



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* 26-Oct-04  
*Time* 3:57 PM

**Dated:** 26-Oct-2004  
**To:** Doug Coe  
 Caltrans-Skyway Project  
 345 Burma Road  
 Oakland CA 94607  
 Phone: Fax:

**SUBMITTAL No:** KFM-SUB-002143 **Rev:** 02  
**Co/Job #** 364-3726  
**Contract #** 04-012024  
**Sub/Supplier:** USI  
**Sub/Supplier No:**

**Subject:** USI - KFM NCR #27R1 (USI NCR #04-24 Rev. 1) Response to CTL-4438

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

**RESUBMITTAL/SUPPLEMENTAL REF:**

- We are sending the following attached items:**  Attached  Via Fax
- Drawing
  - Plans
  - Prog. Pmt
  - Samples
  - Certificates of Compliance
  - Calculations
  - Payroll
  - Specs
  - Copy of Letter
  - Change Order
  - Schedule
  - Invoice

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	02-Nov-04	1	USI - NCR LTR#27R1.102004		1	Pending	1
02	26-Oct-04	1	State Letter # 5.03.1-004438		0	Pending	1
03	26-Oct-04	1	USI - NCR #04-24 Rev.1		0	Pending	5

**These are transmitted as checked below:**

- For Approval
- For Review/comment
- Return For Correction
- For Your Use
- As Requested
- For Information

**Remarks:**

See Attached USI UT& Dimensional Control Reports, and close USI-NCR-04-24 Rev. 1

**CC:**

**Please review / approve by :** 02-Nov-2004

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

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



# 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

October 20, 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 (NCR LTR# 27r1.102004)  
Subject: Response to Caltrans State Letter # 5.03.01-004438  
KFM NCR #27r1

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004438, dated May 11, 2004. Caltrans stated that:

*"The State has reviewed KFM-SUB-002143R01: USI NCR 04-24 Rev.1- Dimensions regarding the request to heat straighten weld distortion in the butt weld in wing plate diaphragm pa86. The State will allow USI to apply one progression of heat in accordance with USI's "Typical Butt Weld Distortion Repair Procedure" included with this submittal. Heat straightening should occur in the presence of a State QA inspector. After the first progression of heat is applied, the measurements of the affected dimension should be communicated to the State QA inspector on the floor. At this time, the State may approve the second progression of heat in accordance with the "Typical Butt Weld Distortion Repair Procedure." 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 "non-destructive 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



Category III

Brad Young - USI  
file

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 Power  
 Be Energy Efficient!

May 11, 2004

KFM, a JV  
 220 Burma Road  
 Oakland, CA 94607

*27 REV 1*

Contract: 04-012024  
 04-SF, Ala-80-13.9/14.3, 0.0/1.6  
 SFOBB Skyway Project  
 State Letter # 5.03.1-004438

Subject: Response to KFM-SUB-002143R01: USI NCR 04-24 Rev.1 - Dimensions

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

The State has reviewed KFM-SUB-002143R01: USI NCR 04-24 Rev.1 - Dimensions regarding the request to heat straighten weld distortion in the butt weld in wing plate diaphragm pa86. The State will allow USI to apply one progression of heat in accordance with USI's "Typical Butt Weld Distortion Repair Procedure" included with this submittal. Heat straightening should occur in the presence of a State QA inspector. After the first progression of heat is applied, the measurements of the affected dimensions should be communicated to the State QA inspector on the shop floor. At this time, the State may approve the second progression of heat in accordance with the "Typical Butt Weld Distortion Repair Procedure." Subsequently, non-destructive testing (NDT) shall be performed in accordance with AWS D1.5 Section 6.7.3.

The State also requests future submittals include additional information concerning the overall deviation from flatness. In addition to the deviation from flatness measured across the 1524 mm length at localized areas of distortion, the State requests the deviation from flatness measured across the total edge-to-edge distance perpendicular to the weld.

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

Sincerely,

*David Wu*

David Wu  
 Senior Bridge Engineer

For: Mr. Douglas Coe  
 Resident Engineer

SKYWAY-BAY BRIDGE PROJECT	
KIEWIT/FCI/MANSON A JV	
DATE: <i>MAY 13, 2004</i>	CONTRACT: <i>362 174</i>
ROUTED BY: <i>J. SBU</i>	NO: <i>04-012024</i>
TO: <i>R. Bienek</i>	SPE: <i>001</i>
INTERNAL KFM COPIES TO:	
<i>ca</i>	
EXTERNAL COPIES TO:	
<i>USI</i>	
SCANNED: <input checked="" type="checkbox"/> Y	FILED TO: <i>SUB 213, R</i>

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

internal NCR # 3

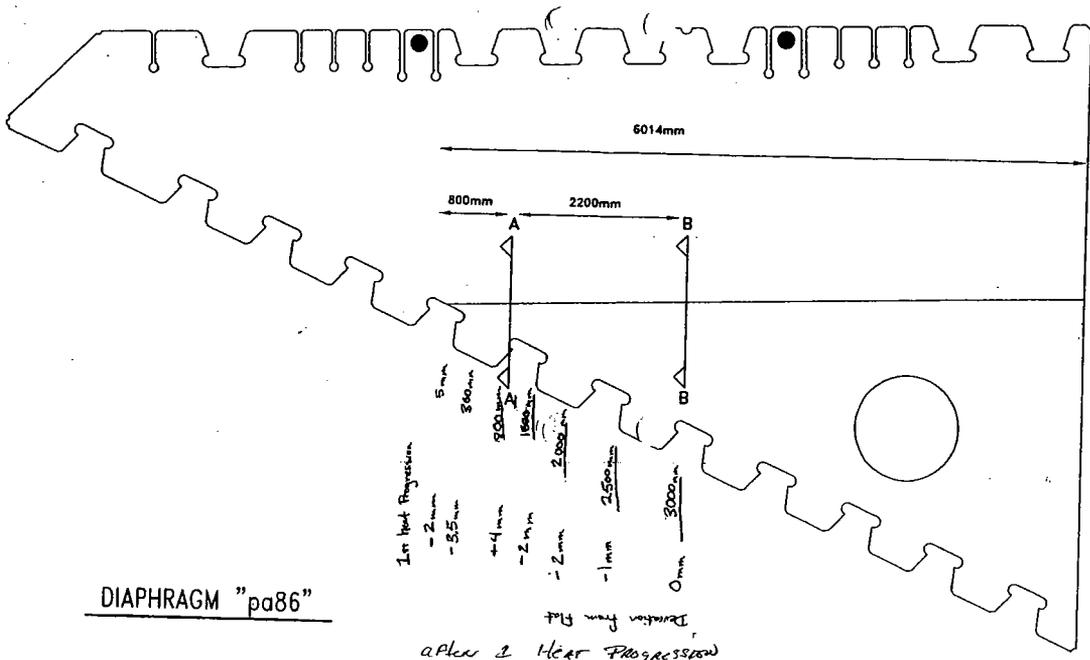
## Universal Structural, Inc NONCONFORMANCE REPORT

DATE: March 30, 2004 April 26, 2004 Rev1	INITIATOR Ralph Seeley	DEPARTMENT: Production	NCR NUMBER: 04-24 Rev. 1
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING 86	CODE/SPECIFICATION AWS D1.5
NONCONFORMANCE: Wing plate diaphragm pa86 has excessive weld distortion in the butt weld. From the left end looking at the shop drawing, the first 800 mm is 8 mm out of flat. From 800 mm to 3000 mm is 14 mm out of flat.  Revision 1, As requested, a sketch needs to be supplied to indication location of excessive distortion.			
QA MANAGER Chris Amonson		DATE: 3/30/04	
RECOMMENDED DISPOSITION: 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.  Revision 1, Please find the attached sketch for location and amounts of distortion.  Caltrains requires witnessing the repair and will only allow one heat progression. Record results after line heats are cooled.			
QA MANAGER Chris Amonson	DATE 3/30/04	PROJECT MANAGER Brad Young	DATE 3/30/04
PLANT MANAGER Ralph Seeley	DATE 3/30/04	KFM/QA MANAGER Rich Bienek	DATE
DISPOSITON COMPLETED			
QC	DATE	CUSTOMER	DATE

Complete

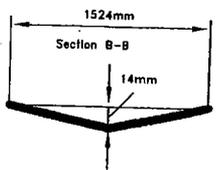
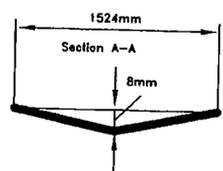
FINAL REVIEW	E. J. Malen 5/7/84
	DATE

See ATTACHED sketch for Deviations From Flat  
at Diaphragm Butt Splice.  
ALL Dimensions ARE within prescribed Tolerances  
after  $\pm$  Heat Progression.



DIAPHRAGM "pa86"

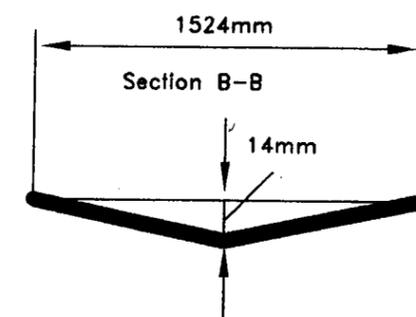
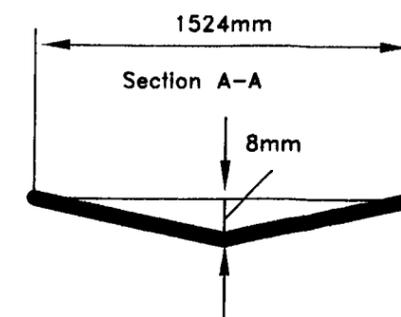
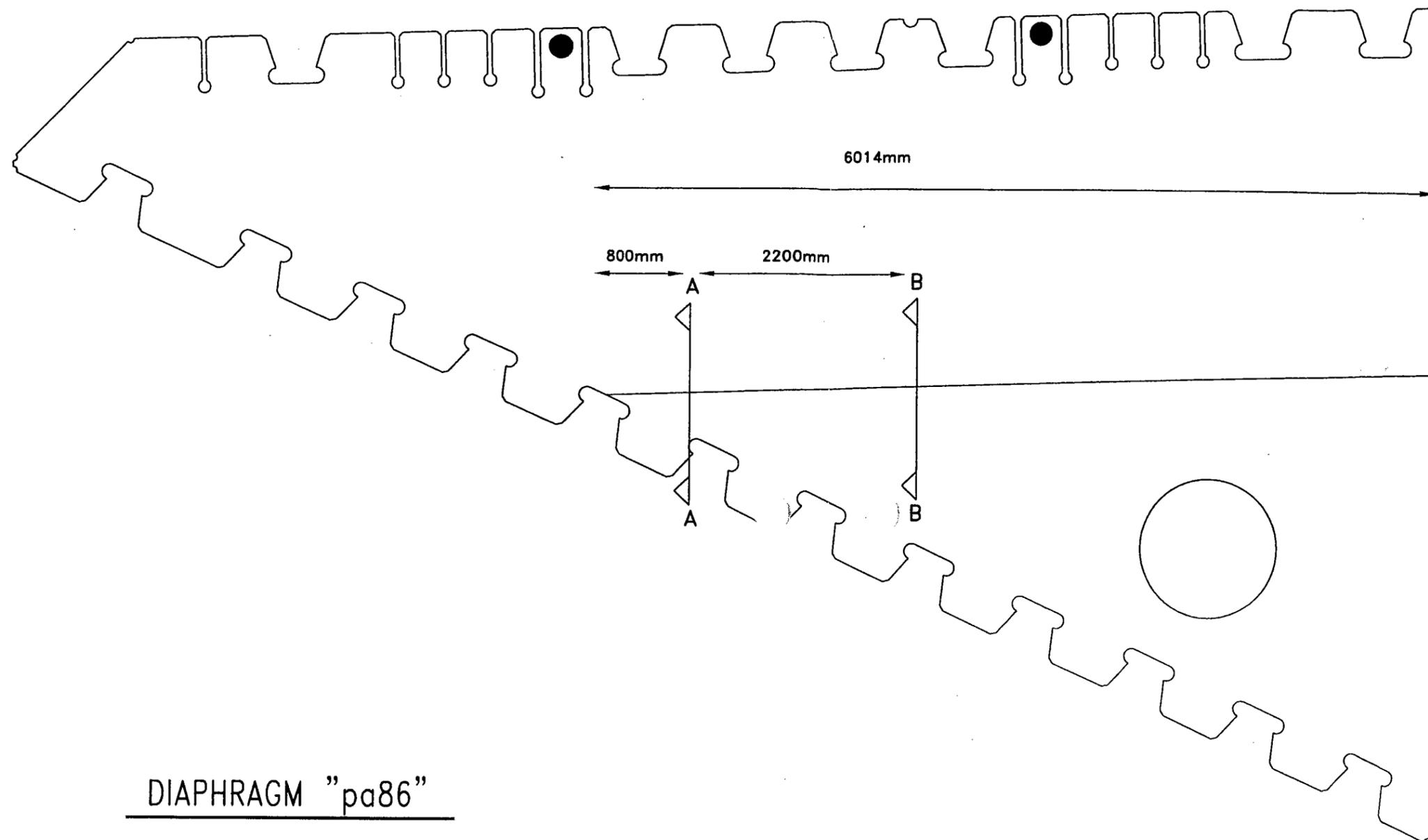
after 1 Heat Progression



Wing Plate Diaphragm

04-24-R2





Wing Plate Diaphragm

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
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December 13, 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 # 5.03.1-006245*

*Subject: Response to KFM-SUB-002143R02: USI KFM NCR #27R1 (USI NCR #04-24 Rev.1)  
Response to CTL 4438*

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

The Engineer has reviewed KFM-SUB-002143R02: USI KFM NCR #27R1 (USI NCR #04-24 Rev.1) Response to CTL 4438. The Engineer takes no exception to the subject submittal and agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR 04-24 Rev.1 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