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Phone (510) 419-0120/ Fax (510) 839-0666

**Request for Information (RFI) Report**  
**KFM Skyway Project # 04-012024**

*Run Date 12-Aug-03*  
*Time 2:51 PM*

Dated: 12-Aug-2003  
To: Doug Coe  
Caltrans-Skyway Project  
345 Burma Road  
Oakland CA 94607  
Phone: (510) 622-5100 Fax: (510) 622-5165  
RFI No: KFM-RFI-000848 Rev: 00  
Co/Job # 364-3726  
Contract # 04-012024  
Sub/Supplier: AME  
Sub/Supplier No: 6D

Date Requested By: 19-Aug-2003 Group: FND

Subject: Ameron RFI 6D - Ameron NCR on E5E-1G.

Drawing No. Ref: Specification Ref: 08-3.01  
Other:  
Resubmittal/Supplement Ref:

Description (Attachments As Needed):  
Please See Attached AME RFI 6D and Respond

Potential Time Impact? No Potential Cost Impact? No Schedule Activity ID#:  
General Explanation of Potential Impact (If Required):

Response (Attachments As Required):

Answered By: Date Answered:

CC:

Prepared By: Chris Webb  
Originator

Reviewed By: *Rich Bienek*  
Rich Bienek

Reviewed By: *Jim Hayward* for *John Hassard*  
John Hassard

Submitted By: *C. [Signature]*  
Contract Admin/DCS Staff

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56,848



**AMERON**  
INTERNATIONAL

**WATER TRANSMISSION  
GROUP**

13032 Slover Avenue  
Fontana, California 92337  
Telephone: (909) 822-1280  
Fax: (909) 356-8816

**REQUEST FOR INFORMATION**

Project: San Francisco/Oakland Bay Bridge

RFI: 6D

Contract No.: 04-12024

Date: August 12 2003

To: **Richard Bienek**  
KFM, a JV  
2405 W. 14th St.  
Oakland, CA 94607

Originator: David Valerio

Subject: Request For Approval

**Resolution:**

To Caltrans NCR for Welding Out of the WPS 174B perimeters:

Reference: Ameron Dwgs E988-5A, R1 AND E988-50, R5, WPS 174B

Pile Section E5E-1G, Girth Weld # 4 is a 2.52" to 2.52" joint, was fit-up with the transition bevel for 2" to 2.52", see page 2 of 2, and welded.

Ameron is requesting approval of this welded joint as is, the joint has been RT using Real Time and found acceptable by Caltrans Inspection. Ameron shall further qualify the weld joint, if deemed necessary, by 100% UT Inspection.

Your prompt attention to this request is greatly appreciated.

Sincerely,

*David A. Valerio*

David Valerio  
QC Supervisor



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Project: San Francisco/Oakland Bay Bridge

RFI: 6D

Contract No.: 04-12024

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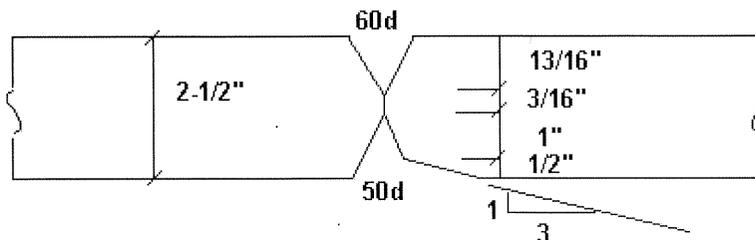
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Subject: Request For Approval

**SAN FRANCISCO OAKLAND BAY BRIDGE  
CALTRANS CONTRACT NO. 04012024**

**Detail Drawing Reference E988-50  
Edge Preparation for 2-1/2" Thickness**



**WELDING PROCEDURE SPECIFICATION (WPS) Yes**   
**PREQUALIFIED  QUALIFIED BY TESTING**   
**or PROCEDURE QUALIFICATION RECORDS (PQR) Yes**

Company Name: AMERON INTERNATIONAL  
Welding Process(es): SAW  
Supporting PQR No.(s): 174B

WPS #: 174B  
Revision: 0  
Authorized by: DAV  
Type ---Manual   
Machine   
Date: 5/16/03 By: DAV  
Date: 5/16/03  
Semi-automatic   
Automatic

**JOINT DESIGN USED**

Type: VEE GROOVE  
Single  Double Weld   
Backing: Yes  No   
Backing Material: BASE METAL  
Root Opening: 1/16" Root Face Dimension: 3/16"  
Groove Angle: 50,60 INCL Radius (J or U): NA  
Back Gouging: Yes  No  Method: ARC GOUGE

**BASE METALS**

Material Specification: ASTM A709  
Type or Grade: 50  
Thickness: Groove: >1 1/2" Fillet: SAME  
Diameter (Pipe): >=24" DIA

**FILLER METALS**

AWS Specification: A5.17  
AWS Classification: EM12K

**SHIELDING**

Flux  Gas   
Comp: Flow Rate: Gas Cup Size:  
Electrode-Flux Class (SAW): FA2-EM12K  
Lincoln L61-860 Flux

**PREHEAT**

Preheat Temp. Min.: 150F >1 1/2" thru 2 1/2", 225F >2 1/2"  
Interpass Temperature Min.: Same Max.: 600

**POSITION**

Position of Groove: FLAT Fillet Weld: FLAT  
Vertical Progression: Up  Down

**ELECTRICAL CHARACTERISTICS**

Transfer Mode (GMAW) Short-Circuiting   
Globular  Spray   
Current: AC  DCEP  DCEN  Pulsed   
Other: DC LEAD AND AC TRAIL  
Tungsten Electrode (GTAW)  
Size: Type:

**TECHNIQUE**

Stringer or Weave Bead: STRINGER  
Multi-pass or Single Pass (per side): MULTI-PASS  
Number of Electrodes: TWO  
Electrode Spacing - Longitudinal: 7/8"  
Lateral: NA  
Angle: 90

**Contact Tube to Work Distance:**

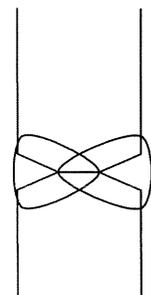
Peening: Yes  No   
Interpass Cleaning: NO

**POSTWELD HEAT TREATMENT**

Temperature: NA  
Time: NA

Pass or Weld Layers	Process	Filler Metals		Current		Volts	Travel Speed IPM
		Class	Diam.	Type\$ Polarity	Ampsor WFS		
<b>SIDE 1</b>							
PASS 1	SAW	EM12K	5/32"	DCEP	366-447	26.0-29.9	22.1-29.9
PASS 2	SAW	EM12K	5/32"	DCEP	472-577	27.9-32.1	22.1-29.9
PASS 3 LEAD	SAW	EM12K	5/32"	DCEP	472-577	27.9-32.1	22.1-29.9
PASS 3 TRAIL	SAW	EM12K	5/32"	AC	540-660	35.3-40.6	22.1-29.9
PASS 4 LEAD	SAW	EM12K	5/32"	DCEP	540-660	29.7-34.2	22.1-29.9
PASS 4 TRAIL	SAW	EM12K	5/32"	AC	585-715	37.2-42.8	22.1-29.9
PASS 5 LEAD	SAW	BM12K	5/32"	DCEP	585-715	29.7-34.2	22.1-29.9
PASS 5 TRAIL	SAW	BM12K	5/32"	AC	630-770	39.0-44.9	22.1-29.9
PASS 6-10							
LEAD	SAW	EM12K	5/32"	DCEP	630-770	30.6-35.3	22.1-29.9
TRAIL	SAW	EM12K	5/32"	AC	679-830	39.9-46.0	22.1-29.9
PASS 11-13							
LEAD	SAW	EM12K	5/32"	DCEP	450-550	30.6-35.3	22.1-29.9
TRAIL	SAW	EM12K	5/32"	AC	499-610	39.9-46.0	22.1-29.9

- Sketch**
- Notes:
- Incl. Angle  
1<sup>st</sup> side - 50d +/-  
2<sup>nd</sup> side - 60d +/-
  - Root opening - 1/16" +/-
  - Root Face - 3/16" +/-
  - Electrode Ext. - 1 1/4" +/-



Layers	Process	Filler Metals		Current		Volts	Travel Speed IPM
		Class	Diam.	Type \$ Polarity	Amps or WFS		
<b>SIDE 2</b>							
PASS 1 LEAD	SAW	EM12K	5/32"	DCEP	450-550	26.0-29.9	22.9-31.0
PASS 1 TRAIL	SAW	EM12K	5/32"	AC	499-610	35.3-40.6	22.9-31.0
PASS 2 LEAD	SAW	EM12K	5/32"	DCEP	499-610	26.9-31.0	22.9-31.0
PASS 2 TRAIL	SAW	EM12K	5/32"	AC	540-660	36.2-41.7	22.9-31.0
PASS 3 LEAD	SAW	EM12K	5/32"	DCEP	540-660	26.9-31.0	22.9-31.0
PASS 3 TRAIL	SAW	EM12K	5/32"	AC	589-720	36.2-41.7	22.9-31.0
PASS 4 LEAD	SAW	BM12K	5/32"	DCEP	589-720	29.7-34.2	22.9-31.0
PASS 4 TRAIL	SAW	BM12K	5/32"	AC	634-775	39.0-44.9	22.9-31.0
<b>PASS 5-14</b>							
LEAD	SAW	EM12K	5/32"	DCEP	630-770	30.6-35.3	22.9-31.0
TRAIL	SAW	EM12K	5/32"	AC	679-830	39.9-46.0	22.9-31.0
<b>PASS 15-17</b>							
LEAD	SAW	EM12K	5/32"	DCEP	450-550	<b>30.6-35.3</b>	22.9-31.0
TRAIL	SAW	EM12K	5/32"	AC	499-610	<b>39.9-46.0</b>	22.9-31.0

**Sketch**

Notes:

1. Incl. Angle  
1<sup>st</sup> side - 50d +/-  
2<sup>nd</sup> side - 60d +/-
2. Root opening - 1/16" +/-
3. Root Face - 3/16" +/-
4. Electrode Ext. - 1 1/4" +/-

