



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-002147 **Rev:** 02  
**Co/Job #** 364-3726  
**Contract #** 04-012024  
**Sub/Supplier:** USI  
**Sub/Supplier No:**

**Subject:** USI - KFM NCR #31R1 (USI NCR 04-28 Rev. 1) Response to CTL - 4442

**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	22-Oct-04	1	USI - NCR LTR #31R1.102204		0	Pending	1
02	26-Oct-04	1	STate Letter # 5.03.1-004442		0	Pending	1
03	26-Oct-04	1	USI - NCR #04-28 Rev. 1		0	Pending	6

**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 & Dimension Reports & Close USI NCR 04-28 Rev. 1

**CC:**

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

**Submitted By:** Rich Bienek

(KFM Staff Member - Originator of Transmittal)

**Checked & Sent By:**

*SBW*  
 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 22, 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# 31r1.102204)

Subject: Response to Caltrans State Letter # 5.03.01-004442  
KFM NCR #31r1

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004442, dated May 11, 2004. Caltrans stated that:

*"The State has reviewed KFM-SUB-002145R01R01: USI NCR 04-28 Rev.1 – Dimensions regarding the request to heat straighten tendon stiffener pc203.. 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."*

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

Contract: 04-012024  
 04-SF, Ala-80-13.9/14.3, 0.0/1.6  
 SFOBB Skyway Project  
 State Letter # 5.03.1-004442

*3/1/04*

*Subject: Response to KFM-SUB-002147R01: USI NCR 04-28 Rev.1 - Dimensions*

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

The State has reviewed KFM-SUB-002147R01: USI NCR 04-28 Rev.1 - Dimensions regarding the request to heat straighten tendon stiffener pc203. 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 - MARSH & J	
DATE: <i>MAY 13, 2004</i>	CD: <i>04 364 3'26</i>
ROUTED BY: <i>DWU</i>	NO: <i>012024</i>
TO: <i>R. Bienek</i>	SPECIAL: <i>copy to Universal checker</i>
INTERNAL KFM COPIES TO	
<i>DL</i>	
EXTERNAL COPIES TO	
<i>UST</i>	
SCANNED: <i>(Y) N</i>	FILED TO: <i>SUB 2147.2.1</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

NCR # 11

## Universal Structural, Inc NONCONFORMANCE REPORT

DATE: March 30, 2004 April 26, 2004 Rev1	INITIATOR Ralph Seeley	DEPARTMENT: Production	NCR NUMBER: 04-28 Rev. 1
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING 203	CODE/SPECIFICATION AWS D1.5
<p>NONCONFORMANCE: Tendon stiffener pc203 is 15 mm out of flat throughout the transition splice.</p> <p>Revision 1, As requested, a sketch needs to be supplied to indication location of excessive distortion.</p>			
QA MANAGER Chris Amonson		DATE: 3/30/04	
<p>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.</p> <p>Revision 1, Please find the attached sketch for location and amounts of distortion</p> <p>Caltrains requires witnessing the repair and will only allow one heat progression. Record results after line heats are cooled.</p>			
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

*Tendon R.B straighten to tolerance*  
*lu*

FINAL REVIEW

DATE

Noted @ 2:50 pm 5-19-04 AP

# UNIVERSAL STRUCTURAL NON-CONFORMANCE REPORT

Date: 3-19-04  
 Initiator: K.E  
 Job Number: 23932  
 NCR No.: 11



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

**Step 1 - Details of Non-conformance:**  
R203 Tendon stiffener, weld splice at transition  
weld 15mm out of flat.

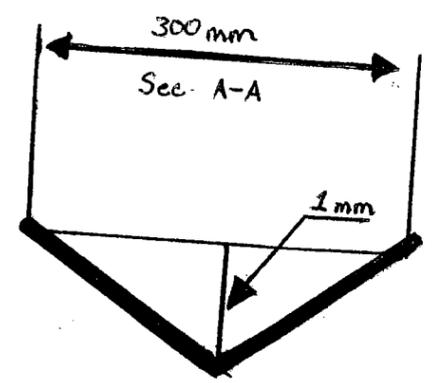
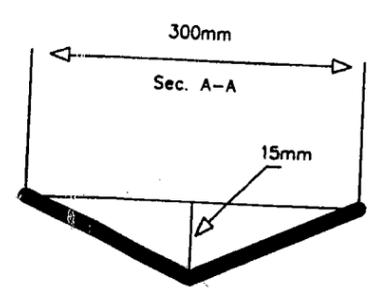
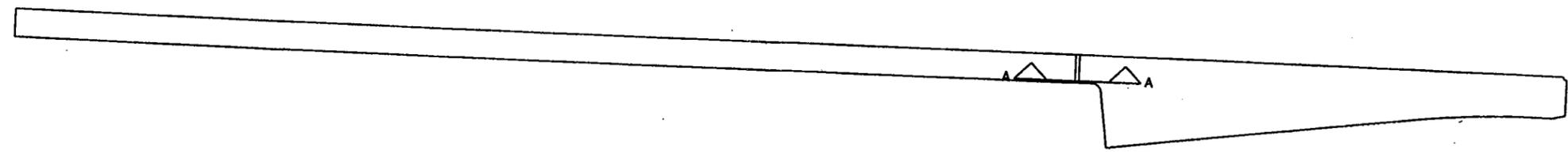
Responsible Department: \_\_\_\_\_ Department Supervisor \_\_\_\_\_  
**Step 2 - Corrective Action:** Engineer approval required:  yes  no  
apply pressure + limited heat to straighten

Signed: \_\_\_\_\_ Date: \_\_\_\_\_

**Step 3 - Corrective Action to prevent re-occurrence:**

Signed: \_\_\_\_\_ Date: \_\_\_\_\_

**Step 4 - Corrective Action Approval:**  
 Approved: \_\_\_\_\_  
 Not Approved, further corrective action required: \_\_\_\_\_



pc203

Tendon Anchorage Ass'y





**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

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 # 5.03.1-006317*

*Subject: Response to KFM-SUB-002147R02: USI KFM NCR #31R1 (USI NCR 04-28 Rev.1)  
Response to CTL 4442*

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

The Engineer has reviewed KFM-SUB-002147R02: USI KFM NCR #31R1 (USI NCR 04-28 Rev.1) Response to CTL 4442. The Engineer takes no exception to the subject submittal and agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR 04-28 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, 9.06.8