

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

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December 07, 2007

Contract No. 04-0120F4

04-SF-80-13.2 / 13.9

Self-Anchored Suspension Bridge

Letter No. 05.03.01-000932

Michael Flowers
Project Executive
American Bridge/Fluor Enterprises, a JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

Submittal 234, Rev 5 - Dimensional Control Plan

The Department has completed review of Submittal ABF-SUB-000234R05, "Dimensional Control Plan for OBG & Crossbeams – Corner Section, OBG and Crossbeam," dated November 19, 2007. The submittal is "Returned for Correction," based upon the following comments:

CATEGORY A:

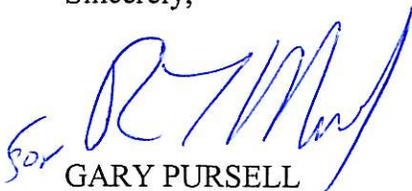
1. The template shown does not address the matching of the corner section to the OBG. This is a three dimensional rigid assembly with multiple plates matching to the independently fabricated OBG. The Contractor must describe a procedure for controlling and verifying tolerances which will allow fit-up of adjoining members. The Department takes no exception to unwelded ends of plates and stiffeners as a shop practice, however, this is not an acceptable method to control for alignment. You are also cautioned that corrections to the stiffened skin plates (if vertically misaligned at the ends) by using the AWS D1.5, Section 3.3 tolerances, will produce unacceptable stresses in the stiffeners and their correction will prove nearly impossible at the rigid corners of the box.
2. This submittal, including the associated "Response to Comments," does not adequately address the Department's previous comment regarding the lift length tolerance (+/- 20mm). Given such large variations in the lengths of individual lifts, the Contractor needs to explain how alignment and camber will be achieved between adjoining lifts.
3. As stated in State Letter 5.03.01.000782, this portion of the Dimensional Control Plan (DCP) will not be approved until the Dimensional Verification Plan (DVP) is approved, as the two documents must relate. An informational copy of the box girder DVP was transmitted to the Department. This plan appears to be incomplete and does not state how the required geometry will be verified (refer to similar comments in the Department's response to the Tower DVP).
4. Provide the tolerances for diaphragm locations and alignment to the OBG in order to achieve the overall geometry. Similarly, provide the tolerance for the crossbeam plates and alignment to the OBG (See Comment 1).

5. The length between suspender brackets (dimension L1) needs to reference the overall suspender bracket layout and reference the DVP for checking the final location of the suspender brackets.
6. Section D-D is not shown anywhere. Please provide.
7. The Department previously commented that wherever non-metric dimensional tolerances are shown, they shall be changed to metric. Please address this comment.

In addition to addressing the comments provided in this letter, the Department's representatives in Shanghai request a meeting with ABF and ZPMC to discuss issues regarding the information provided in this submittal.

If you have any questions, please contact Gary Lai in the Working Drawing Campus.

Sincerely,


GARY PURSELL
Resident Engineer

cc: Rick Morrow, Brian Boal, Patrick Lowry, Keith Devonport
file: 05.03.01, 55.0234