

Subject: USI - Closeout Letter for NCR 165

Special Provis. (SP) REF: 10-41.44
 Standard Spec. (SS) REF:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items: Attached

Via Fax

- | | | |
|--|--|--|
| <input checked="" type="checkbox"/> Contract Plans/Specs | <input type="checkbox"/> Certs of Compl./Samples | <input type="checkbox"/> Working Drawings |
| <input type="checkbox"/> Drawings/Calculations | <input type="checkbox"/> Schedule | <input type="checkbox"/> WQCP and/or Addenda |
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Progress Estimate Request | <input type="checkbox"/> Weekly Weld Reports |
| <input type="checkbox"/> Copy of Letter | <input type="checkbox"/> Payroll Information | <input type="checkbox"/> CWR Procedure |

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	14-Aug-06	1	USI - Closeout Letter for NCR 165		0	Pending	6

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 : 21-Aug-2006

Submitted By: Dennis Winter
 (KFM Staff Member - Originator of Transmittal)

Checked & Sent By:
 Contract Admin/DCS Staff



Universal Structural, Inc.

August 9, 2006

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# 165.080906)

Subject: Response to Caltran/Mets NCR# 155

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. has received Caltran Non Conformance Report# 155 dated June 24, 2005. The report states

"KFM's quality control manager and onsite representatives allowed USI to perform a critical weld repair without following the requirements in AWS D1.5:96, Section 12.15.1.1 and USI's internal repair procedure 9.0.1. rev 4, paragraph 6.1.2.1..."

CWR# 05-252R1 is complete and the follow up NDE is acceptable.

This incident occurred due to two factors. Firstly, the welder involved was unaware of the proper procedure and consequences of leaving a critical weld repair incomplete. Second, the immediate supervisor was unaware that this was a violation. After this incident, all welders and supervisors were informed of the proper welding procedure. All weld repairs since were performed by welders with intent of completion within the parameters of the weld procedure.

Attachments:

- Copy of - Caltrans State Letter 5.03.1-008120
- Copy of - Caltrans NCR# 155
- Copy of - USI Closure documents (CWR# 05-252R1)

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.

Nate Lindell
QA Manager

BL

DEPARTMENT OF TRANSPORTATION

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



Flex Your Power
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KFM ncr 165

June 24, 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 # 5.03.1-008120

Subject: KFM/USI NCR No. 155: Failure to Follow Requirements for Critical Weld Repairs

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 perform a critical weld repair without following the requirements in AWS D1.5:96, Section 12.15.1.1 and USI's internal repair procedure 9.0.1 rev. 4, paragraph 6.1.2.1. One area of CWR 05-252 R1 (weld joint 410 of diagonal plate pa339 to 100 mm plate) was excavated and 16 passes were welded on the evening of 06/22/2005. This repair area was allowed to cool overnight without completion.

This NCR will be tracked as KFM/USI NCR No. 155. KFM/USI was verbally notified of this NCR by Caltrans' METS on 06/23/05. 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

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
MATERIALS ENGINEERING AND TESTING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection
Bay Area Branch
690 Walnut Ave., St. 150
Vallejo, CA 94592-1133
(707) 649-5453
FAX: (707) 649-5493



Contract #: 04-012024
Cty SF Rte 80 PM 13.9/14.3.
File # 10.25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Vancouver, WA

Date: 06/23/2005

Prime Contractor: Kiewit, FCI and Manson (KFM), a Joint Venture

NCR #155

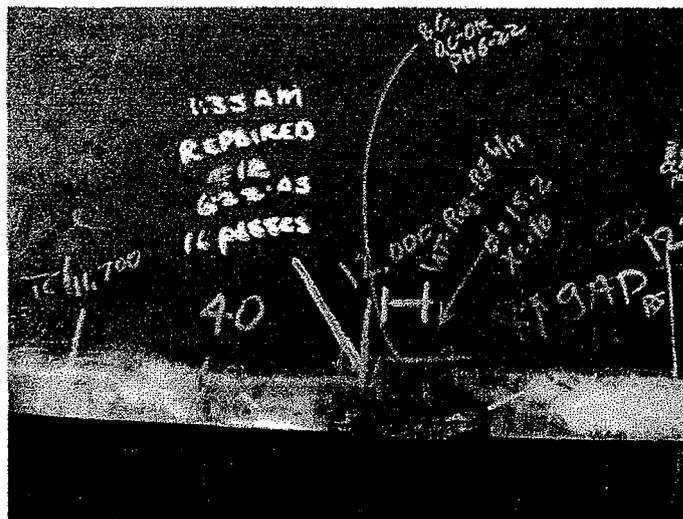
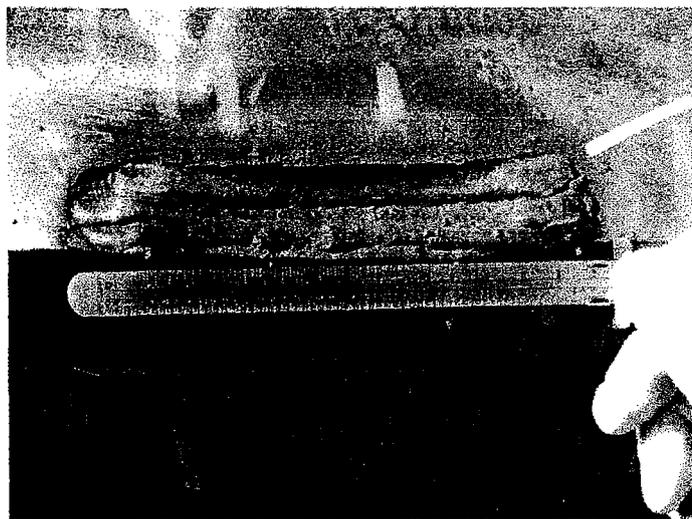
Submitting Contractor: Universal Structural, Inc. (USI)

KFM NCR 165

Type of problem:

Welding	<input checked="" type="checkbox"/>	Concrete	<input type="checkbox"/>	Other	<input type="checkbox"/>
Welding:	<input checked="" type="checkbox"/>	Curing:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>
Joint fit-up:	<input type="checkbox"/>	Coating:	<input type="checkbox"/>	Other:	<input type="checkbox"/>
Procedural:	<input type="checkbox"/>	Procedural:	<input type="checkbox"/>		

Description of Non-Conformance: KFM's Quality Control (QC) Manager and on-site representatives allowed USI to perform a critical weld repair (CWR) without following the requirements in AWS D1.5:96, section 12.15.1.1 and USI's internal repair procedure 9.0.1 rev. 4, paragraph 6.1.2.1. One area of CWR 05-252 R1 (weld joint 410 of diagonal plate Pa339 to 100 mm plate) was excavated, and 16 passes were welded on the evening of 06/22/2005. This repair area was allowed to cool overnight without completion. The following photographs depict the repair area after being allowed to cool.



Applicable reference: AWS D1.5:96, section 12.15.1.1, which states, "When postheat is required, the weld shall not be allowed to cool below the minimum preheat and interpass temperature before being raised to the postweld heat treatment (PWHT) temperature."

USI internal repair procedure 9.0.1 rev. 4, paragraph 6.1.2.1, which states, "For critical status repairs and noncritical status repairs that require postheat, the weld shall not be allowed to cool from the time welding starts through the time that hydrogen diffusion post heating begins."

Who discovered the problem: John W. Miller



Universal Structural, Inc.

January 22, 2006

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 05-252R1.012206

Subject: Response to METS/Caltrans Letter (Pending)
KFM CWR # 05-252R1

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. has not received Caltrans State Letter (Pending). USI Critical Weld Repair# 05-252R1, on Girder 9A, p328d to diagonal deck plate pa336 (weld joint# 410) was verbally approved on 6/22/05.

Please review and submit to Caltrans for a letter to close out this CWR

Attachments:

- Copy of -- USI's Critical Weld Repair# 05-252R1
- Copy of -- USI's Ultrasonic Test Report (Weld Joint# 410)

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

Sincerely,
Universal Structural, Inc.

Nate Lindell
QA Manager

Universal Structural, Inc

CRITICAL WELD REPAIR

DATE: June 18, 2005	INITIATOR Tony Gross	DEPARTMENT: QC	CWR NUMBER: 05-252R1
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING A9H/K	CODE/SPECIFICATION AWS D1.5

NONCONFORMANCE:

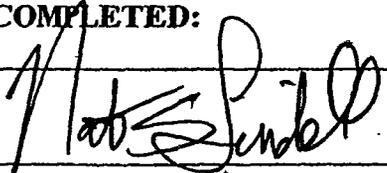
Unacceptable indications were found in the ultrasonic test performed after the initial weld was completed. The indications were found on Girder 9A, p328d to diagonal deck plate pa336, weld joint #410. This is a critical weld repair due to the fact that the discontinuity exceeds 65% in depth. Repair rejects totaling 395mm or 2.6% of total weld length 15000mm. The location and size of the indication 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 of 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 6/18/05	PLANT MANAGER Ralph Seeley	DATE 6/18/05
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DISPOSITON COMPLETED:

FINAL REVIEW 	DATE 1/23/06
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Comments: Verbal OK to proceed with repair from Caltrans
6-22-05 JH

RECEIVED
 1300
 JUN 21 2005
 BY: JH

UNIVERSAL STRUCTURAL INC.

ULTRASONIC TEST REPORT

REPORT IDENTIFICATION				EQUIPMENT IDENTIFICATION				CUSTOMER IDENTIFICATION							
JOB #	23932			Equipment:	Krautkramer			PROJECT:	OAKLAND BAY BRIDGE						
DRAWING #	328 Girder 9			Model:	52L			CUSTOMER:	KFM / AJV						
ITEM #	Pa328			Ser.#	60482			BRIDGE:	34-0006 L/R						
CWR #:	05-252 R1			Transducer Ser #:	013BH6			CONTRACT:	04-012024						
				Mhz:	2.25	Size:	0.625	ACCEPTANCE STANDARD: AWS D1.5 - 96							
				Type:	<input checked="" type="checkbox"/> 70	<input type="checkbox"/> 60									
					<input type="checkbox"/> 45	<input checked="" type="checkbox"/> 0									
				IW Block Ser. #	0654-03										
				Couplant: Cellulose Paste											

PIECE MARK	WJ #	REPAIR #	WELDER ID	LENGTH OF WELD (mm)	THICKNESS	ACCEPT	REJECT	LEG	INDICATION LEVEL	REFERENCE LEVEL	ATTENUATION FACTOR	INDICATION RATING	LENGTH (mm)	ANGULAR DISTANCE	DEPTH	DISTANCE FROM X	DISTANCE FROM Y	
						<input type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>						
Pa336 to Pa328	410																	
Area 4	410	1	10	300	16	X		1,2		46								
Area 5	410	1	10	300	16	X		1,2		46								
Area 34	410	1	10	300	16	X		1,2		46								
Area 35	410	1	10	300	16	X		1,2		46								
Area 39	410	1	10	300	16	X		1,2		46								
Area 41	410	1	12	300	16	X		1,2		46								

Comments: _____

Welding Process:
 FCAW
 SAW
 SMAW
 Other
 Visual Acceptance Prior to NDE:

Weld Joint Type:
 T-Joint
 Butt Joint
 Corner Joint
 Yes
 No

Pat McDevitt / Sean Vance LEVEL II TECHNICIAN	11/15/2005 DATE
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!*

August 17, 2006

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 # 5.03.1-010309

Subject: Response to Various KFM Submittals to Closeout USI NCRs

Dear Mr. Zink,
Attention: Mr. Dennis Winter,

The Engineer has reviewed and takes no exceptions to the following submittals, which contain documents to closeout various Non-Conformance Reports (NCR):

<u>KFM-SUB #</u>	<u>Description</u>
6993	USI Documents Closing NCR 165 (METS NCR 155)
6957	USI Documents Closing NCR 224 (METS NCR 214)
6958	USI Documents Closing NCR 231 (METS NCR 224)
6960	USI Documents Closing NCR 247 (METS NCR 242)
6962	USI Documents Closing NCR 250 (METS NCR 245)
6967	USI Documents Closing NCR 264 (METS NCR 263)
6968	USI Documents Closing NCR 265 (METS NCR 264)
6969	USI Documents Closing NCR 268 (METS NCR 265)

If you have any questions, please contact David Wu at (510) 622-5104 or Ady Velasco at (858) 355-8746.

Sincerely,

<<< ORIGINAL SIGNED >>>

David Wu
Senior Bridge Engineer

For: Mr. Douglas Coe
Resident Engineer

cc: P. Lowry, D. Coe, V. Iyer, D. Wu, B. Chew, I. Kwong

file: 5.03.1