



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 10:29 AM

Dated: 14-Jan-2005

SUBMITTAL No: WM-SUB-002137

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 Closing USI KFM NCR #21 (NCR 04-18)**

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
- Samples
- Payroll
- Change Order
- Plans
- Certificates of Compliance
- Specs
- Schedule
- Prog. Pmt
- Calculations
- Copy of Letter
- Invoice

Item	Date	Copies	Description	Drawing No	Rev	Status	Pages
01	11-Jan-05	1	Letter of Transmittal #230		0	Pending	2
02	14-Jan-05	1	USI - Documents Closina USI KFM NCR #21 (NCR 04-18)		0	Pnndinn	5

These are transmitted as checked below:

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

Remarks:

CC:

Please review / approve by : 21-Jan-2005

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

Checked & Sent By:   
Contract Admin/DCS Staff

# UNIVERSAL STRUCTURAL INC.

<u>REPORT IDENTIFICATION DATA</u>				<u>EXAMINATION METHOD</u>				
USI JOB NO 23932 DWG. NO: <u>53</u> ITEM NO: <u>PA53</u>				EQUIPMENT: PARKER PROBE DA-400 PARKER B-300 CURRENT TYPE: AC. DRY, CONTINUOUS, 4-6" SPACING POWDER COLOR RED, CIRCLE SYSTEMS, INC. #63 PROCEDURE NO. MT-1 (REV 4)				
<u>CUSTOMER IDENTIFICATION</u>				<u>ACCEPTANCE STANDARD</u>				
PROJECT : SKYWAY STRUCTURES. CUSTOMER: K.F.M. I A JV BRIDGE NO: 34-0006 L/R CONTRACT NO: 04-012024				AWS D1.5 (1996) ACCEPTANCE STANDARD <u>VISUAL ACCEPTANCE PRIOR TO NDE</u> BY: S. REED, M. GARCIA P. HALE, , JOHN G R N				
PIECE MARKS	WID	AREA	ACCEPT	REJECT	REPAIR	ACCEPT	REJECT	NOTES
P151d		100	✓					(6) total
P151V		100	✓					(2) Total

LEVEL II TECHNICIAN - PETER HALE

EXAMINATION DATE

LEVEL II TECHNICIAN - MIKE GARCIA

EXAMINATION DATE

LEVEL II TECHNICIAN - JOHN GREY

EXAMINATION DATE

LEVEL II TECHNICIAN - SCOTT REED

EXAMINATION DATE

LEVEL II TECHNICIAN - C. Stewart

7/29/04

EXAMINATION DATE

LEVEL II TECHNICIAN - [Signature]

EXAMINATION DATE

CHRIS AMONSON - CWI - 87110071, USI QCM, REVIEW

1/28  
REVIEW DATE

# 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: 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"/> Samples        |
| <input type="checkbox"/> copy of letter | <input type="checkbox"/> Change order | <input type="checkbox"/> Change order | <input type="checkbox"/> Change order | <input type="checkbox"/> Plans          |
|   |                                       |                                       |                                       | <input type="checkbox"/> Specifications |
- NCR Responses (Re-Submit)

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

DATE: 1-14-05  
 ROUTED BY: RICH BIENEK  
 NO. 04-01-2024  
 SPECIAL NOTES:  
 SKYWAY BRIDGE PROJECT  
 KIEWIT / FCI / MANSON, JV  
 INTERNAL KFM COPIES TO:  
 EXTERNAL COPIES TO:  
 SCANNED: Y N FILED TO:

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

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

# UNIVERSAL STRUCTURAL, INC.



6045 E. Victoria Ave.  
Tacoma, WA 98178

P.O. Box 1038  
Tacoma, WA 98402

Chenoweth (360) 493-0124  
Forslund (360) 827-2411  
Fax (360) 493-0124

October 15, 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# 21r1.101504)  
Subject: Response to Caltrans State Letter # 5.03.01-004444

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004444, dated May 11, 2004. Caltrans stated that:

- 1. Sketch of each piece showing where the heat will be applied.**
- 2. Estimate of the number of applications of heat to bring the material into conformance.**
- 3. Explanation of how Fabrication Procedures will be modified and improved."**

Please see the attached sketch of Wing End Diaph, along with a copy of USI's "non-destructive test (NDT)". Also, on point number 3, do to the nature of this incident (isolated), plus the fact this will not effect future fabrication; there is no reason to revise the "fabrication procedure".

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

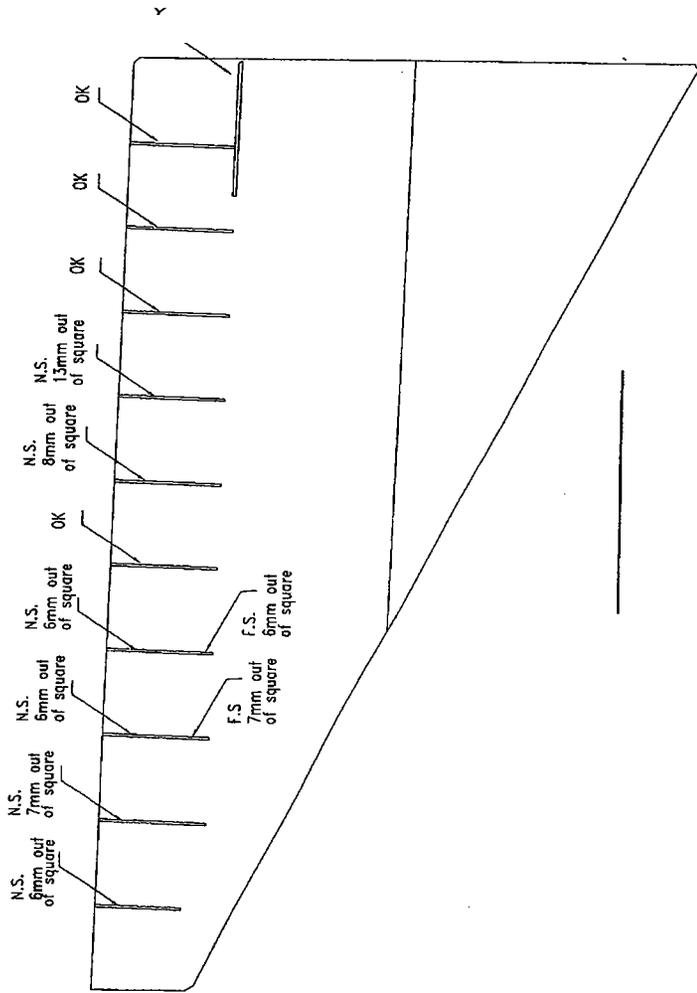


Category III

HARDER MECHANICAL CONTRACTORS







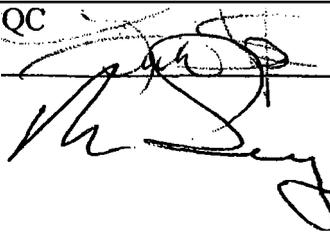
DIAPHRAGM "pd53"

Wing End Diaph

# Universal Structural, Inc

## NONCONFORMANCE REPORT

<b>DATE:</b> March 30, 2004 April 26, 2004 Rev0	<b>INITIATOR</b> Ralph Seeley	<b>DEPARTMENT:</b> Production	<b>NCR NUMBER:</b> 04-18 Rev. I
<b>JOB NUMBER:</b> 23932	<b>JOB NAME:</b> SFOBB	<b>DRAWING</b> 53	<b>CODE/SPECIFICATION</b> AWS D1.5
<b>NONCONFORMANCE:</b>  Diaphragm pa53 has eight (8) stiffeners, 1-p151b, 5-p151d, and 2-p 151v that exceed the 5mm. tolerance. Maximum out of tolerance on each stiffener is 8mm.  Revision 1, As requested, the dimensions need to be verified and witnessed by Caltrains inspection.			
<b>QA MANAGER</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 the stiffener side, 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, Dimensions were verified with one correction from the 8mm. noted to 13mm. Please find the attached sketch for individual measurements.			
<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>	<b>DATE</b>	<b>CUSTOMER</b>	<b>DATE</b>


3/11/05  
2/29/04

DEPARTMENT OF TRANSPORTATION

SFOBB - Skyway Project  
 5 Burma Road  
 Oakland, CA 94607  
 Facsimile Number: (510) 622-5166



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 # 5.03.1-004444

Subject: Response to KFM-SUB-002137R01: USI NCR 04-18 Rev. 1- Dimensions

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

**2/2/04**

The State has reviewed KFM-SUB-002137R01: USI NCR 04-18 Rev. 1 – Dimensions regarding the request to heat straighten stiffeners on pa53. The subject ~~submittal~~ is not approved. The State will reconsider the request upon receipt of the following information:

1. Sketch of each piece showing where the heat will be applied.
2. Estimate of the number of applications of heat to bring the material into conformance.
3. Explanation of how Fabrication Procedures will be modified and improved.

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: <b>MAY 13 2004</b>	COORD: 364 3726
ROUTED BY: <b>SBW</b>	NO: 04-012024
TO: <b>R. Bienek</b>	SPECIAL NOTES: <b>Copy to Universal Truck</b>
INTERNAL KFM COPIES TO	
<b>ca</b>	
EXTERNAL COPIES TO	
<b>UST</b>	
SCANNED: <b>(Y)</b> N	FILED TO: <b>SUB 2137.R1</b>

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



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 25-Feb-05  
 Time 12:12 PM

Dated: 25-Feb-2005

SUBMITTAL No: KFM-SUB-002137

Rev: 03

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 Closing USI KFM NCR #21 (NCR 04-18) 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

- Drawing
- Samples
- Payroll
- Change Order
- Plans
- Certificates of Compliance
- Specs
- Schedule
- Prog. Pmt
- Calculations
- Copy of Letter
- 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 Closing USI KFM NCR #21 (NCR 04-18) R1		1	Pending	5

These are transmitted as checked below:

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

# 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: 361

DATE: February 23, 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 # 5.03.01-006864, KFM NCR 21R1 USI Letter # 21R1.022105
1 Original	NCR Response	Caltrans State Letter # 5.03.01-006872, KFM NCR 22 USI Letter # 22.022105
1 Original	NCR Response	Caltrans State Letter # 5.03.01-006874, KFM NCR 24 USI Letter # 24.022105
1 Original	NCR Response	Caltrans State Letter # 5.03.01-004895, KFM NCR 48 USI Letter # 48.021505
1 Original	NCR Response	Caltrans State Letter # 5.03.01-006745, KFM NCR 84 USI Letter # 84.022105

SKYWAYBAY BRIDGE PROJECT  
KIEWIT / CIL / MANSON, A JV  
DATE: 2-25-05  
CO/DB: 394-3726  
ROUTED BY: NO: 44-01224  
TO: RICH BIENEK SPECIAL NOTES:  
INTERNAL KFM COPIES TO:  
EXTERNAL COPIES TO:  
SCANNED: Y N FILED TO:

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.

**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

February 11, 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 # 5.03.1-006864**

***Subject: Response to KFM-SUB-002137R02: USI Documents Closing USI KFM NCR #21 (NCR 04-18)***

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

The Engineer has reviewed KFM-SUB-002137R02: USI Documents Closing USI KFM NCR #21 (NCR 04-18). 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

# Universal Structural, Inc

## NONCONFORMANCE REPORT

DATE: March 30,2004 April 26,2004 Rev0	INITIATOR Ralph Seeley	DEPARTMENT: Production	NCR NUMBER: <b>04-18 Rev. 1</b>
JOB NUMBER: 23932	JOB NAME: SFOBB	DRAWING 53	CODE/SPECIFICATION <b>AWS D1.5</b>

**NONCONFORMANCE:**

Diaphragm pa53 has eight (8) stiffeners, 1- p 15 lb, 5-p 15ld, and 2-p 15lv that exceed the 5mm. tolerance. Maximum out of tolerance on each stiffener is 8 mm.

Revision 1,

As requested, the dimensions need to be verified and witnessed by Caltrains inspection.

QA MANAGER C. 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.).

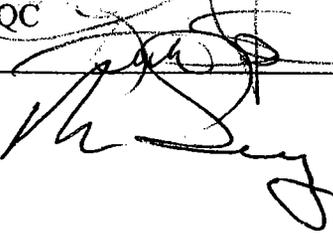
All application of heat to base metal shall be controlled by using Temp Sticks or Thermocouples to assure that heat does not exceed allowable. Weld joints are to be heated on the stiffener side, parallel to the weld. This line heat will be located approximately 1 to 3 inches from the weld joint on the outside of the surface that is distorted.

Revision 1,

Dimensions were verified with one correction from the 8mm. noted to 13 mm. Please find the attached sketch for individual measurements.

QA MANAGER C. 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
	11/1/05		
	2/29/04		



# 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

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# 21r1.022105)

Subject: Response to Caltrans State Letter # 5.03.01-006864  
KFM NCR # 04-21R1

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-006864, dated February 11, 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 - 5.03.1-006864
- Copy of Sketch - Diaphragm pa53, p151d, p151v
- Copy of USI's - NCR 04-18R1
- 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 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

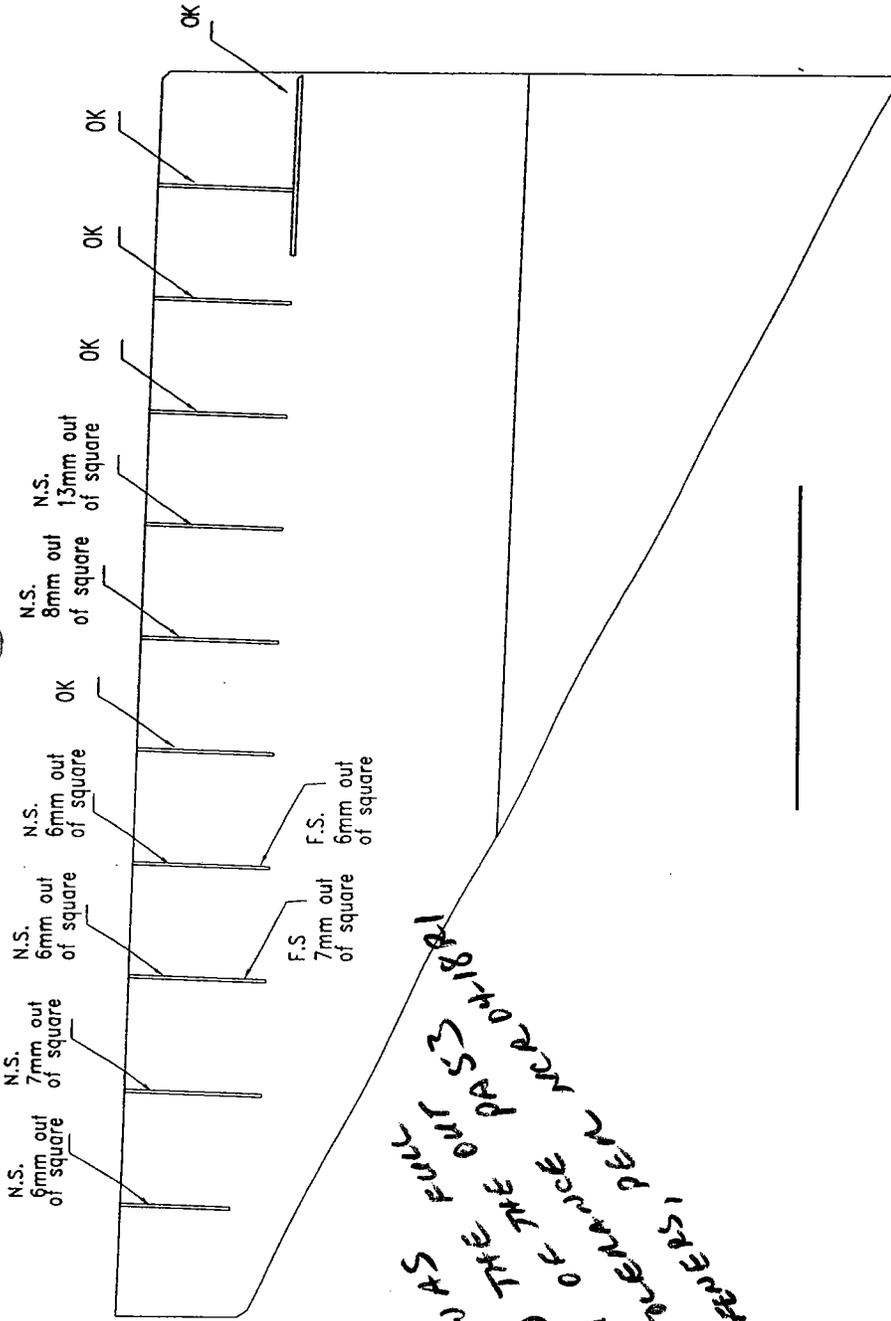
cc: Brad Young - USI



Category III

A Subsidiary of  
HARDER MECHANICAL CONTRACTORS





AS FURTHER  
 HEAT TREATING WAS APPLIED  
 TO THE PARTS  
 LEADING TO THE  
 STRENGTHENING OF  
 THE PARTS

DIAPHRAGM '0a53'

Wing End Diaph



**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

February 11, 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 # 5.03.1-006864*

*Subject: Response to KFM-SUB-002137R02: USI Documents Closing USI KFM NCR #21 (NCR 04-18)*

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

The Engineer has reviewed KFM-SUB-002137R02: USI Documents Closing USI KFM NCR #21 (NCR 04-18). 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