



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 4:36 PM

Dated: 26-Oct-2004

SUBMITTAL No: KFM-SUB-002142

Rev: 01

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 - KFM NCR #26 (USI NCR 04-23 Rev. 0) Response to CTL - 4249

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	20-Oct-04	1	USI - NCR LTR#26.102004)		1	Pending	1
02	26-Oct-04	1	State Letter # 5.03.1-004249		0	Pending	1
03	26-Oct-04	1	USI - NCR #04-23		0	Pending	3

These are transmitted as checked below:

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

Remarks:

Attached UT Report Clears KFM-NCR-26 (USI NCR 04-23 Rev 0) Per CTL - 4249

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# 26.102004)

Subject: Response to Caltrans State Letter # 5.03.01-004249  
KFM NCR #26

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc. received Caltrans State Letter # 5.03.01-004246, dated April 21, 2004. Caltrans stated that:

*"The State has reviewed KFM-SUB-002142R00: USI NCR 04-23 regarding the request to heat straighten diaphragm assembly pa85. The State will allow USI to heat straighten wing plate diaphragm pa85 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 "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

cc: Brad Young - USI  
file



Category III

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!

April 21, 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 # 5.03.1-004249

*Subject: Response to KFM-SUB-002142R00: USI NCR 04-23*

Dear Mr. Skoro,  
Attention: Paul Hegarty,

The State has reviewed KFM-SUB-002142R00: USI 04-23 regarding the request to heat straighten wing plate diaphragm pa85. The State will allow USI to heat straighten wing plate diaphragm pa85 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 Engineer

For Mr. Douglas Coe  
Resident Engineer

cc: D. Coe, I. Khinsann, V. Iyer, D. Wu, S. Abbas, B. Chew, H. El-Natur, C. Lowy, C. Kwong

file: 5.03.1, 9.07.8

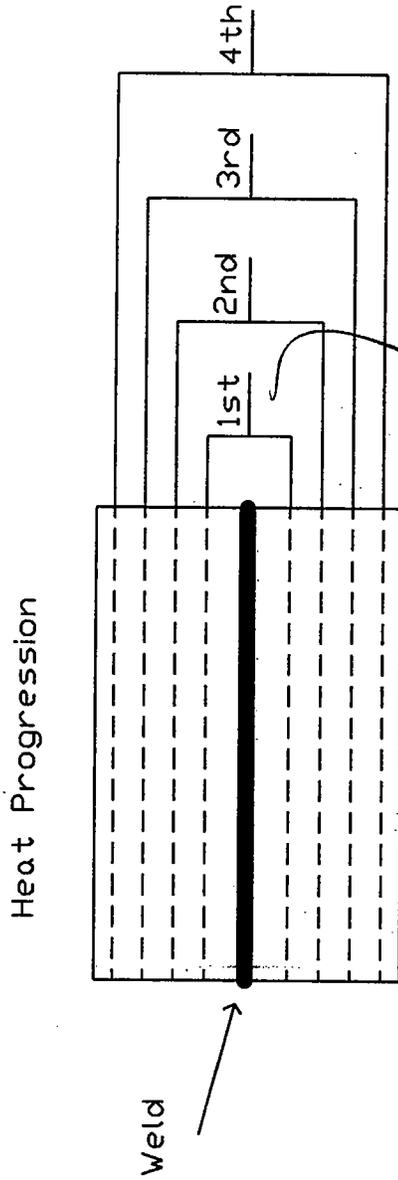
*internal NCR #2*

## Universal Structural, Inc NONCONFORMANCE REPORT

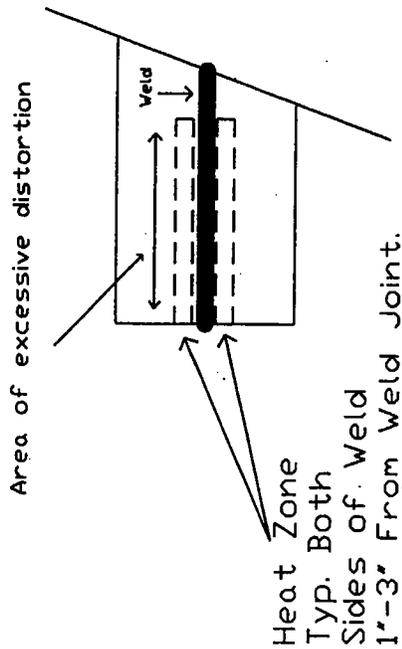
DATE:	INITIATOR	DEPARTMENT:	NCR NUMBER:
March 30, 2004	Ralph Seeley	Production	04-23
JOB NUMBER:	JOB NAME:	DRAWING	CODE/SPECIFICATION
23932	SFOBB	85	AWS D1.5
<b>NONCONFORMANCE:</b> Wing plate diaphragm pa85 has excessive weld distortion in the butt weld. From the left end looking at the shop drawing, the first portion of the weld to the left side of the pipe penetration is 8 mm out of flat. From the right side of the pipe penetration to 2100 mm is 7 mm out of flat.			
QA MANAGER Chris Amonson		DATE: 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.			
QA MANAGER	DATE	PROJECT MANAGER	DATE
Chris Amonson	3/30/04	Brad Young	3/30/04
PLANT MANAGER	DATE	KFM/QA MANAGER	DATE
Ralph Seeley	3/30/04	Rich Bienek	
<b>DISPOSITION COMPLETED</b>			
QC	DATE	CUSTOMER	DATE
FINAL REVIEW <i>Splice straighten to within tolerance</i> <i>Devin Ward</i> 			DATE 4/27/04 7/28/04

*ONE HEAT*

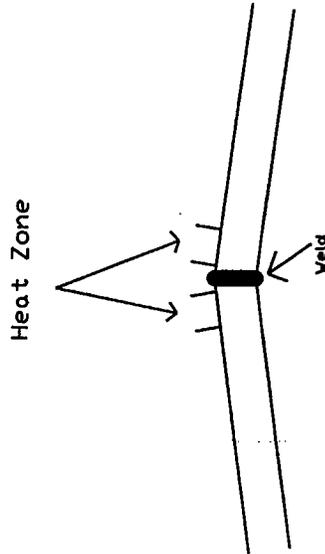
# TYPICAL BUTT WELD DISTORTION REPAIR PROCEDURE



ONE PROGRESSION USED



Heat Zone  
Typ. Both  
Sides of Weld  
1'-3' From Weld Joint.



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



**DEPARTMENT OF TRANSPORTATION**

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



*Flex Your Power  
Be Energy Efficient!*

December 12, 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 # 5.03.1-006243*

*Subject: Response to KFM-SUB-002142R01: USI KFM NCR #26 (USI NCR 04-23 Rev.0) Response to CTL 4249*

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

The Engineer has reviewed KFM-SUB-002142R01: USI KFM NCR #26 (USI NCR 04-23 Rev.0) Response to CTL 4249. The Engineer takes no exception to the subject submittal and agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR 04-23 Rev.0 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