

**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program**

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September 09, 2008

Contract No. 04-0120F4  
04-SF-80-13.2 / 13.9  
Self-Anchored Suspension Bridge  
Letter No. 05.03.08-000006

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

Dear Michael Flowers,

**Deck Panel Tack Weld Repair and Acceptance Criteria**

As a follow up to State Letter #2626 dated August 28, 2008, A Way Forward for Successful OBG Assembly and in response to several discussions and meetings between ABF and Caltrans, this letter serves as an understanding to the repair of the tack weld defects in the OBG deck panels already produced.

The internal repairs in the tack welds will be resolved as follows:

1. ABF will implement the internal repair procedure as proposed in submittal ABF-SUB-0006334R02 approved by the Department on July 30, 2008
2. Acceptance criteria shall include acceptable visual profile, minimum 80% depth of penetration and no detection of cracks within the 80% DOP. The inspection methods used will be visual inspection, conventional UT procedure for LOP, the prescreening procedure with the modified UT procedure (gate to gate), and the phased array procedure utilized for initial crack detection will be used only to confirm if the modified UT procedure indicates the possible presence of cracks.

The repair of the DP super panels (DP#025, DP#026, DP#027, DP#065, DP#066, and DP #067) except for where diaphragms cover certain tack welds may also be repaired with the approved procedures. However, some of the repairs may require certification for welders welding in the overhead position. This certification should be administrable in hours.

If you have questions, please contact Jason Tom.

Sincerely,

**<<< ORIGINAL SIGNED >>>**

GARY PURSELL  
Resident Engineer

cc: Rick Morrow, Jason Tom, Peter Siegenthaler, Doug Coe  
file: 05.03.08