



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 18-Jul-05
Time 1:56 PM

Dated: 18-Jul-2005

SUBMITTAL No: KFM-SUB-004892

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: 880

Subject: USI Documents Clearing NCR #101 (METS #86)

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	15-Jul-05	1	USI Documents Clearing NCR #101 (METS #86)		0	Pending	6

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 : 25-Jul-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

July 15, 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# 101.071505)

Subject: Response to Caltrans State Letter # 5.03.01-007003, DTD 2/28/05
KFM NCR #101

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-007003, dated February 28, 2005.

Caltrans stated:

"The State QA inspector reviewed radiographic (RT) film which were accepted by USI. Section 2 D-E, 3 C-D and 4 B-C contained rejectable indications per AWS D1.5 1996."

USI QCM reviewed the RT film in question and generated CWR #05-029 to repair this indication. Subsequent repair has been completed, along with all NDE requirements. This CWR has been closed on State Letter #5.03.1-008092

Please see attached documentation:

- Copy of State Letter #5.03.1-007003 (METS/Caltrans NCR No. 86)
- Copy of USI's cover letter #05-029R8.052705
- Copy of USI's CWR #05-029R8 (verbal approval, 5-19-05)
- Copy of USI's Ultrasonic Test Report
- Copy of State Letter #5.03.1-008092 (Clearing documents for CWR 05-029R8))

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

cc: file



Category III

A Subsidiary of
HARDER MECHANICAL CONTRACTORS



DLT
2/28/05

DEPARTMENT OF TRANSPORTATION

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



Flex Your Power
Be Energy Efficient!

February 28, 2005

KFM, a JV
220 Burma Road
Oakland, CA 94607

KFM NCR 101

Contract: 04-012024
04-SF, Ala-80-13.9/14.3, 0.0/1.6
SFOBB Skyway Project
State Letter # 5.03.1-007003

Subject: USI NCR No. 86: Failure of USI to Reject Unacceptable Radiographic Film

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. The State QA inspector reviewed radiographic (RT) film which were accepted by USI. Section 2 D-E, 3 C-D and 4 B-C contained rejectable indications per AWS D1.5 1996.

This NCR will be tracked as USI NCR No. 86. USI was verbally notified of this NCR by Caltrans' METS on 02/23/05. 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.

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

UNIVERSAL STRUCTURAL, INC.

USI

UNIVERSAL STRUCTURAL, INC.

SUB OF HARDER MECHANICAL

May 27, 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 05-029R8.052705

Subject: Response to Caltrans State Letter # (Pending)
KFM CWR # 05-029R8

Mr. Hegarty & Mr. Bienek,

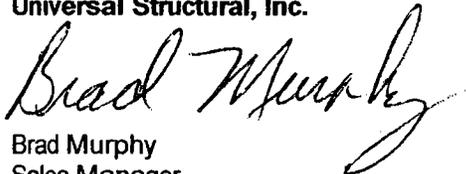
Universal Structural, Inc has not received Caltrans State Letter # (Pending).

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

- Copy of Caltrans State Letter # (Pending)
- Copy of USI's – CWR Number: 05-029R8 (Verbal OK, 05-19-05)
- Copy of USI's – Ultrasonic Test Report

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

HARDER MECHANICAL CONTRACTORS



Universal Structural, Inc CRITICAL WELD REPAIR

DATE: May 13, 2005	INITIATOR Mark Nastari	DEPARTMENT: QC	CWR NUMBER: 05-029R8
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING 3A	CODE/SPECIFICATION AWS D1.5

CIRCUMSTANCE:

As shown on the attached USI-NDE report, an unacceptable indication was found in the UT test performed on Girder 3A, deck plate to deck plate weld joint# 1120 (pa9 to pa10).

This is a critical weld repair because it has become the seventh repair for this joint. To further assist in your review, a full weld NDE audit is also attached. All relevant NDE reports have been previously submitted.

It is important to note that the R6 repair attempts on the other 8 defects were successful due to the new welding technique developed during the welding of Girder 4A deck-to-deck welds. Therefore, we have high confidence that this repair attempt shall also be successful.

Specifically, USI has experienced great success with deck-to-deck welds (initial & repair) using a single-vee joint configuration, metallic backing, GMAW continuous tack, SAW BHFC (bead, hot-pass, fill & cap), and FCAW 4G touch-up (if required). When defects are located in the lower portions of the weld and the repair can be accomplished overhead with no more than one (1) pass of FCAW, such as this one, we have also enjoyed success.

Because of the depth of this defect, USI proposes repairing with FCAW from underneath.

RECOMMENDED DISPOSITION:

1. QC to verify and layout defect locations.
2. Preheat to 150 degrees F for excavations where CAC-A is used.
3. Excavation to include at least one inch either side of each defect.
4. Prepare cavity by grinding to clean metal and properly tapering each end.
5. Call for inspection to double-check the location and to confirm that discontinuity has been removed.
6. MT the excavation to confirm that the indication has been eliminated.
7. Inform QA that weld repair is commencing.
8. Preheat per work procedure number 9.01 rev 4.
9. Weld using approved FCAW WPS.
10. Grind starts & stops and clean each weld layer between passes.
11. Post heat per work procedure number 9.01 rev 4.
12. Upon cooling to ambient temperature, QC to VT repaired area per tension criteria.
13. RT per AWS D1.5 (tension).
14. After 24 hours, UT per AWS D1.5 (tension).

CORPORATE QC MANAGER Keith Stephenson <i>[Signature]</i>	DATE 5/13/05	PLANT MANAGER Ralph Seeley	DATE 5/13/05
DISPOSITION COMPLETED:		DATE	
FINAL REVIEW <i>[Signature]</i>		MAY 27 2005	

Comments:

Verbal OK to proceed with repairs from Caltrans with concerns about high number of repairs

5-19-05 JH

RECEIVED
 1500
 MAY 27 2005
 BY: *[Signature]*

BL

DEPARTMENT OF TRANSPORTATION

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



Flex Your Power
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June 22, 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 # 5.03.1-008092

Subject: Response to KFM-SUB-002857R01, KFM-SUB-003405R02, KFM-SUB-003660R03, KFM-SUB-003669R02, KFM-SUB-003703R03, KFM-SUB-003747R02, KFM-SUB-003763R03, KFM-SUB-003773R10, KFM-SUB-003804R05, KFM-SUB-003912R03, KFM-SUB-003931R03, KFM-SUB-003958R01

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

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

- KFM-SUB-002857R01: USI Documents Clearing Critical Weld Repair 04-58
- KFM-SUB-003405R02: USI Documents Clearing Critical Weld Repair 04-135R1
- KFM-SUB-003660R03: USI Documents Clearing Critical Weld Repair 05-008R2
- KFM-SUB-003669R02: USI Documents Clearing Critical Weld Repair 05-011R1
- KFM-SUB-003703R03: USI Documents Clearing Critical Weld Repair 05-015R2
- KFM-SUB-003747R02: USI Documents Clearing Critical Weld Repair 05-025R1
- KFM-SUB-003763R03: USI Documents Clearing Critical Weld Repair 05-027R2
- KFM-SUB-003773R10: USI Documents Clearing Critical Weld Repair 05-029R8
- KFM-SUB-003804R05: USI Documents Clearing Critical Weld Repair 05-033R4
- KFM-SUB-003912R03: USI Documents Clearing Critical Weld Repair 05-050R2
- KFM-SUB-003931R03: USI Documents Clearing Critical Weld Repair 05-052R1A1
- KFM-SUB-003958R01: USI Documents Clearing Critical Weld Repair 05-062

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, 9.06.8

DEPARTMENT OF TRANSPORTATION

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



*Flex Your Power
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August 19, 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 # 5.03.1-008516

Subject: Response to KFM-SUB-003195R03 KFM-SUB-004086R01, KFM-SUB-004779R00, KFM-SUB-004529R01, KFM-SUB-004834R00, KFM-SUB-004831R00, KFM-SUB-004336R05, KFM-SUB-004892R00, KFM-SUB-004996R00, KFM-SUB-004997R00, KFM-SUB-004998R00, KFM-SUB-004999R00

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

The Engineer has reviewed the following submittals which are approved:

- KFM-SUB-003195R03: USI Documents Clearing Critical Weld Repair 04-83
- KFM-SUB-004086R01: USI Documents Clearing Critical Weld Repair Report 05-88
- KFM-SUB-004779R00: USI Documents Clearing NCR 156 (METS NCR 146)
- KFM-SUB-004529R01: USI Closing Documents for KFM NCR 133 (METS NCR 120) – Response to STL 8112
- KFM-SUB-004834R00: Documents Clearing KFM USI NCR 170 (METS 160)
- KFM-SUB-004831R00: Documents Clearing KFM USI NCR 168 (METS NCR 158)
- KFM-SUB-004336R05: USI Documents Clearing CWR 05-159R5
- KFM-SUB-004892R00: USI Documents Clearing NCR 101 (METS 86)
- KFM-SUB-004996R00: USI Documents Clearing NCR 176 (METS NCR 165)
- KFM-SUB-004997R00: USI Documents Clearing KFM/OIW NCR 177 (METS NCR 164)
- KFM-SUB-004998R00: USI Documents Clearing KFM/OIW NCR 183 (METS NCR 173)
- KFM-SUB-004999R00: USI Documents Clearing KFM NCR 175 (METS 162)

State Letter #:5.03.1-008516
KFM, a JV
August 19, 2005
Page 2 of 2

Contract: 04-012024
04-SF, Ala-80-13.9/14.3, 0.0/1.6
SFOBB Skyway Project

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

file: 5.03.1, 9.03.8