



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 13-Jan-05
Time 9:54 AM

Dated: 13-Jan-2005
To: Doug Coe
 Caltrans-Skyway Project
 345 Burma Road
 Oakland CA 94607
 Phone: Fax:

SUBMITTAL No: KFM-SUB-003643 **Rev:** 00
Co/Job # 364-3726
Contract # 04-012024
Sub/Supplier: USI
Sub/Supplier No:

Subject: USI - Documents Clearing W M NCR #68 (METS 54)

Special Provis. (SP) REF: 083.01
Standard Spec. (SS) REF:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items: Attached

Via Fax

- | | | |
|---------------------------------------|---|---|
| <input type="checkbox"/> Drawing | <input checked="" type="checkbox"/> Plans | <input type="checkbox"/> Prog. Pmt |
| <input type="checkbox"/> Samples | <input type="checkbox"/> Certificates of Compliance | <input type="checkbox"/> Calculations |
| <input type="checkbox"/> Payroll | <input type="checkbox"/> Specs | <input type="checkbox"/> Copy of Letter |
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Schedule | <input type="checkbox"/> Invoice |

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	13-Jan-05	1	Letter of Transmittal #161		0	Pending	1
02	13-Jan-05	1	USI - Documents Clearing W M NCR #68 (METS 54)		0	Pending	13

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 : 20-Jan-2005

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

Checked & Sent By: SPURK
 Contract Admin/DCS Staff



UNIVERSAL STRUCTURAL, INC.

604 S E Victory Ave
Vancouver, WA 98661

P O Box1030
Vancouver, WA 98666

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

December 2, 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# 68.120204)

Subject: Response to Caltrans State Letter # 5.03.1-005903
KFM NCR # 68

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.1-005903, dated October 25, 2004, Caltrans stated that:

Weld joints 101 and 102 on pa19 were gouged out without submitting a Critical Weld Repair for approval from the Engineer. The weld was removed in an attempt to straighten distortion from prior welding. The length of the excavation exceeds the allowable lengths in AWS S1.5, 1996, Section 12.17.2."

USI recognizes that the excavation performed was in violation of AWS D1.5. During the excavation of these welds USI made every effort to not exceed 65% maximum depth; however USI failed to realize the length of excavation exceeded the 10% maximum allowed by code. USI submitted CWR # 04-80 & 04-81 (see attached copies) after excavation. USI has performed further training to assure this situation will not be repeated. Please notify 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



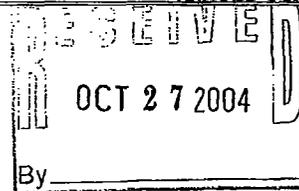
Category III

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
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BLPH
 10/26/04

October 25, 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.I-005903

Subject: USI NCR No. 54: Failure to Submit A Critical Weld Repair Report Prior to Removing Weld Joints on Pa19

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

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

1. Weld joints **101 and 102 on pa19** were gouged out without submitting a **Critical Weld Repair for approval from the Engineer**. The weld was removed in an attempt to straighten distortion from prior welding. The length of the excavation exceeds the allowable lengths in AWS D1.5, 1996, Section 12.17.2.

This NCR will be tracked as USI NCR No. **54**. USI was verbally notified of this NCR by Caltrans' METS on **10/19/04**. 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.

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

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
City SE Rte 80 PM 13.9/14.3
File # 10.25 B

QUALITY ASSURANCE - NONCONFORMANCE REPORT

Location: Vancouver, WA

Date: 10-19-04

Prime Contractor: Kiewit, FCI and Manson Joint Venture

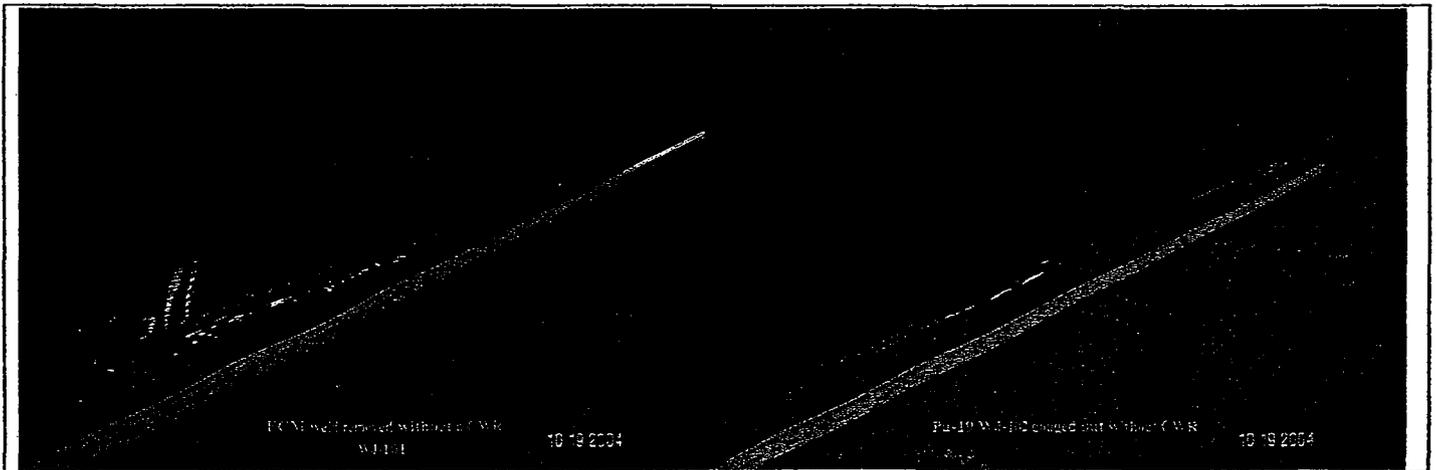
Submitting Contractor: Universal Structural Inc.

Type of problem:

*NCR # 54
PER E-MAIL INFO
FROM PH/10-14-04/5:27PM
LB*

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 checked="" type="checkbox"/>	Procedural:	<input type="checkbox"/>		

Description of Non-Conformance: Weld joints 101 and 102 on Pa-19 were gouged out without submitting a Critical Weld Repair for approval from the Engineer. The weld was removed in an attempt to straighten distortion from prior welding. The length of the excavation exceeds the allowable lengths in AWS D1.5, 1996, Section 12.17.2.



Applicable reference: AWS D1.5-96 Sec. 12.172 and 12.173

Who discovered the problem: ~~Mark~~ Wright (Caltrans Quality Assurance)

Name of individual from Contractor notified: Mr. Mike Worby (Quality Control)

Time and method of notification: 1730 Verbal on 10-19-04

Name of Caltrans Engineer notified: Dave Wu

Time and method of notification: 10/20/04, 3:30 p.m., voice mail

QC Inspector's Name: Mike Worby

Was the QC Inspector aware of problem: yes



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 21-Oct-04
 Time 8:29 AM

Dated: 10-21-04

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

SUBMITTAL No: KFM-SUB-003114 Rev: 00
 Co/Job # 364-3726
 Contract # 04-012024
 Sub/Supplier: USI
 Sub/Supplier No:

Subject: USI - Critical Weld Repair Report #04-80

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	21-Oct-04	1	USI - Critical Weld Repair Report #04-80		0	Pending	3

These are transmitted as checked below:

- For Approval
- For Your Use
- For Review/comment
- As Requested
- Return For Correction
- For Information

Remarks:

CC:

Please review / approve by : 28-Oct-2004

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

Checked & Sent By: _____
 Contract Admin/DCS Staff

DEPARTMENT OF TRANSPORTATION

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



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October 28, 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 # 5.03.1-005968

Subject: Response to KFM-SUB-003114R00: USI Critical Weld Repair Report 04-80

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

The Engineer **has** reviewed **KFM-SUB-003114R00: USI Critical Weld Repair Report 04-80** regarding the request to repair weld joint #101 between pa19 and pa49. The subject submittal is approved **with concerns**. **As** described in State Letter No. **5903**, the Engineer is concerned the Contractor began the requested repair prior to **obtaining** Engineer approval. The Engineer's approval is required prior to **beginning** all Critical Weld Repairs.

Should you have **any** questions, please contact Patrick Lowry at (858) 344-2712 or David **Wu** at (510) 622-5104.

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, 9.06.8

Universal Structural, Inc

CRITICAL WELD REPAIR

DATE:	INITIATOR	DEPARTMENT:	CWR NUMBER:
October 20, 2004	Ralph Seeley	Production	04-80
JOB NUMBER:	JOB NAME:	DRAWING	CODE/SPECIFICATION
23932	SFOBB	A3A/G	AWS D1.5
NONCONFORMANCE:			
<p>As shown on the attached USI-QC Weld Repair Tracking Sheet #0109, On girder 3A, pa19 to pa49 weld joint #101 weld was removed to repair weld distortion. A skip weld technique will be used to minimize weld distortion. This is a critical repair due to the length of the indication exceeds the length allowed. The location and size of the indication is illustrated on the attached sketch.</p>			
RECOMMENDED DISPOSITION:			
<ol style="list-style-type: none"> 1. Preheat to 150 degrees F for excavation if CAC-A is used. 2. Begin excavation to make sure that no more than 65% is removed 3 Grind to clean metal. 4 MT excavation to confirm that no indications are present. 5 Inform QA that weld repair is commencing. 6 Preheat per work procedure number 9.01 rev 4. 7 Weld using a previously approved FCM WPS for this project, being careful to tie stop and starts. 8 Post heat per work procedure number 9.01 rev 4. 			
QA MANAGER		PROJECT MANAGER	
Keith Stephenson	DATE 10/20/04	Brad Young	DATE 10/20/04
PLANT MANAGER		KFM/QA MANAGER	
Ralph Seeley	DATE 10/20/04	Rich Bienek	DATE
DISPOSITON COMPLETED:			
PLANT MANAGER		CUSTOMER	
Ralph Seeley	DATE		DATE
FINAL REVIEW			DATE



Universal Structural, Inc.

San Francisco-Oakland Bay Bridge Project - USI J/N 23832- Contract 04-012024

Weld Repair Tracking Sheet No: 0109

INITIAL WELD STATUS

Date: 10119/04 QC: Keith Stephenson

Structure: Girder 3 Part: pa19 PCMK(s): pa19/pa49

Weld No: 101 WPS: FCAW WID: NIA

Method of Rejection: VT PT MT UT RT Other*:

* = If "Other", Explain: Weld distortion

Reject Length: 2155 Weld Length: 11582 Reject%: 18.6%

Cavity Length: _____ Weld Length: _____ Repair%: _____

Critical: CWR No: 04-80 Non-Critical:

Caltrans State Letter No: _____ 5968

FIRST REPAIR WELD STATUS

Date: _____ QC: _____

Weld No: _____ WPS: _____ WID: _____

Accepted or Rejected: _____

Method of Acc/Rej: VT PT MT UT RT Other*:

* = If "Other", Explain: _____

Critical: CWR No: _____ Non-Critical:

Caltrans State Letter No: _____

SECOND REPAIR WELD STATUS

Date: _____ QC: _____

Weld No: _____ WPS: _____ WID: _____

Accepted or Rejected: _____

Method of Acc/Rej: VT PT MT UT RT Other*:

* = If "Other", Explain: _____

Critical: CWR No: _____ Non-Critical:

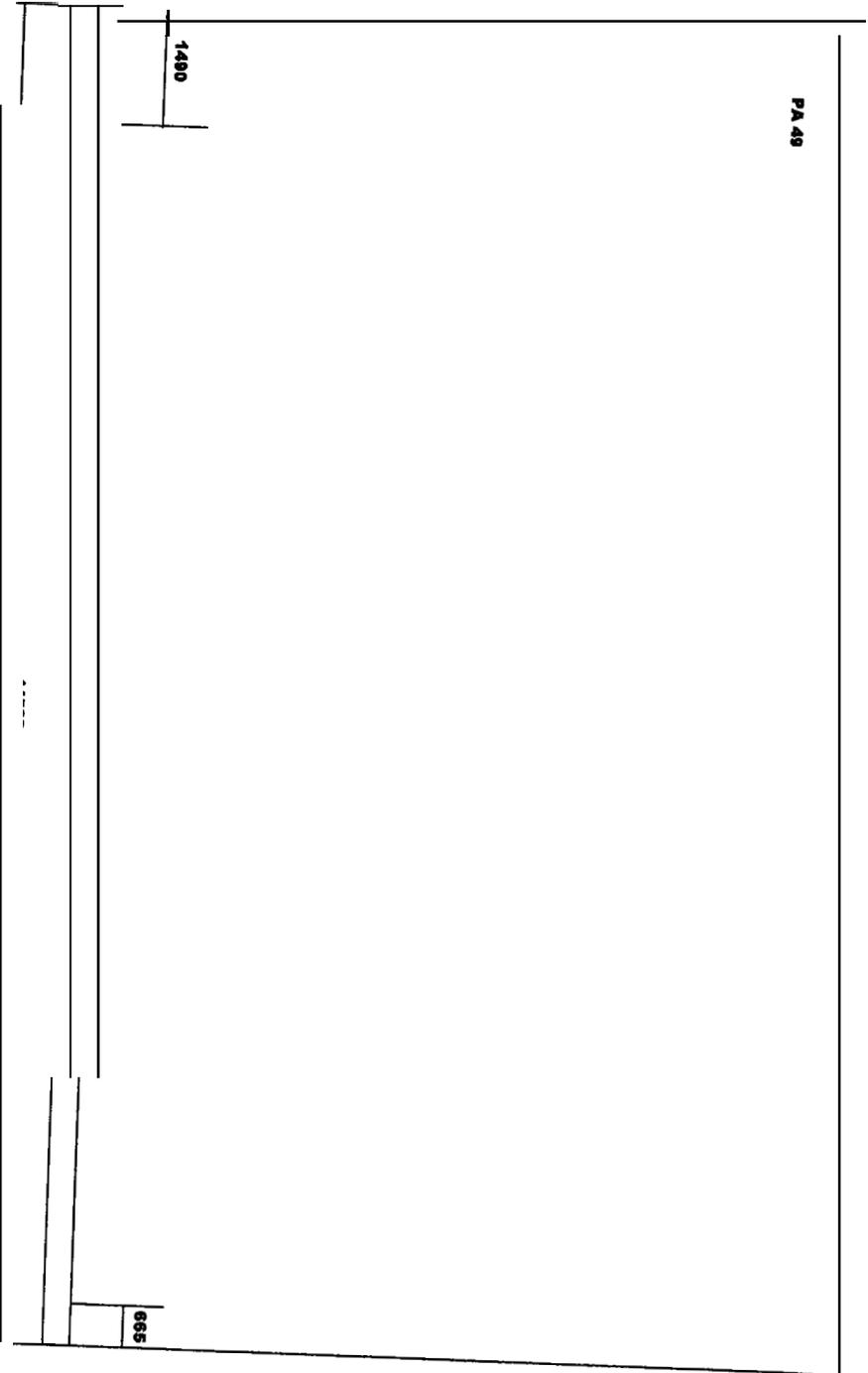
Caltrans State Letter No: _____

PA 49

1490



665



CWR# 04-80

TRACKING# 0109



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 21-Oct-04
 Time 8:29 AM

Dated: 10-21-04

SUBMITTAL No: KFM-SUB-003115

Rev: 00

To: Doug Coe
 Caltrans-Skyway Project
 345 Burma Road
 Oakland CA 94601
 Phone: Fax:

Co/Job # 384-3726
 Contract # 04-012024
 Sub/Supplier: USI
 Sub/Supplier No:

Subject: USI - Critical Weld Repair Report #04-81

Special Provis. (SP) REF: 06-3.01

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	21-Oct-04	1	USI - Critical Weld Repair Report #04-81		0	Pending	3

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: 28-Oct-2004

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

Checked & Sent By: _____
 Contract Admin/DCS Staff

DEPARTMENT OF TRANSPORTATION

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



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October 28, 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 # 5.03.1-005969

Subject: Response to KFM-SUB-003115R00: USI Critical Weld Repair Report 04-81

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

The Engineer **has** reviewed **KFM-SUB-003115R00: USI Critical Weld Repair Report 04-81** regarding the request to repair weld joint **#102** between pa19 and pa50. The subject submittal is approved with concerns. **As** described in State Letter No. **5903**, the Engineer is concerned **the** Contractor began the requested repair prior to obtaining Engineer approval. The Engineer's approval is required prior to beginning all Critical Weld Repairs.

Should you have any questions, please contact Patrick **Lowry** at (858) 344-2712 or David Wu at (510) 622-5104.

Sincerely,

<<< ORIGINAL SIGNED >>>

David Wu
 Senior Bridge Engineer

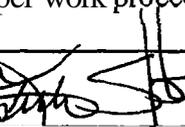
For: Mr. Douglas Coe
 Resident Engineer

cc: D. Coe, I. Khinsann, V. Iyer, **D. Wu**, S. Abbas, B. Chew, H. El-Natur, P. **Lowry**, I. Kwong

file: 5.03.1, 9.06.8

Universal Structural, Inc

CRITICAL WELD REPAIR

DATE:	INITIATOR	DEPARTMENT:	CWR NUMBER:
October 20, 2004	Ralph Seeley	Production	04-81
JOB NUMBER:	JOB NAME :	DRAWING	CODE/SPECIFICATION
23932	SFOBB	A3A/G	AWS D1.5
RECOMMENDED DISPOSITION:			
<ol style="list-style-type: none"> 1. Preheat to 150 degrees F for excavation if CAC-A is used. 2. Begin excavation to make sure that no more than 65% is removed 3. Grind to clean metal.. 4. MT excavation to confirm that no indications are present. 5. Inform QA that weld repair is commencing. 6. Preheat per work procedure number 9.01 rev 4. 7. Weld using a previously approved FCM WPS for this project, being careful to tie stop and starts. 8. Post heat per work procedure number 9.01 rev 4. 			
QA MANAGER	DATE	PROJECT MANAGER	DATE
Keith Stephenson 	10/20/04	Brad Young	10/20/04
PLANT MANAGER	DATE	KFM/QA MANAGER	DATE
Ralph Seeley	10/20/04	Rich Bienek	
DISPOSITON COMPLETED:			
PLANT MANAGER	DATE	CUSTOMER	DATE
Ralph Seeley			



Universal Structural, Inc.

San Francisco-Oakland Bay Bridge Project - USI J/N 23932- Contract 04-012024

Weld Repair Tracking Sheet No: 0110

INITIAL WELD STATUS

Date: 10/19/04 QC: Keith Stephenson

Structure: Girder 3 Part: pa19 PCMK(s): pa19/pa50

Weld No: 102 WPS: ECAW WID: N/A

Method of Rejection: VT PT MT UT RT Other*:

• = If "Other", Explain: Weld distortion

Reject Length: 4320 Weld Length: 11495 Reject % : 37.6%

Cavity Length: _____ Weld Length: _____ Repair % : _____

Critical: CWR No: 04-81 Non-Critical:

Caltrans State Letter No: _____ 5969

FIRST REPAIR WELD STATUS

Date: _____ QC: _____

Weld No: _____ WPS: _____ WID: _____

Accepted or Rejected: _____

Method of Acc/Rej: VT PT MT UT RT Other*:

* = If "Other", Explain: _____

Critical: CWR No: _____ Non-Critical:

Caltrans State Letter No: _____

SECOND REPAIR WELD STATUS

Date: _____ QC: _____

Weld No: _____ WPS: _____ WID: _____

Accepted or Rejected: _____

Method of Acc/Rej: VT PT MT UT RT Other*:

* = If "Other", Explain: _____

Critical: CWR No: _____ Non-Critical:

Caltrans State Letter No: _____

PA 50

3200

4320

11498

CWR# 04-81
TRACKING# 0110

DEPARTMENT OF TRANSPORTATION

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



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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 # 5.03.1-006858

Subject: Response to KFM-SUB-003643R00: USI Documents Clearing KFM NCR #68 (METS #54)

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

The Engineer has reviewed KFM-SUB-003643R00: USI Documents Clearing KFM NCR #68 (METS #54). The Engineer agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR No. 54 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