



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 14-Jan-05  
 Time 10:30 AM

Dated: 14-Jan-2005

SUBMITTAL No: KFM-SUB-002138

Rev: 01

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

Co/Job # 3643726  
 Contract # 04012024  
 Sub/Supplier: **USI**  
 Sub/Supplier No:

Subject: **USI** - Documents Clearing **USI** KFM NCR #22 (USI NCR 04-19)

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        |

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	11-Jan-05	1	Letter of Transmittal #230		1	Pending	2
02	14-Jan-05	1	<b>USI</b> - Documents Clearing <b>USI</b> KFM NCR #22 (USI NCR 04-19)		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 : 21-Jan-2005

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

Checked & Sent By: *SBurks*  
 Contract Admin/DCS Staff



# Universal Structural, Inc.

a subsidiary of

HARDER MECHANICAL CONTRACTORS, MC.

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: 230

DATE: January 11, 2005

PROJECT: SFOBB Skyway Structure

JOB NO.: 23932

ATTENTION: Paul Hegarty /

Rich Bienek

TO: Kiewit / FCI / Manson, JV

220 Burma Road

Oakland, CA

Page 1 of 2

WE ARE SENDING YOU

- |   |                                       |                                       |                                       |  |
|---|---------------------------------------|---------------------------------------|---------------------------------------|--|
| <input type="checkbox"/> Shop Drawings  | <input type="checkbox"/> ATTACHED     | <input type="checkbox"/> Prints       | <input type="checkbox"/> Prints       | <input type="checkbox"/> NCR Responses (Re-Submit) |
| <input type="checkbox"/> copy of letter | <input type="checkbox"/> Change order | <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 # 5.03.01-004444, KFM NCR 21R1
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004244, KFM NCR 22
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004245, KFM NCR 23
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004246, KFM NCR 24
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004248, KFM NCR 25
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004619, KFM NCR 38
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004827, KFM NCR 44
1 Original	NCR Response	Caltrans State Letter # 5.03.01-4908, KFM NCR 49

THESE ARE TRANSMITTED AS CHECKED BELOW

- For Approval   
  For your use   
  As Requested   
  FOR BIDS DUE

**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:

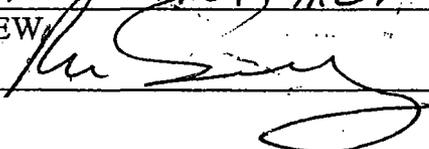
Signed:

*Brad Murphy*  
 Brad Murphy

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

internal NCR #10

# Universal Structural, Inc NONCONFORMANCE REPORT

<b>DATE:</b> March 30, 2004	<b>INITIATOR</b> Ralph Seeley	<b>DEPARTMENT:</b> Production	<b>NCR NUMBER:</b> 04-19
<b>JOB NUMBER:</b> 23932	<b>JOB NAME:</b> SFOBB	<b>DRAWING</b> 54	<b>CODE/SPECIFICATION</b> AWS D1.5
<b>NONCONFORMANCE:</b> Diaphragm pa54 has four (4) stiffeners p151y that exceed the 5mm. tolerance. Maximum out of tolerance on each stiffener is 7 mm.			
<b>QA W A G E R</b> C. Amonson		<b>DATE:</b> 3/30/04	
<b>RECOMMENDED DISPOSITION:</b>  Areas distorted by welding 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. Weld joints are to be heated on both sides, parallel to the weld. This line heat will be located approximately 1 to 3 inches from the weld joint on the outside of the surface that is distorted.			
<b>QA MANAGER</b> C. Amonson	<b>DATE</b> 3/30/04	<b>PROJECT MANAGER</b> Brad Young	<b>DATE</b> 3/30/04
<b>PLANT MANAGER</b> Ralph Seeley	<b>DATE</b> 3/30/04	<b>KFM/QA MANAGER</b> Rich Bienek	<b>DATE</b>
<b>QC</b> 4 stiffeners straightened. 4-26-04 witnessed By Mark Miller, K.E.			
<b>FINAL REVIEW</b> 		<b>DATE</b> 7/28/04	



4/22/04

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## DEPARTMENT OF TRANSPORTATION

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

April 21, 2004

KFM, a JV  
220 Burma Road  
Oakland, CA 94607Contract: 04-012024  
04-SF, Ala-80-13.9/14.3, 0.0/1.6  
SFOBB Skyway Project  
State Letter # 5.03.1-004244**Subject: Response to KFM-SUB-002138R00: USI NCR 04-19**Dear Mr. Skoro,  
Attention: Paul Hegarty,

The State has reviewed KFM-SUB-002138R00: USI NCR 04-19 regarding the request to heat straighten diaphragm assembly pa54. The State will allow USI to heat straighten diaphragm assembly pa54 in the presence of a State QA inspector. Subsequently, non-destructive testing (NDT) shall be performed in accordance with AWS D1.5 Section 6.7.3.

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

Sincerely,

David Wu  
Senior Bridge EngineerFor: Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, J. Khinsann, V. Iyer, D. Wu, S. Abbas, B. Chew, H. El-Natur, P. Lowry, U. Kwong

file: 5.03.1, 9.07.8



# UNIVERSAL STRUCTURAL, INC.

10435 Victory Ave  
Lanham, MD 20686

PO Box 1000  
Lanham, MD 20686

Phone: (301) 456-1234  
FAX: (301) 456-1234  
E-MAIL: info@usi.com

October 15, 2004

Kiewit / FCI / Manson, JV (WM)  
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# 22.101504)

Subject: Response to Caltrans State Letter # 5.03.01-004244

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004244, dated April 21, 2004. Caltrans stated that:

***"The State has reviewed KFM-SUB-002138R00: USI NCR 04-19 regarding the request to heat straighten diaphragm assembly pa54. The State will allow USI to heat straighten diaphragm assembly pa54 in the presence of a State QA inspector. Subsequently, non-destructive testing (NDT) shall be performed in accordance with AWS D1.5 Section 6.7.3."***

Please see the following attachments and subsequent follow up copy of USI's "nondestructive testing (NDT)" Report.

Please notify Caltrans 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

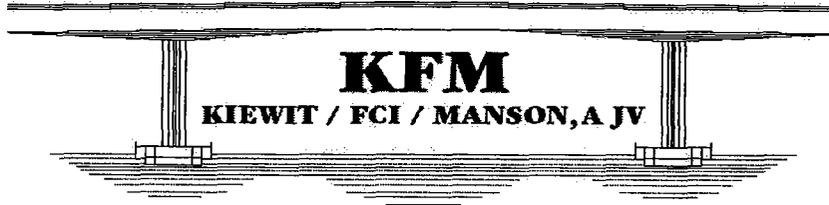
cc: Brad Young - USI  
file



Category #1

HARDER MECHANICAL CONTRACTORS





P.O. BOX 23223 Oakland, CA 94623  
 Phone (510)4194120/ Fax (510)839-0666

**LETTER OF SUBMITTAL**  
 KFM Skyway Project# 04-012024

Run Date 25-Feb-05  
 Time 12:12 PM

Dated: 25-Feb-2005

SUBMITTAL No: KFM-SUB-002141

Rev: 02

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 KFM NCR #25 (USI NCR 04-22) R1**

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 checked="" 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	23-Feb-05	1	Letter of Transmittal #361		0	Pending	1
02	23-Feb-05	1	USI - Documents Clearing USI KFM NCR #25 (USI NCR 04-22)		1	Pending	5

These are transmitted as checked below:

- |                                       |   |  |
|---------------------------------------|---|--|
| <input 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 : 04-Mar-2005

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

Checked & Sent By:   
 Contract Admin/DCS Staff



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 02-Aug-05  
 Time 4:06 PM

Dated: 02-Aug-2005

SUBMITTAL No: KFM-SUB-002138

Rev: 02

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

Co/Job # 364-3726  
 Contract # 04-012024  
 Sub/Supplier: USI  
 Sub/Supplier No:

Subject: USI - Documents Clearing KFM NCR #22 (USI NCR 04-19)

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 checked="" 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	21-Feb-05	1	USI - Documents Clearing KFM NCR #22 (USI NCR 04-19)		0	Pending	5

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 : 09-Aug-2005 \_\_\_\_\_

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

Checked & Sent By:   
 Contract Admin/DCS Staff

**UNIVERSAL STRUCTURAL, INC.****USI****UNIVERSAL STRUCTURAL, INC.**  
Sub of HARDER MECHANICAL

February 21, 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# 22.022105)

Subject: Response to Caltrans State Letter # 5.03.01-006872  
KFM NCR # 04-22

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-006872, dated February 14, 2005. Caltrans stated that:

*"...the subject submittal does not contain sufficient information to resolve the NCR. The Engineer understands heat straightening has already been completed...."*

Please see the attached:

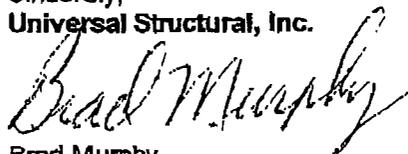
- Copy of State Letter - 5.03.1-006872
- Copy of Sketch - Diaphragm pa54, p151y stiffeners
- Copy of USI's - NCR 04-19
- Copy of USI's - Magnetic Particle Test Report

At the time this occurrence, USI was not documenting the length of the heat process (since then this process has been revised). After review with USI's shop lead man Ken Estab and to the best of our knowledge the heat straightening process was the full length of the (p151y) stiffeners.

Please notify Caltrans 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



Category III

HARDER MECHANICAL CONTRACTORS



STATE OF CALIFORNIA-BUSINESS, TRANSPORTATION AND HOUSING AGENCY

ARNOLD SCHWARZENEGGER, Governor

DEPARTMENT OF TRANSPORTATION

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



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February 14, 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 # 5.03.1-006372

Subject: Response to KFM-SUB-002138R01: USI Documents Clearing USI KFM NCR #22 (USI NCR 04-19)

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

The Engineer has reviewed KFM-SUB-002138R01: USI Documents Clearing USI KFM NCR #22 (USI NCR 04-19). The subject submittal does not contain sufficient information to resolve the NCR. The Engineer understands heat straightening has already been completed on this piece. As such, please include a sketch showing where each application of heat was applied to resolve the NCR or inform the Engineer where this information may be found at USI.

Should you have any questions, please contact David Wu at (510) 622-5104 or Patrick Lowry at (858) 344-2712.

Sincerely,

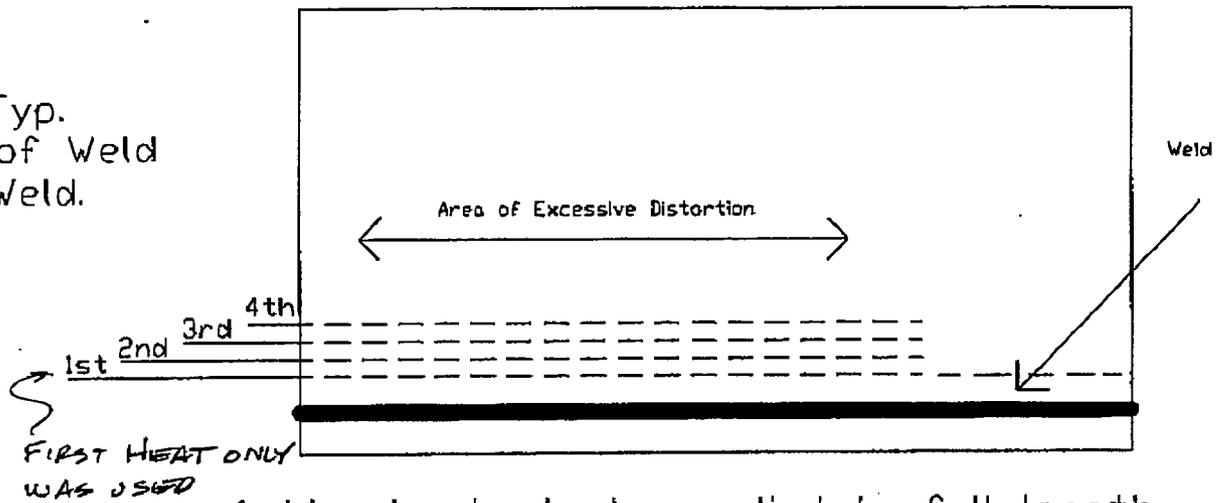
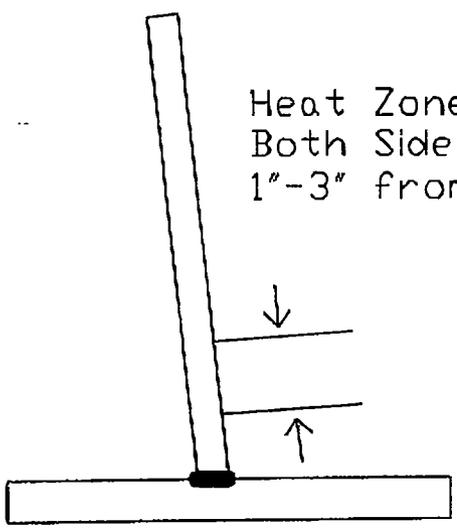
<<< ORIGINAL SIGNED >>>

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

# TYPICAL T-JOINT WELD DISTORTION REPAIR PROCEDURE.

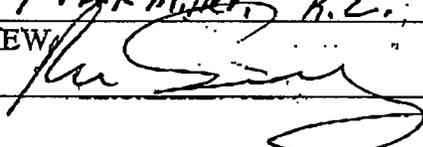


1. Line heats to be applied to full length of weld where excessive distortion is present
2. First line heat shall be placed nearest to the weld and progress away from the previous line of heat.
3. Each line heat will be applied to the stiffener side parallel to the weld and allowed to cool. Check prior to application of next progress heats.

*internal NCR # 10*

# Universal Structural, Inc

## NONCONFORMANCE REPORT

DATE:	INITIATOR	DEPARTMENT:	NCR NUMBER:
March 30, 2004	Ralph Seeley	Production	04-19
JOB NUMBER:	JOB NAME:	DRAWING	CODE/SPECIFICATION
23932	SFOBB	54	AWS D1.5
NONCONFORMANCE:			
Diaphragm pa54 has four (4) stiffeners p151y that exceed the 5mm. tolerance. Maximum out of tolerance on each stiffener is 7 mm.			
QA MANAGER C. Amonson		DATE: 3/30/04	
RECOMMENDED DISPOSITION:			
<p>Areas distorted by welding 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.).</p> <p>All application of heat to base metal shall be controlled by using Temp Sticks or Thermocouples to assure that heat does not exceed allowable. Weld joints are to be heated on both sides, parallel to the weld. This line heat will be located approximately 1 to 3 inches from the weld joint on the outside of the surface that is distorted.</p>			
QA MANAGER	DATE	PROJECT MANAGER	DATE
C. Amonson	3/30/04	Brad Young	3/30/04
PLANT MANAGER	DATE	KFM/QA MANAGER	DATE
Ralph Seeley	3/30/04	Rich Bienek	
DISPOSITION COMPLETED			
QC	DATE	CUSTOMER	DATE
<i>4 stiffeners straightened. 4-26-04</i>	<i>4-26-04</i>		
<i>witnessed By Mark Miller, K.E.</i>			
FINAL REVIEW			DATE
			<i>7/23/04</i>



**DEPARTMENT OF TRANSPORTATION**

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



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February 14, 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 # 5.03.1-006872*

*Subject: Response to KFM-SUB-002138R01: USI Documents Clearing USI KFM NCR #22 (USI NCR 04-19)*

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

The Engineer has reviewed KFM-SUB-002138R01: USI Documents Clearing USI KFM NCR #22 (USI NCR 04-19). The subject submittal does not contain sufficient information to resolve the NCR. The Engineer understands heat straightening has already been completed on this piece. As such, please include a sketch showing where each application of heat was applied to resolve the NCR or inform the Engineer where this information may be found at USI.

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