



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 21-Jan-05
Time 11:28 AM

Dated: 21-Jan-2005

SUBMITTAL No: KFM-SUB-003711

Rev: 00

To: Doug Coe
 Caltrans-Skyway Project
 345 Burma Road
 Oakland CA 94607
 Phone: Fax:

Co/Job # 364-3726
 Contract # 04012024
 Sub/Supplier: USI
 Sub/Supplier No:

Subject: USI - Documents Clearing USI KFM NCR #64 (METS 50)

Special Provis. (SP) REF: 08-3.01
 Standard Spec. (SS) REF:

RESUBMITTAL/SUPPLEMENTAL REF:

We are sending the following attached items: Attached

Via Fax

- | | | |
|---------------------------------------|---|---|
| <input type="checkbox"/> Drawing | <input type="checkbox"/> Plans | <input type="checkbox"/> Prog. Pmt |
| <input type="checkbox"/> Samples | <input type="checkbox"/> Certificates of Compliance | <input type="checkbox"/> Calculations |
| <input type="checkbox"/> Payroll | <input type="checkbox"/> Specs | <input type="checkbox"/> copy of Letter |
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Schedule | <input type="checkbox"/> Invoice |

Rem	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	21-Jan-05	1	Letter of Transmittal#246		0	Pending	1
02	21-Jan-05	1	USI - Documents Clearing USI W/M NCR #64 (METS 50)		0	Pending	20

These are transmitted as checked below:

- | | | |
|--|---|--|
| <input checked="" type="checkbox"/> For Approval | <input type="checkbox"/> For Review/comment | <input type="checkbox"/> Return For Correction |
| <input type="checkbox"/> For Your Use | <input type="checkbox"/> As Requested | <input type="checkbox"/> For Information |

Remarks:

CC:

Please review / approve by : 28-Jan-2005

Submitted By: Rich Bienek
 (KFM Staff Member - Originator of Transmittal)

Checked & Sent By:
 Contract Admin/DCS Staff

Universal Structural, Inc.

a subsidiary of

HARDER MECHANICAL CONTRACTORS, INC.

604 S.E. Victory Avenue, Vancouver, WA. 98661

P.O. Box 1030, Vancouver, WA. 98666

Phone: Vancouver (360) 695-1261 - Portland (503) 227-2419

Fax: (360) 696-3590

LETTER OF TRANSMITTAL

NO: 246

DATE: January 19, 2005

PROJECT: SFOBB Skyway Structure

JOB NO: 23932

ATTENTION: Paul Hegarty / Rich Bienek

TO: KFM

220 Burma Road
Oakland, CA 94607

WE ARE SENDING YOU

- | | | | |
|---|---------------------------------------|---------------------------------------|---|
| <input type="checkbox"/> Shop Drawings | <input type="checkbox"/> ATTACHED | <input type="checkbox"/> Prints | <input type="checkbox"/> NCR Responses |
| <input type="checkbox"/> copy of letter | <input type="checkbox"/> Change order | <input type="checkbox"/> Change order | <input type="checkbox"/> Samples |
| | | <input type="checkbox"/> Plans | <input type="checkbox"/> Specifications |

1 Original	NCR Response	Caltrans State Letter # 5.03.01-006105
		USI Letter # 73.011705
		KFM NCR # 73
1 Original	NCR Response	Caltrans State Letter # 5.03.01-005899
		USI Letter # 64.011705
		KFM NCR # 64

SKYWAY BAY BRIDGE PROJECT

KIEWIT / FCI / MANSON, A JV

DATE: 1-21-05	CO/JOB: 364-3726
ROUTED BY:	NO. 04-012024
TO: RICH BIENEK	SPECIAL NOTES:

INTERNAL KFM COPIES TO:

--	--	--	--	--	--	--	--	--	--

EXTERNAL COPIES TO:

--	--	--	--	--	--	--	--	--	--

SCANNED: Y N FILED TO:

- For Approval
 For your use
 As Requested
 FOR BIDS DUE

REMARKS:

Copy To:

Signed:

Brad Murphy
Brad Murphy

If enclosures are not as noted, kindly notify us at once.



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

January 17, 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# 64.011705)

Subject: Response to Caltrans State Letter # 5.03.01-005899, DTD 10/25/04
KFM NCR # 64

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc received Caltrans State Letter # 5.03.01-005899, dated October 25, 2004.
Caltrans state that:

"KFM's QCM and onsite representative allowed USI to deviate from the approved fabrication procedures without the Engineer's approval. During the fabrication of web plates pa49 and pa50, the Contractor did not complete steps 75 and 25 of the Fabrication Procedures, Section III, Subparagraph 1."

Please review the following information:

- Copy of Caltrans State Letter # 5.03.1-005899
- Copy of **USI's** Letter of Response
- Copy of Dimensional Check Set 1 drawing, Web Plate Assembly pa49
- Copy of Dimensional Check Set 2 drawing, Web Plate Assembly pa49, with note on Check #5 "Check 5 comp. pending revised fab plan, Incident Report 113 filed 10-15-04"
- Copy of USI's - Internal Incident No. 113 (with note "...distortion will no longer be out of tolerance when the web is fit to the soffit")
- Copy of pa49 weld distortion sketch
- Copy of Dimensional Check Set 1 drawing, Web Plate Assembly pa50, with a note on Check #2 - Reject, (USI Internal) NCR 38
- Copy of USI's - Internal Incident No. 38 Rev. 1, that reference's HSR 04-34
- Copy of **USI's** cover letter for HSR 04-34
- Copy of Caltrans State Letter # 5.03.1-005848 (approving Heat Straightening)



Category III

A Subsidiary of
HARDER MECHANICAL CONTRACTORS



UNIVERSAL STRUCTURAL, INC.

SFOBB Skyway Project
USI# 23932

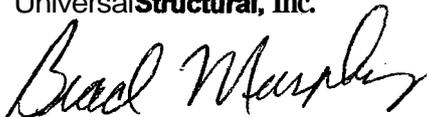
January 19, 2005

- Copy of USI's - Heat Straightening Request 04-34 (verbal OK)
- Copy of USI's - Magnetic Particle Test Report (Accept)
- Copy of sketch, pa pa50 (distortion)
- Copy of sketch, pa pa50 (Heat Straightening complete)
- Copy of Dimensional Check Set 2 drawing, Web Plate Assembly pa50, with note on Check #5 "Check 5 complete pending revised fab plan - Incident Report 114 filed 10-15-04"
- Copy of USI's - Internal Incident No. 114 (with note "...distortion will no longer be out of tolerance when the web is fit to the soffit")
- Copy of pa50 weld distortion sketch

USI continues to strive for fabrication excellence and will diligently work with METS/Caltrans in documenting all requirements for this project (as noted in the attachments enclosed). It is USI's goal to keep our Fabrication Plan updated (up to Revision 14, which now includes implementing a "Traveler"). Please review the enclosed information and request 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.**



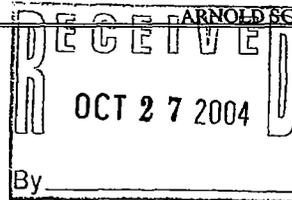
Brad Murphy
Sales Manager

cc: Brad Young - USI
file

BLPH
10/26/04

DEPARTMENT OF TRANSPORTATION

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



Flex Your Power
Be Energy Efficient!

October 25, 2004

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 # 5.03.1-005899

Subject: KFM/USI NCR No. 50: Deviating from Approved Fabrication Procedures (Fabrication of web plates pa49 and pa50)

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

This Non-Conformance Report (NCR) is issued by the State to KFM for the following reason:

- 1. KFM's **QCM** and onsite representatives allowed USI to deviate from the approved fabrication procedures without the Engineer's approval. During the fabrication of web plates pa49 and pa50, the Contractor did not complete steps 15 and 25 of the Fabrication Procedures, Section III, Subparagraph I.

This NCR will be tracked as **KFM/USI NCR No. 50**. KFM was verbally notified of this NCR by Caltrans' METS on 10/19/04. 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
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

December 15, 2004

KFM
220 Burma Road
Oakland, California 94623



Attn: Mr. Paul Hegarty

Re: State letter no. **5.03.01-005899**, WM NCR **64**, **USI** NCR No. 50,
regarding web plates **pa49** and **pa50**.

Mr. Hegarty & Mr. Bienek,

Please reference **USI/NCR** reply to State letter 5.03.1-005900, KFM NCR 65. The dimensional check information required for step 15 of the Fabrication Plan is included in that NCR reply. This information was completed on girders 3A and 4A as required by the Fabrication Plan Revision 12. **USI** informed Caltrans personnel that it had encountered a dimensional check noted in Revision 12 that was not required at that particular time. This check was shown in the Fabrication Plan to be performed prior to any attachments being fit or welded. Once this situation had been encountered, it was obvious that a check being performed prior to the addition of any attachments and final heat application from welding to the panels would be worthless information.

Dimensional checks being performed after welding as indicated in step 25 of the Fabrication Plan has also been performed and noted in the Checker Set. Once **USI** had been informed that even though notification had been given for a revision to the Fabrication Plan as previously agreed, Caltrans would be writing an NCR, **USI** went ahead and measured the panels at that time. Even though this information was of no value **USI** was attempting to avoid this NCR.

Obviously Caltrans expects **USI** to continue performing work according to the Fabrication Plan even when it is in error. We can only assume that those individuals that wrote the Special Provisions were requiring a Fabrication Plan because it can be a very useful tool for the fabricator and help the engineer identify any concerns, such as handling issues that may need further clarification. Using the Fabrication Plan as a tool to issue NCR's does not make the Plan an effective tool to anyone involved. If a Fabrication Plan does not have flexibility that promotes efficient and effective fabrication processes, it becomes useless and a detriment to the project.

All issues on State letter no. 5.03. 01-005899, regarding Dimensional Checks are in accordance with USI Fabrication Plan are in compliance.

If you have any questions or need further clarification, please contact me immediately.

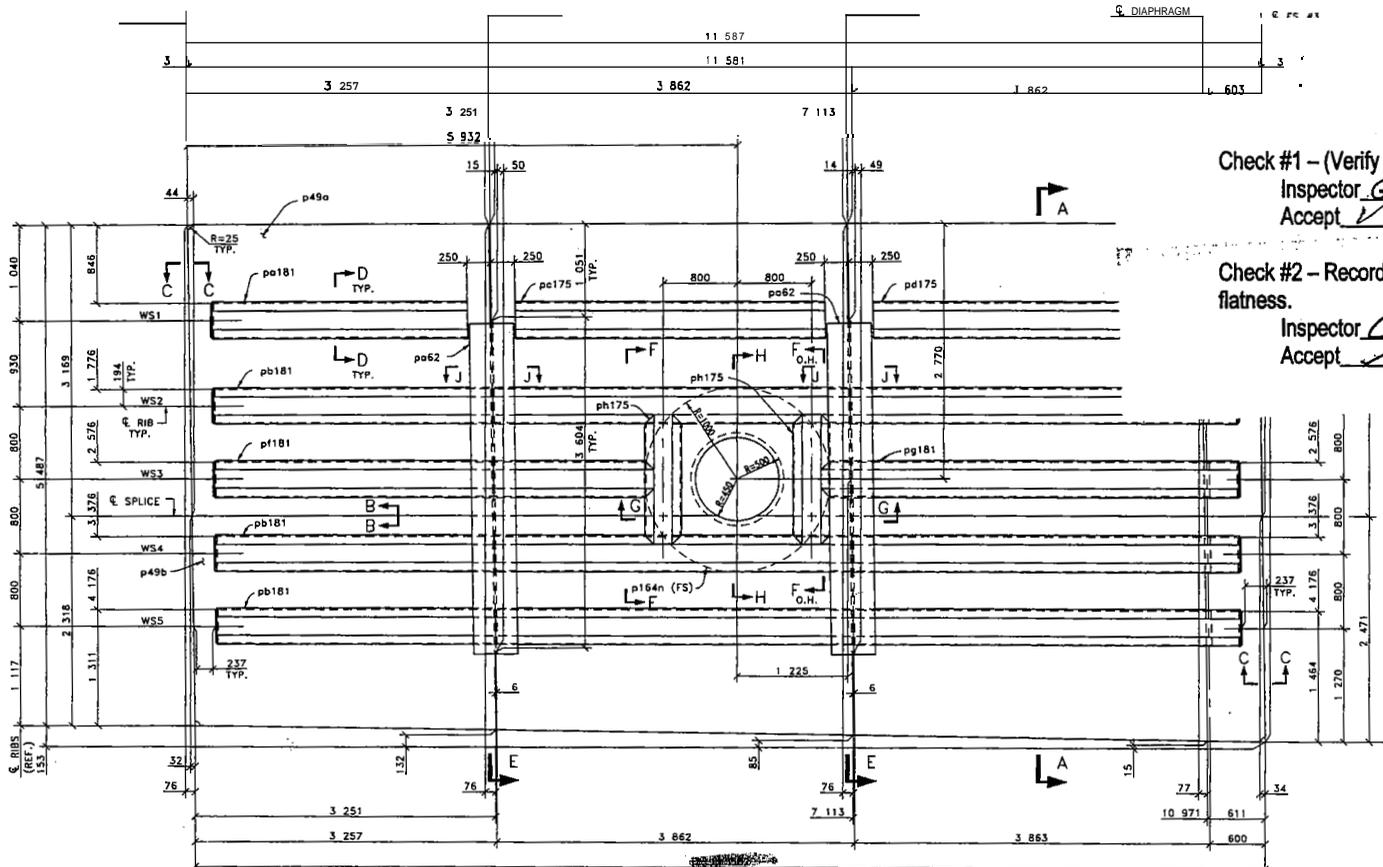
Sincerely,

Universal Structural, Inc.

Ralph Seeley
Plant Manager

cc:   file

E:\USERS\ROBERTO GATEKEEPER\BRIDGE SKYWAY\LINE WEB PLATE ASSEMBLY (ASSY) (DIM) (DWD) (DWG) 7 IN. BY 11.0 IN. DATE: 09/19/02

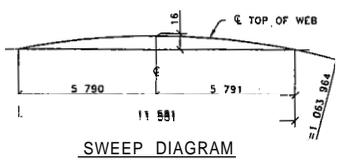
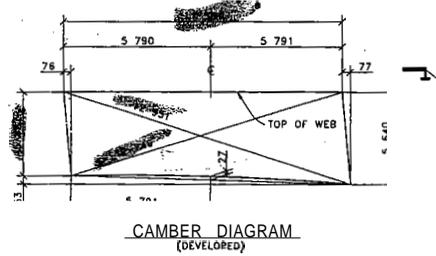


Check #1 - (Verify fit-up prior to welding butt welds.)
 Inspector George Mason Date 7/26/04
 Accept Reject NCR#(s) _____

Check #2 - Record overall dimensions, crosschecks and any out of tolerance flatness.
 Inspector George Mason Date 7-31-04
 Accept Reject NCR#(s) _____

APPROVED FOR FABRICATION
 MAR 23 2004

ONE ~ WEB PLATE ASSEMBLY ~ p49



- NOTES:
- 1) FOR GENERAL NOTES SEE 041
 - 2) FOR ASSEMBLY MARK LAYOUT SEE LJ
 - 3) FOR STANDARD SEE S164, S175 & S181
 - 4) FOR CUTTING LAYOUT SEE p449, p499 & p49b
 - 5) FOR ASSEMBLY SEE 62

WORK THIS DWG WITH SHT. 49B/B

REV	REVISION	BY	DATE
1	DIMENSION WELD PREP REVISED DIM'S ADDED	RGV	07/02



SHEET TITLE: "E" LINE WEB PLATE ASSEMBLY p49 (ASSY 3A)	MATERIAL SPEC.
PROJECT: SKYWAY STRUCTURES - CONTRACT NO. 04-012021	4709M_0314512
TRANSITION SPAN - BRIDGE NO. 34-0006 L/R	ERECTION DWG.
DISTRICT 04, ROUTE 80 : KILOMETER POST 13.9/14.3, 0.0/1.6	
SAN FRANCISCO / ALAMEDA COUNTY	REF. DWG.
CUSTOMER: KFM / A JV.	
DRAWN BY: Allen Wen	DATE: 09/19/02
CHECKED BY: SIN	DATE: 11/18/02
JOE NO.	23932
SHEET NO.	49A/B

UNIVERSAL STRUCTURAL INCIDENT REPORT



Copies to: Step 1 - Plant Manager Superintendent
 Step 2 - OQC Manager ODepartment Head OGeneral Manager OProject Manager

Step 1 - Details of Incident:
web Pa 49 has weld distortion. (see attached sketch)

Responsible Department: _____ Department Supervisor _____

Step 2 - Corrective Action: Engineer approval required: yes no
THE PLANT MANAGER HAS REVIEWED HIS PROBLEM AND FINDS THAT THE DISTORTION WILL NO LONGER BE OUT OF TOLERANCE WHEN THE WELD IS FIT TO THE SPEC.

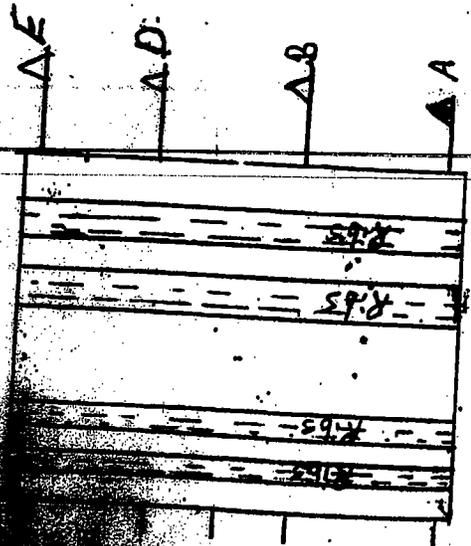
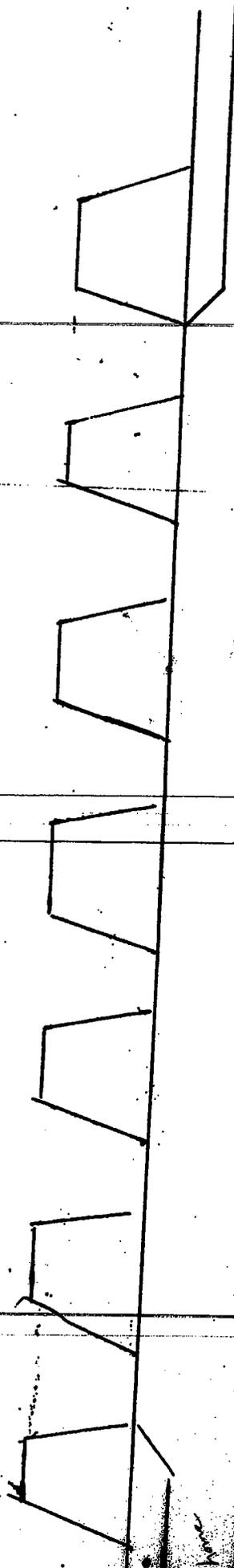
Signed: *George Mason* Date: *Oct 15, 2004*

Step 3 - Corrective Action to prevent re-occurrence:
NONE REQUIRED

Signed: *[Signature]* Date: *10/19/04*

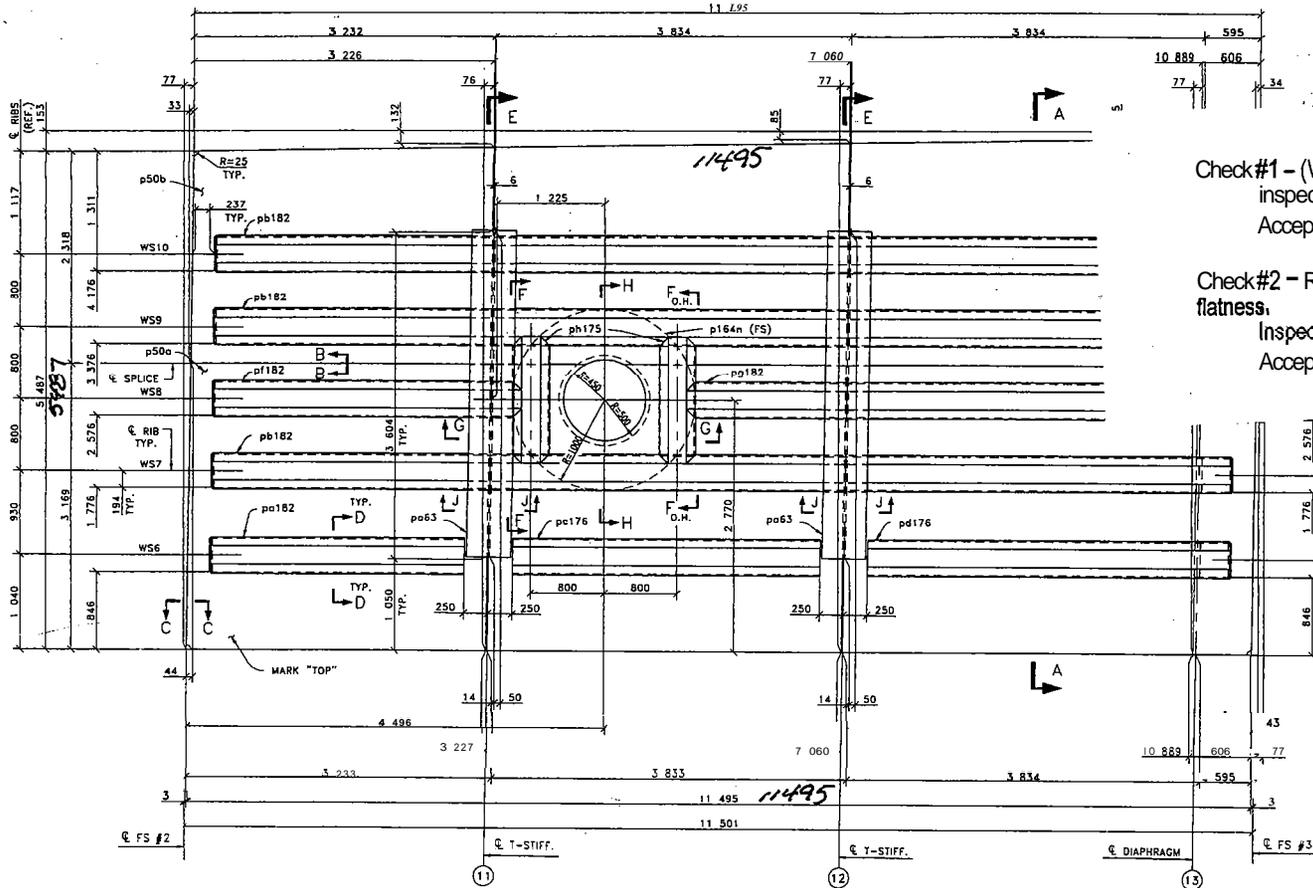
SI 4 - Action Approval:
 Approved: _____
 Not Approved, further corrective action required: _____

Weld distortion due to welding rib Pg 49



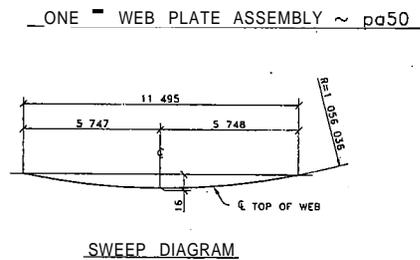
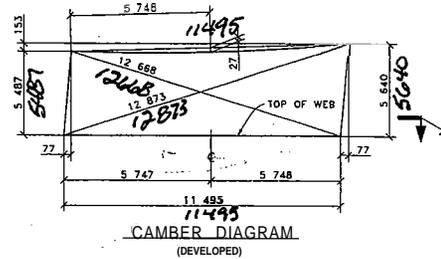
SECTION	DEVIATION FROM SQUARE				
	Original Condition	1st Heat	2nd Heat	3rd Heat	4th Heat
A-A	7	7			
B-B	6	6			
D-D	8	13			
E-E	7	13			

E:\USERS\ROBERTO GATEKEEPER\BRIDGE SKYWAY\1' LINE\1' LINE ASSEMBLY\ASSY 3A\DWG\0050A_A.DWG 7-17-03 2:03:32 PM EST



Check #1 - (Verify fit-up prior to welding butt welds.)
 inspector George Mason Date 7/27/04
 Accept Reject NCR#(s) _____

Check #2 - Record overall dimensions, crosschecks and any out of tolerance flatness.
 Inspector John P. Smith Date 7-30-04
 Accept Reject NCR#(s) 38



- NOTES:
- 1) FOR GENERAL NOTES SEE GNI
 - 2) FOR ASSEMBLY MARK LAYOUT SEE LI
 - 3) FOR STANCHION SEE S184, S176, S176 & S182
 - 4) FOR CUTTING LAYOUT SEE pa50, p50a & p50b
 - 5) FOR ASSEMBLY SEE 63

WORK THIS DWG WITH SHT. 50B/B

APPROVED FOR FABRICATION
 MAR 23 2004

REV	REVISION	BY	DATE
	DIMENSIONS ADDED. DIMENSION & WELD PREP REVISED	RCV	07/03
 UNIVERSAL STRUCTURAL, INC. VANCOUVER, WASHINGTON			
SHEET TITLE: E' LINE WEB PLATE ASSEMBLY ~ pa50 (ASS'Y 3A) MATERIAL SPEC.			
PROJECT: SKYWAY STRUCTURES - CONTRACT NO. 04-012021		A709M, GR34512	
TRANSITION SPAN - BRIDGE NO. 34-0006 L/R		ERECTION DWG.	
DISTRICT 04, ROUTE 80 : KILOMETER POST 13.9/14.3,0.0/1.6			
SAN FRANCISCO / ALAMEDA COUNTY			
CUSTOMER: KFM / A JV			
DRAWN BY: <u>Allen Wen</u>		DATE: <u>09/19/02</u> JOB NO.	
CHECKED BY: <u>SIN</u>		DATE: <u>11/15/02</u> 23932	
		SHEET NO. <u>50A/B</u> REV. <u>Δ</u>	

0434

CODE _____

UNIVERSAL STRUCTURAL INCIDENT REPORT

Date: 9-29-04
 Initiator: Ken Esteb
 Job Number: 23932
 IR No.: 38 Rev. 1



Copies to: Step 1 - Plant Manager Superintendent
 Step 2 - QC Manager Department Head General Manager Project Manager

Step 1 - Details of Incident:
Web Pl. Pa50 There is a dent 380mm long by 150mm deep in top of web. 8mm max distortion. Per attached drg.

Responsible Department: _____ Department Supervisor _____
Step 2 - Corrective Action: Engineer approval required: yes no
Restrain affected area + apply 3~~7~~ strip heats as per attached sketch.
Comp. 10-12-04

Signed: Kenneth D. Esteb Date: 9-29-04

Step 3 - Corrective Action to prevent re-occurrence:

Signed: _____ Date: _____

Step 4 - Corrective Action Approval:
 Approved: _____
 Not Approved, further corrective action required: _____



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) 698-3590

December 17, 2004

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 (HSR LTR# 34.121704)

Subject: Response to Caltrans State Letter # 5.03.01-005848

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-005848, dated October 18, 2004. Caltrans stated that:

'The Engineer has reviewed KFM-SUB-002968R01:USI- Heat Straightening Request # 34 regarding the request to repair web plate pa50. The damaged web plate, pa 50 is hereby rejected in accordance with Section 55-1.04 of the Standard Specifications until such time as the Contractor can demonstrate it conforms to the contract requirements. The Contractor should nondestructively test the web along the axes of the bending in order to confirm additional damage has not occurred. After performing the nondestructive testing, the State QA inspector will observe the applications of heat in accordance with the subject submittal. The Engineer has concerns regarding the Contractor's ability to adequately handle material as noted in State Letter No. 5875.'

One line heat was applied to the bent area on pa 50 and brought it into tolerance. 100% of the heated area was Magnetic Particle Tested and had passing results.

Please see the following attachments for HSR 34 and subsequent follow up copy of USI's "Magnetic Particle Test Report."

Please submit to Caltrans and request a letter to close this HSR.

If you have any questions or need further clarification, please contact me at your earliest possible convenience.

Sincerely,
Universal Structural, Inc.

Josh Mead
U.S.I.

cc: Brad Young - USI
file



Category III

A Subsidiary of
HARDER MECHANICAL CONTRACTORS



DEPARTMENT OF TRANSPORTATION

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



*Flex Your Paver
Be Energy Efficient!*

October 18, 2004

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 # 5.03.1-005848

Subject: Response to KFM-SUB-002968R00: USI Heat Straightening Request 04-34

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

The Engineer has reviewed KFM-SUB-002968R00: USI Heat Straightening Request 04-34 regarding the request to repair web plate, pa50. The damaged web plate, pa50 is hereby rejected in accordance with Section 55-1.04 of the Standard Specifications until such time **as** the Contractor can demonstrate it **conforms** to the contract requirements. The Contractor should nondestructively test the web plate along the axes of bending in order to **confirm** additional damage has not occurred. After performing the nondestructive testing, the State QA inspector will observe the applications of heat in accordance with the subject submittal. The Engineer has concerns regarding the Contractor's ability to adequately handle material **as** noted in **State Letter** No. 5815.

Should you have any questions, please contact David Wu at (510) 622-5104.

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

file: 5.03.1, 9.06.8

Universal Structural, Inc

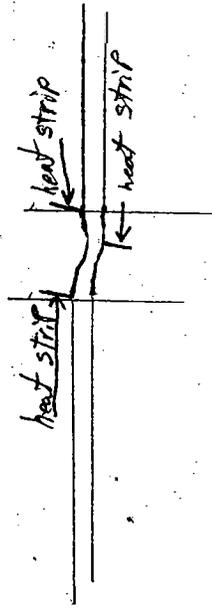
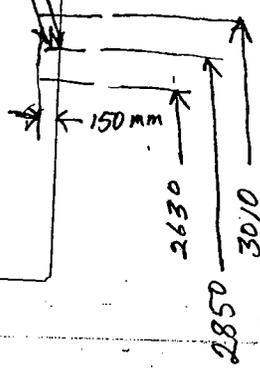
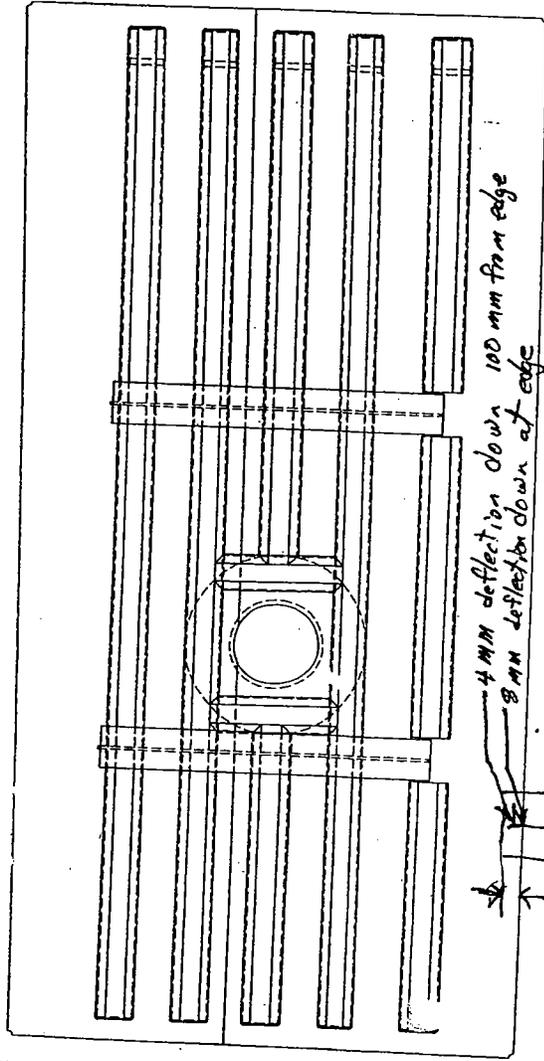
HEAT STRAIGHTENING REQUEST

DATE:	INITIATOR	DEPARTMENT:	HSR NUMBER:
Sept 29, 2004	Ralph Seeley	Production	04-34
JOB NUMBER:	JOB NAME:	DRAWING	CODE/SPECIFICATION
23932	SFOBB	50 Girder 3A	AWS D1.5
NONCONFORMANCE :			
Web PL Pa 50 has a dent 380mm long by 150mm deep in the top of the web. 8mm max distortion. This problem was caused during handling when the piece was rolled over in the welding process.			
QA MANAGER C. Amonson		DATE: 9/29/04	
RECOMMENDED DISPOSITION:			
Areas distorted shall be straightened by application of a limited amount of localized heat with minimal mechanical assistance. The temperature of heated areas shall not exceed 1100 degrees F. (600 degrees C.).			
All application of heat to base metal shall be controlled by using Temp Sticks or Thermocouples to assure that heat does not exceed allowable.			
Heat lengths will be 200mm long. Placement shown on attached sketch.			
QA MANAGER	DATE	PROJECT MANAGER	DATE
C. Amonson	9/29/04	Brad Young	9/29/04
PLANT MANAGER	DATE	KFM/QA MANAGER	DATE
Ralph Seeley	9/29/04	Rich Bienek	
PLANT MANAGER		CUSTOMER	
Ralph Seeley	DATE		DATE
FINAL REVIEW			DATE

OK TO PROCEED PER CT/QA ON 10-11-04
 RS/10-12-04

RSD
 9-29-04
 CS

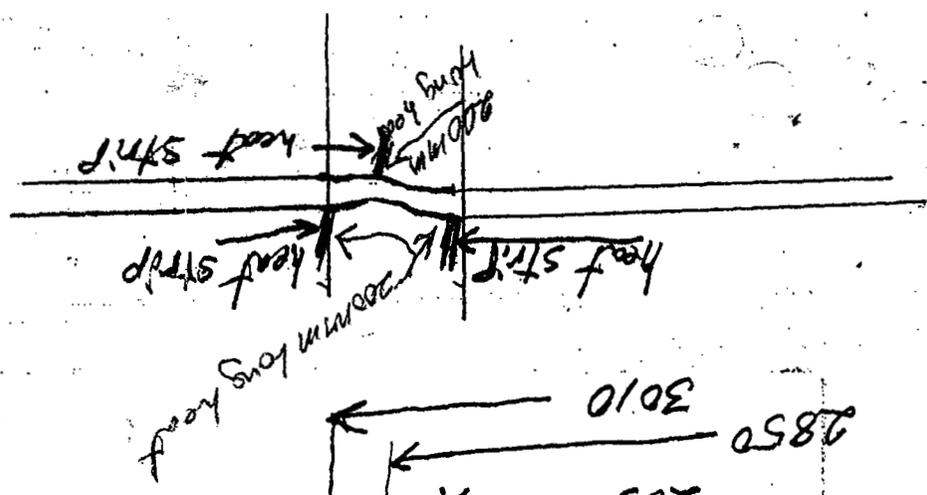
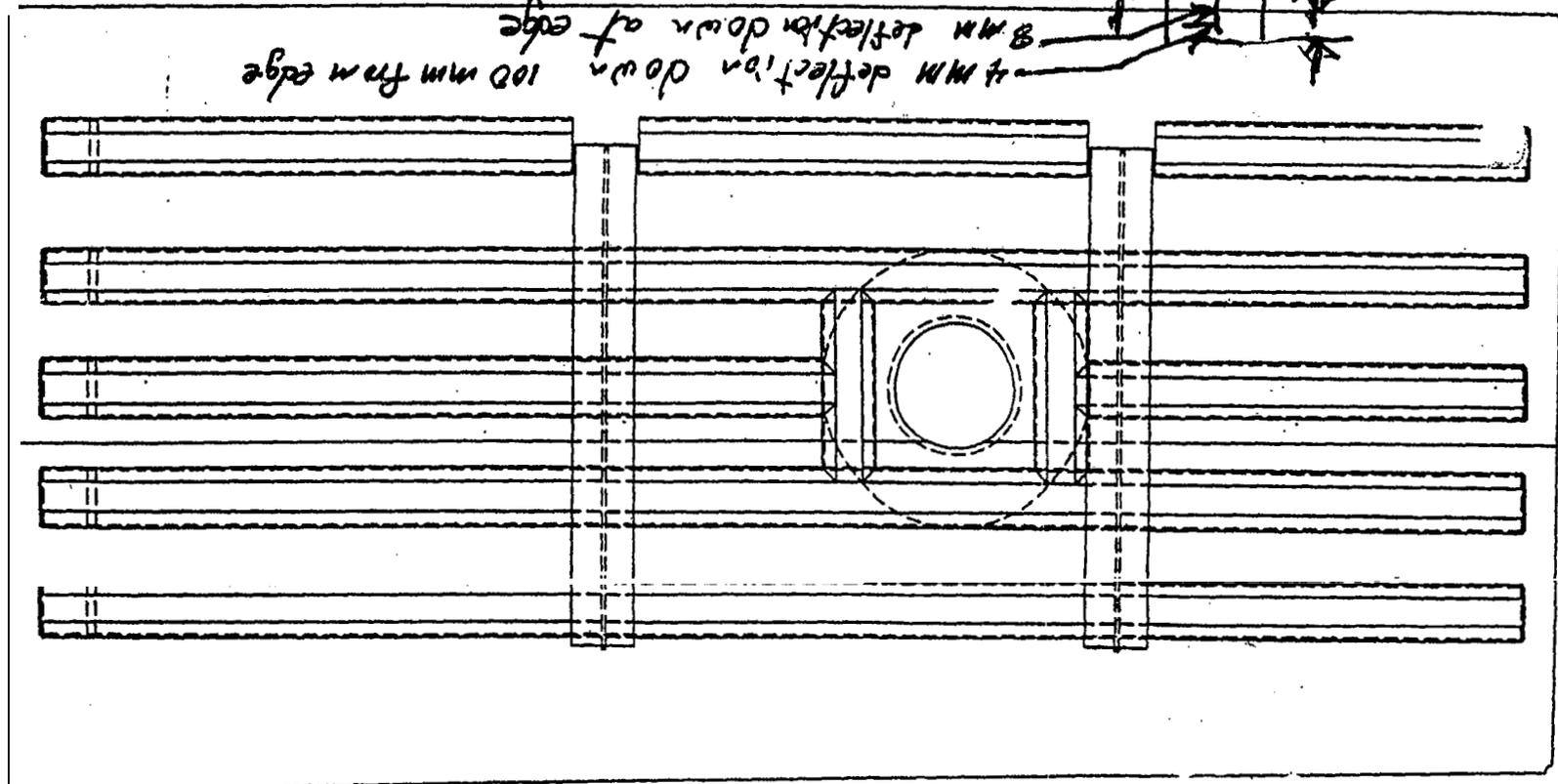
MT THE HEATED AREAS
 ADDITIONAL VERBAL FROM CT/QA RS/10-12-04



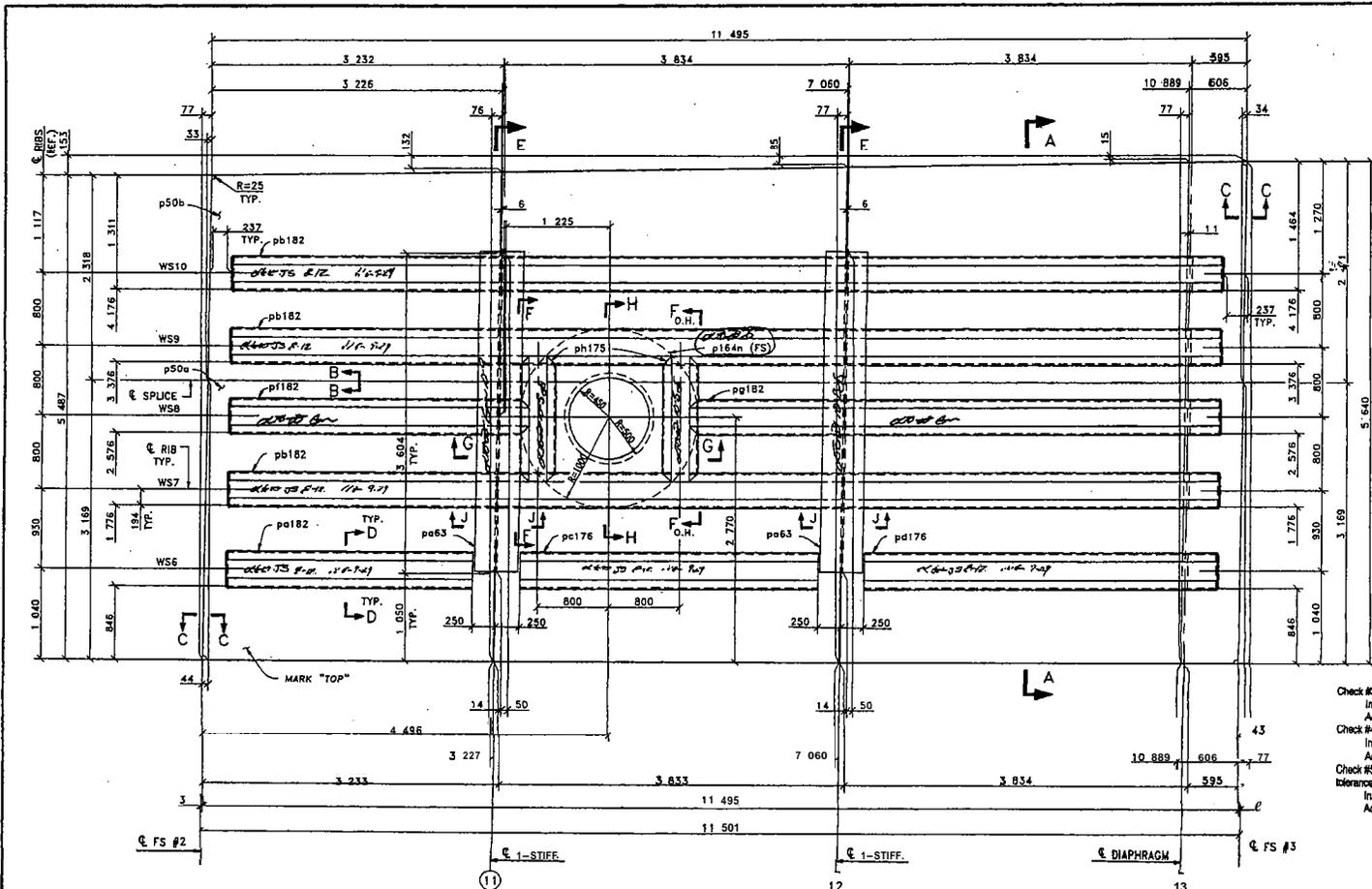
Heat Straightening Comp.
 Q.C. Notified to Mag.
 affected area. K.2
 10-12-04

1500 mm long area
 flat within 2 mm after heat

4 mm deflection down 100 mm from edge
 8 mm deflection down of edge



E:\USERS\ROBERTO GATEKEEPER\BAY BRIDGE SKYWAY\1\LINE ASSEMBLIES\ASSY 3A\DWG\00050A.A.DWG 7-17-03 2:03:32 PM EST

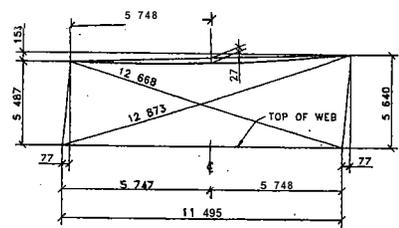


Check #3 - Verify Layout
 Inspector Jim Sutherland Date 11/15/02
 Accept Reject NCR#(s) _____

Check #4 - Verify Fit-up
 Inspector Jeff Swenson Date 10/30/02
 Accept Reject NCR#(s) _____

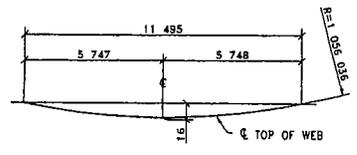
Check #5 - record all dimensions (based on centerlines) for each side. Out of tolerance deviation will be recorded using the In-house NCR.
 Inspector Jeff P. Swenson Date 10/30/02
 Accept Reject NCR#(s) 04, 05, 06, 07, 08, 09, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100

ED FOR
 ATION
 MAR 22 2004



CAMBER DIAGRAM
 (DEVELOPED)

ONE ~ WEB PLATE ASSEMBLY ~ pg50



SWEEP DIAGRAM

- NOTES:
- 1) FOR GENERAL NOTES SEE GN1
 - 2) FOR ASSEMBLY MARK LAYOUT SEE L3
 - 3) FOR STANDARD SEE 5164, 5175, 5176 & 5182
 - 4) FOR CUTTING LAYOUT SEE p050, p500 & p50b
 - 5) FOR ASSEMBLY SEE 63

WORK THIS DWG WITH SHT. 50B/B

MK	REVISION	BY	DATE
A	DIMENSIONS ADDED. DIMENSION & WELD PREP REVISED	RGV	07/03

USI UNIVERSAL STRUCTURAL, INC.	
604 S.E. VICTORY AVE. VANCOUVER, WASHINGTON	

SHEET TITLE: "E" LINE WEB PLATE ASSEMBLY ~ pg50 (ASSY 3A)	MATERIAL SPEC.
PROJECT: SKYWAY STRUCTURES - CONTRACT NO. 04-012021	A709M, GR345T2
TRANSITION SPAN - BRIDGE NO. 34-0006 L/R	ERECTION DWG.
DISTRICT 04, ROUTE 80 : KILOMETER POST 13,9/14,3,0.0/1.6	-
SAN FRANCISCO / ALAMEDA COUNTY	REF. DWG.
CUSTOMER: KFM / A JV	-
DRAWN BY: <u>Allen Wen</u>	DATE: 09/19/02
CHECKED BY: <u>SM</u>	DATE: 11/15/02
JOB NO. 23932	SHEET NO. 50A/B
REV. 1	REV. 1

UNIVERSAL STRUCTURAL INCIDENT REPORT



Date: 10.15.04
 Initiator: Jon P. Smithman
 Job Number: 23932
 IR No.: 114

Copies to: Step 1 - Plant Manager O Superintendent
 Step 2 - OQC Manager O Department Head O General Manager O Project Manager

Step 1 - Details of Incident:
WEB PLATE ASSEMBLY PASD ON GIRDER 3A HAS
WELD 2" TYP - SEE ATTACHED SKETCH

Responsible Department: _____ Department Supervisor _____

Step 2 - Corrective Action: Engineer approval required: yes no
PLANT MANAGER HAS REVIEWED THIS PROBLEM
AND CONCLUDES THAT THE DISTORTION WILL NOT
BE OUT OF TOLERANCE WHEN THE WEB IS
FIT TO THE SOFFIT.

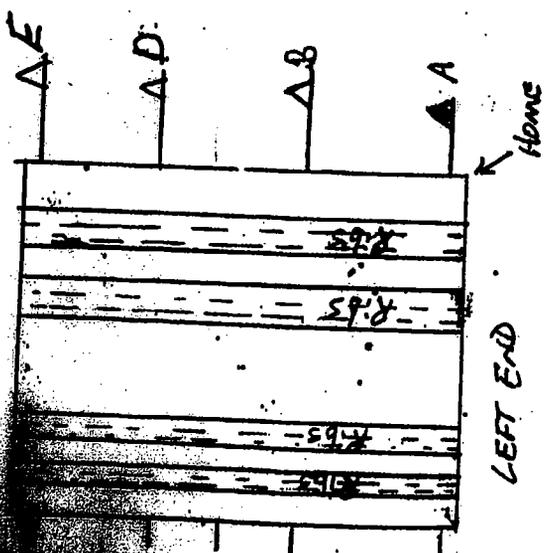
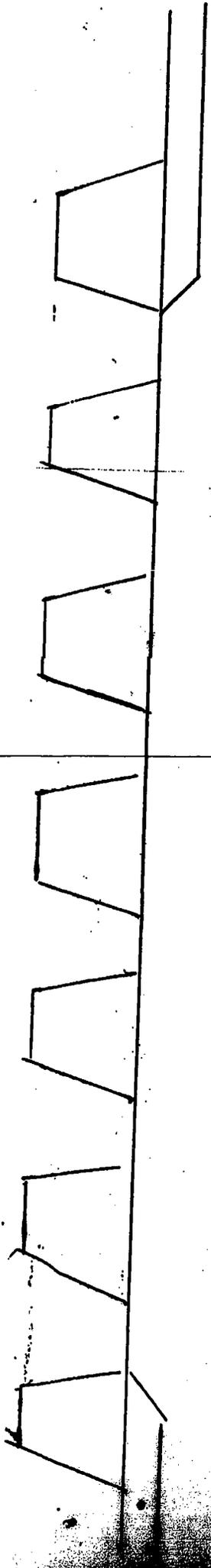
Signed: Jon P. Smithman Date: 10.15.04

Step 3 - Corrective Action to pre _____ **cur** _____
None @ IRCD

Signed: & [Signature] Date: 10/19/04

Step 4 - Corrective Action Approval:
 Approved: _____
 Not Approved, further corrective action required: _____

old distortion due to welding ribs



PA50 GIRDER 3A

SECTION	Original Checks	DEVIATION FROM SQUARE			
		1st Heat	2nd Heat	3rd Heat	4th Heat
A-A	2, 10				
B-B	4, 8				
D-D	3, 7				
E-E	1, 10				

DEPARTMENT OF TRANSPORTATION

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



*Flex Your Power
Be Energy Efficient!*

March 02, 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 # 5.03.1-007016

Subject: Response to KFM-SUB-003711R00: USI Documents Clearing USI KFM NCR #64 (METS #50)

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

The Engineer has reviewed KFM-SUB-003711R00: USI Documents Clearing USI KFM NCR #64 (METS #50). The Engineer takes exception to the Contractor's response in KFM-SUB-3711 that the dimensional checks required in the approved fabrication procedures "would be worthless information." The Engineer's concerns regarding the documentation of dimensional tolerance checks have been documented in multiple previous state letters. The Engineer is satisfied the Contractor has taken steps that sufficiently address the Engineer's concerns expressed in State Letter #5899. As a result, USI NCR No. 50 is resolved.

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: 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