



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 31-Jan-05
 Time 2:24 PM

Dated: 31-Jan-2005

SUBMITTAL No: WMSUB-003777

Rev: 00

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

Co/Job # 3643726
 Contract # 04-012024
 Sub/Supplier: USI
 Sub/Supplier No:

Subject: USI - Documents Clearing USI W M NCR #67 (METS 53)

Special Provis. (SP) REF: 083.01
 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 |

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	31-Jan-05	1	Letter of Transmittal #270		0	Pending	1
02	31-Jan-05	1	USI - Documents Clearing USI W M NCR #66 (METS 52)		0	Pending	4

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 : 07-Feb-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: 270

DATE: January 28, 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 checked="" 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 |

COPIES	ITEM	DESCRIPTION/ REMARKS
1 Original	NCR Response	Caltrans State Letter # 5.03.01-00666 Universal Structural, Inc. NCR LTR # 80.012805, KFM NCR # 80
1 Original	NCR Response	Caltrans State Letter # 5.03.1-005901 Universal Structural, Inc. NCR LTR 66.012805, KFM NCR # 66
1 Original	NCR Response	Clatrans State Letter # 5.03.1-005902 Universal Structural, Inc. NCR LTR 67.012805 KFM NCR #67

SKYWAY-BAY BRIDGE PROJECT
KIEWIT / FCI / MANSON, A JV

DATE: 1-31-05	CO/JOB 364-3726
ROUTED BY:	NO. 04-112024
TO: RICH BIENEK	SPECIAL NOTES:

INTERNAL KFM COPIES TO:

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EXTERNAL COPIES TO:

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THESE ARE TRANSMITTED AS CHECKED BELOW

- For Approval
 For your use
 As Requested
 FOR BIDS DUE

SCANNED: Y N FILED TO:

REMARKS Mr. Hegarty & Mr. Bienek,
 Universal Structural, Inc. (USI) is in receipt of the above mentioned Caltrans State Letter's and the following attachments; with individual cover letters is USI's record of subsequent action taken.

Copy To:

Signed:

Brad Murphy
 Brad Murphy cc:SC W

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



UNIVERSAL STRUCTURAL, INC.

604 S E Victory Ave
Vancouver, WA 98661

PO Box 1030
Vancouver, WA 98666

Vancouver (360) 695-1261
Portland (503) 227-2419
FAX (360) 696-3590

January 28, 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# 67.012805)

Subject: Response to Caltrans State Letter# 5.03.01-005902, DTD 10/25/04
KFM NCR # 67

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc received Caltrans State Letter # 5.03.01-005902, 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. The Contractor did not complete steps 8, 10, 11 and 13 of the Fabrication Procedures, Section IV before continuing fabrication of Assembly 4A."

After notification of Revision 13 of the Fabrication Plan was submitted, the assembly portion of the girder was overlooked. After subsequent meetings and better understanding of requested information, Revision 14 was then submitted. This Revision included the addition of a "Shop Traveler-Girder Assembly"; see copy of page 54 of 115 of Revision 14 noting this addition. This SHOP TRAVELER was reviewed by USI and METS/Caltrans; it was then mutually agreed upon and implemented into USI's shop. See example copy of SHOP TRAVELER.

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). 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



Brad Young - USI

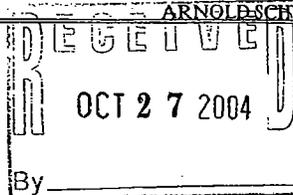
A Subsidiary of
HARDER MECHANICAL CONTRACTORS



B2477
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

KFM NCR 67

Contract: 04-012024
04-SF, Ala-80-13.9/14.3, 0.0/1.6
SFOBB Skyway Project
State Letter # 5.03.1-005902

Subject: KFM/USI NCR No. 53: Deviating ~~from~~ Section IV of the Approved Fabrication Procedures

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 representative allowed USI to deviate from the approved fabrication procedures without the Engineer's approval. The Contractor did not complete steps 8, 10, 11, and 13 of the Fabrication Procedures, Section IV before continuing fabrication of Assembly 4A.

This **NCR** will be tracked as **KFM/USI NCR No. 53**. 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

REV 14

IV. GIRDER ASSEMBLY PROCEDURE. ASSEMBLY 1A. *This procedure is for reference only. Assembly guidelines are noted on the Shop Traveler-Girder Assembly. (See “Girder Assembly Details” attached for the general overview of fabrication sequence.) This procedure will assemble the first section of the “E” Line girder that is approximate 20000 mm long and identified on USI shop drawing L1 as Assembly 1A.*

1. Prepare designated area in our shop and lay out location of steel support cribs for the Soffit plate. Set up cribbing so that the minimum clearance between floor and “Soffit plate is 48 inch. Place cribbing to comply with attached “Bunking Procedure” and shim as necessary to achieve positive camber.
2. Have a Dimensional Checker verify both location and elevation of cribbing to comply with shop drawings.
3. Place Soffit Plate Assembly on cribbing and check that the location will comply with the provided shop layout.
4. Place Diaphragms 1(Dwg A1B), 2(Dwg A1C), 4(Dwg A1E) and 7(Dwg A1G) on to Soffit Plate using the centerlines previously marked and checked.
5. Fit-up and tack-weld Diaphragms in place and brace to Soffit Plate.
6. Fit the restraint to the Hinge Pipe Support Diaphragms as shown in the “Hinge Pipe Diaphragm Restraint Detail”, Attached. **(NOTE: No welding outside the weld area is permitted).**
7. Have a CWI check for correct joint configuration and assign weld joint I.D. numbers.
8. Place and tack weld T-Stiffener pa61 at diaphragm locations 3, 5 and 6.
9. Have CWI check for correct joint configuration and assign weld joint I.D. numbers.
10. Fit-up and tack weld Web Plate Assembly pa45 and pa46 to Soffit plate and diaphragm’s 1, 2, 4 and 7.
11. Fit-up and tack weld deck plate T-stiffeners to the Web and Web T-Stiffeners.
12. Have a CWI check for correct joint configuration and assign weld joint I.D. numbers.
13. Have a Dimensional Checker verify location of this partial assembly for compliance with the TSDT sheet and record results.
14. Commence welding the Web to Soffit and diaphragms to the Soffit/Web. Complete the weld to the ribs after the main welds to plate have been made.
15. On the web, layout all locations of the wing plates and diaphragms using the fit line on the Soffit and the top of the Diaphragm.
16. Have the Dimensional Checker verify layout.
17. Fit and tack weld the Wing Plate Support Stiffeners (MK p25 1a and p25 1b) to the Soffit and Web after the Web has been welded to the Soffit.
18. Have a CWI check for correct joint Configuration and assign weld joint I.D. numbers.
19. Commence welding to Soffit and Web.
20. Have the Dimensional Checker check and record related dimensions per the drawings and TSDT sheet.

SHOP TRAVELER

PROJECT NO. 23932

GIRDER NO. 3A

PANEL NO. PA19
SOFFIT PLATE

FAB PLAN REF. #	SIGN-OFF	DISCRIPTION OF TASK	DETAIL ATTACHED	SEE DIM. DRAWINGS	ACTUAL DIMENSION (worst case)	TOLERANCE +/-	ACCEPT	REJECT	DATE	***REJECT REPORT #	FINAL ACCEPTANCE
3	KE	Fit Panel Splices									
4	Gm	Verify weld joint and support				AWS	✓		7-23-04		
	KE	Weld Panel Joints									
5	D	Perform NDE of Panel Joints							1/24/05		
6	G	Check Panel Flatness	X			5mm	✓		7-28-04		
7	KE	Lay-out ribs and diaphragms									
8	KE	Lay-out T-stiffeners									
	KE	Lay-out all other attachments									
9	Gm	Verify Lay-out		less than 5mm out		5mm	✓				
12	KE	Shim ends for final position									
15	KE	Fit and tack ribs									
16	G, JS	Verify weld joints:									
	JS	Bevel 30 deg.									
	JS	Gap									
	JS	Tack depth									
13	KE	Weld Rib joints									
	KE	Cut width and prep									
14	D	Perform NDE of Rib Joints									
15	G	Check Panel Flatness @ CL							11/24/05 10/16/04	110/116	
16	KE	Fit-up T-stiffeners									
	KE	Fit-up Diaphragms									
*		Fit-up all other Attachments									
17	G, JS	Verify Fit-up				5mm			10-14-04		
	G, JS	Verify weld joints				AWS			10-14-04		
18		Weld all Attachments									
19		Perform NDE									
20	Gm	Chk loc. of all attachments	X			5mm	✓		10-20-04		
*	G	Check Width	X			5mm			12-9-04		
*	JS	Check Panel Flatness	X			5mm	✓		1-3-05	144	

EXAMPLE

**Welding will only be performed when the joint has been verified and a weld joint number has been assigned and indicated on the joint itself. (typical for all welding)

**Rejected dimensions are noted on USI Non Conformance and/or Incident Reports

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 # 5.03.1-007019

Subject: Response to KFM-SUB-003777R00: USI Documents Clearing USI KFM NCR #67 (METS #53)

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

The Engineer has reviewed KFM-SUB-003777R00: USI Documents Clearing USI KFM NCR #67 (METS #53) and it is approved. The Engineer agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR No. 53 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