

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

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November 7, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.01-002934

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

Dear Michael Flowers,

Submittal 872 - Freehand Flame Cutting Shop Procedure - ZPMC Fabrication Procedure

The Department has completed review of Submittal ABF-SUB-000872R00, "Freehand Flame Cutting Shop Procedure - ZPMC Fabrication Procedure," dated October 13, 2008. The submittal is "Returned for Correction," as outlined by the following comments:

CATEGORY A:

1. Freehand thermal cutting shall only be done where the Engineer has given prior approval in writing.
2. **Item 1:**
 - a. Specify the range of plate thickness for which this procedure will be used.
 - b. Where flame cutting is performed at locations in the vicinity of other plates, specify the types of measures that will be used to protect these plates.
 - c. Approval for this procedure and those individuals who perform freehand flame cutting shall be proved by trials as agreed to by the Engineer.
3. **Item 2:** Revise the 3-mm width. This dimension will be approved based on the trials described above and may vary for different plate thicknesses. It is understood that "cutting line" refers to the "finish line" at the final surface of the cut after grinding.
4. **Item 3:** Specify a procedure to address treatment of material discontinuities exposed by thermal cutting. This must reference requirements of D1.5 (2002) sections 3.2.2.1 (p.50) and 3.2.3 (p.49).
5. **Item 4:** Insert the phrase, "*in the material edges*" before the phrase, "*which are not subsequently welded*" to reflect the D1.5 requirement.
6. **Item 5:** Provide a note that the maximum roughness for flame cut surfaces shall meet the requirements of D1.5 section 3.2.3 (p.49).

If you have any questions, please contact the Department's representatives in Shanghai, China.

Sincerely,



GARY PURSELL
Resident Engineer

cc: Rick Morrow
Brian Boal
Jason Tom
Stanley Ku
Scott Kennedy
Doug Coe
file: 05.03.01, 55.0872