KFM
KIEWIT / FCI / MANSON, A JV

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 *09-Feb-05*
Time *9:28 AM*

Dated: 09-Feb-2005

SUBMITTAL No: KFMSUB-003831 Rev: 00

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** WM NCR #57 (METS #43)

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	08-Feb-05	1	Letter of Transmittal #301		0	Pending	1
02	08-Feb-05	1	**USI** - Documents Closing **USI** KFM NCR #54 (METS #40)		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:

cc:

Please review / approve **by :** 15-Feb-2005

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

Checked & Sent **By:** SBURIS
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: 301
DATE: February 7,2005
PROJECT: SFOBB Skyway Structure
JOB NO.: 23932
ATTENTION: Rich Beinek

TO: KFM
220 Burma Road
Oakland. CA 94607

WE ARE SENDING YOU

☐ ATTACHED ☑ NCR Responses

☐ Shop Drawings ☐ Prints ☐ Prints ☐ Samples
☐ Copy of letter ☐ Change order ☐ Change order ☐ Plans ☐ Specifications

COPIES	ITEM	DESCRIPTION / REMARKS
1 Original	NCR Response	Caltrans State Letter # 5.03.01-005069, USI Letter # 54.020305, KFM NCR #54
1 Original	NCR Response	Caltrans State Letter # 5.03.01-005714, USI Letter # 57.020305, KFM NCR # 57

SKYWAY-BAY BRIDGE PROJECT
KIEWIT / FCI / MANSON A JV
DATE: 2-8-05 CO/JOB 364-3726
ROUTED BY NO 04-012024
TO: SPECIAL NOTES.
RICH BIENEK
INTERNAL KFM COPIES TO:
EXTERNAL COPIES TO:
SCANNED: Y N FILED TO:

THESE ARE TRASMITTED 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 and the following attachments; with the individual cover letter 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.

UNBVERSAL STRUCTURAL, INC.

604 S E Victory Ave • PO Box1030 • Vancouver (360)695-1261
Vancouver WA 98661 • Vancouver. WA 98666 • Portland (503) 227-2419
FAX (360) 696-3590

February 3,2005

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# 57.020305)

Subject: Response to Caltrans State Letter # 5.03.01-005714, DTD 10/05/04
KFM NCR # 57

Mr. Hegarty & Mr. Bienek,

Universal Structural, Inc received Caltrans State Letter # 5.03.01-005714, dated October 05, 2004. Caltrans state that:
"USI continued to welding closed rib panels before making adjustments to their Distortion Control Plan after out of tolerance flatness was measured on Assembly 3A wing plate pa37."

USI made revisions to the Fabrication Plan; see copy of Rev. 13, page 25 of 109, Section I, Item 15, that deleted this action. The recorded flatness tolerance would not have served any purpose (note; all dimensional checks continue to be done during the fabrication). Due to the fact the Wing Plate, at this stage, still has numerous items to be welded to it. This evolved to Rev. 14, see copy of page 26 of 115 I. Web Plate Assembly, that states "...Assembly guidelines are noted on the Shop Traveler-Web Plate". Hence a Shop Traveler was implemented into the Fabrication Plan.

It was mutually agreed upon, with all patties concerned, that USI will be able to make adjustments in the Fabrication Plan (advising METS/Caltrans at the time) during fabrication. These actions will then be properly documented and a Revision to the Fabrication Procedure will be submitted. USI continues to work with METS/Caltrans in attiring to all requirements for this project.

UNIVERSAL STRUCTURAL, INC.

SFOBB Skyway Project
USI # 23932

February 4, 2005

Please note, we believe there is a mistake in this State Letter that reference's wing plate pa37 ? we believe it should read pa27.

Please review and submit to Caltrans for 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

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

Flex Your Power
Be Energy Efficient!

October 05,2004

KFM NCR 57

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 # 5.03.1-005714

Subject: USI NCR No. 43: Failure to Follow Distortion Control Plan from Fabrication Procedures

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

This Non-Conformance Report (NCR) is issued by the State to KFM as a result of your supplier, USI, for the following reason:

1. USI continued welding closed rib panels before making adjustments to their Distortion Control Plan after out of tolerance flatness was measured on Assembly 3A wing plate pa37. PA27? SHOULD BE

This **NCR will** be tracked as USI NCR No. **43.** USI was verbally notified of this **NCR** by **Caltrans' METS** on **09/29/04.** Please review and address how you plan to resolve this **NCR** and bring your work back into compliance with our contract.

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

Sincerely,

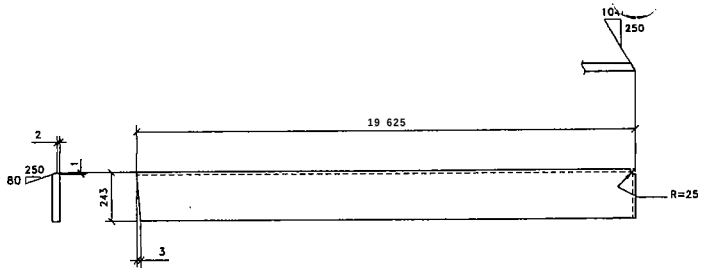
<<< ORIGINAL SIGNED >>>

David Wu
Senior Bridge Engineer

For: Mr. Douglas Coe
Resident Engineer

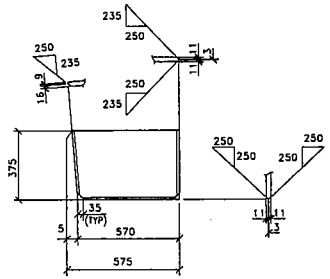
cc: D. Coe, I. Khinsann, V. Iyer, D. Wu, S. Abbas, B. Chew, H. El-Natur, P. Lowry, I. Kwong

file: 5.03.1, 9.07.8



ONE ~ PL 13 x **243** x 19 625 ~ pa37

(ASS'Y 1A)



PL 25 x 375 x 575 ~ pc37^{R} (AS SHOWN)

(ONE ~ REQ'D) (S/L: 10A/17) (UAT'L SPEC. A709M-GR.345F2)

PL 25 x 375 x 575 ~ pc37^{L} (OPP HAND)

(ONE ~ REQ'D) (S/L: 10A/17) (MAT'L SPEC. A709M-GR.345F2)

(DIAPHRAGY 4 / pa84)

BILL OF MATERIAL

MARK	QTY.	DESCRIPTION	LENGTH mm		UNIT WT.	WEIGHT	S/L	REMARKS
pa37	1	PL 13 x 243	19	625		487	15A/3	
pc37R/L	2	PL 25 x 375		575	42	84	10A/17	MAT'L SPEC A709M-GR.345F2
			TOTAL WEIGHT=			571		

APPROVED FOR FABRICATION

FEB 25 2004

EDGE DISTANCE ~

SPACING NOT SHOWN ~

CONNECTORS:

GENERAL NOTES: SEE GN1

HOLES

SHOP PAINT: SEE GN1

TRANSITION SPAN

PREPARATION FOR PAINT: SEE GN1

MK	REVISION	BY	DATE
1	pc37R/L REVISED, ADVANCE BILL MARKS ADDED	RGV	08
2	pc37R/L DIM'S REV'D	RGV	08
3	pc37R/L EDGE PREP REV'D	RGV	08/03

UNIVERSAL STRUCTURAL, INC.
604 S.E. VICTORY AVE.
VANCOUVER, WASHINGTON

SHEET TITLE: SOFFIT EDGE PL & LOOSE STD. PL's

PROJECT: SKYWAY STRUCTURES ~ CONTRACT NO. 04-012021

TRANSITION SPAN ~ BRIDGE NO. 34-0006 L/R

DISTRICT 04. ROUTE 80 : KILOMETER POST 13.9/14.3,0.0/1.6

SAN FRANCISCO / ALAYEOA COUNW

CUSTOMER: KFU / A JV.

DRAWN BY: K.L. DATE: 11/30/02 JOB NO. 23932

CHECKED BY: AW/SIN DATE 12/2/02

MATERIAL SPEC. A709M-GR.345T2 U/N

ERECTION OWG. ~

REF. DWG. ~

SHEET NO. 37

R V. 0

15. Move to storage area.

I. **Web Plate Assembly.** (NOTE: Fabricate assemblies in conjunction with "Sub-Assembly Detail – Web Plate", Attached) These assemblies are detailed on sheet 45A/B, 45B/B 46A/B and 46B/B.

1. Layout entire plate in Cad and increase the width by 2 mm and the length by 40 mm. Burn Plates using the "Plate Processing Procedure".
2. Set up the assembly area next to the Wing Plate Bunks.
3. Fit and tack weld p45a to p45b and p46a to p46b respectively.
4. Have a CWI approve joint configuration and assign weld joint I.D. numbers.
5. Weld and inspect butt splice using "Distortion Control Plan" and the "Typical Butt Splice Procedure".
6. Have QC Perform NDE per the WQCP (See NDES) on completed butt splice and record welder I.D. on weld map.
7. Have Dimensional Checker check overall dimensions, flatness, and distortion to the TSDT Sheet.
8. Layout all rib plate location, T-Stiffener locations, Manhole locations and any other attachments or penetrations.
9. Have a Dimensional Checker verify that the lay-out is correct.
10. Fit-up and tack weld all closed rib stiffener sub-assemblies to web plate. (See 'Closed Rib Fitting Procedure")
11. Have CWI approve weld joint configuration and assign weld joint I.D. numbers.
12. Elevate the ends of web plate longitudinally while restraining the center of the plate with hold downs per the "Sub-Assembly Detail – Web Plate".
13. Weld using approved procedure.
14. Have QC Perform all required NDE per the WQCP (See NDES) and record welder I.D on weld map.

REV 13

15. ~~Have the Dimensional Checker check and record dimensions and out of tolerance distortion (per TSDT sheet) required on the "Checker Set #2".~~
16. Fit-up T-stiffener in previously marked location and tack-weld to hold in place.
17. Have a CWI check for correct fit up and assign weld joint I.D. numbers.
18. Complete welding with approved procedure.
19. Have QC perform all necessary NDE per the WQCP (See NDES) and record welder I.D. numbers on weld map.
20. Turn web plate assembly over.
21. Fit and tack weld manhole reinforcing ring.
22. Have a CWI approve joint configuration and assign weld joint I.D. numbers.
23. Complete welding using approved procedure.
24. Have QC perform all required NDE per the WQCP (See NDES) and record welder I.D on weld map.
25. Have the Dimensional Checker check and record dimensions and out of tolerance distortion (per TSDT sheet) required on the "Checker Set #2".

REV 14

I. Web Plate Assembly. *This procedure is for reference only. Assembly guidelines are noted on the Shop Traveler-Web Plate.* (**NOTE**: Fabricate assemblies in conjunction with "Sub-Assembly Detail – Web Plate", Attached) These assemblies are detailed on sheet 45A/B, 45B/B 46A/B and 46B/B.

1. Layout entire plate in Cad and increase the width by 2 mm and the length by 40 mm. Burn Plates using the "Plate Processing Procedure".
2. Set up the assembly area next to the Wing Plate Bunks.
3. Fit and tack weld p45a to p45b and p46a to p46b respectively.
4. Have a CWI approve joint configuration and assign weld joint I.D. numbers.
5. Weld and inspect butt splice using "Distortion Control Plan" and the "Typical Butt Splice Procedure".
6. Have QC Perform NDE per the WQCP (See NDES) on completed butt splice and record welder I.D. on weld map.
7. Have Dimensional Checker check overall dimensions, flatness, and distortion to the TSDT Sheet.
8. Layout all rib plate location, T-Stiffener locations, Manhole locations and any other attachments or penetrations.
9. Have a Dimensional Checker verify that the lay-out is correct.
10. Fit-up and tack weld all closed rib stiffener sub-assemblies to web plate. (See "Closed Rib Fitting Procedure")
11. Have CWI approve weld joint configuration and assign weld joint I.D. numbers.
12. Elevate the ends of web plate longitudinally while restraining the center of the plate with hold downs per the "Sub-Assembly Detail – Web Plate".
13. Weld using approved procedure.
14. Have QC Perform all required NDE per the WQCP (See NDES) and record welder I.D on weld map.
15. Fit-up T-stiffener in previously marked location and tack-weld to hold in place.
16. Have a CWI check for correct fit up and assign weld joint I.D. numbers.
17. Complete welding with approved procedure.
18. Have QC perform all necessary NDE per the WQCP (See NDES) and record welder I.D. numbers on weld map.
19. Turn web plate assembly over.
20. Fit and tack weld manhole reinforcing ring.
21. Have a CWI approve joint configuration and assign weld joint I.D. numbers.
22. Complete welding using approved procedure.
23. Have QC perform all required NDE per the WQCP (See NDES) and record welder I.D on weld map.
24. Have the Dimensional Checker check and record dimensions and out of tolerance distortion (per TSDT sheet) required on the "Checker Set #2".

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

Flex Your Power
Be Energy Efficient!

March 02, 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 # 5.03.1-007020

Subject: Response to KFM-SUB-003831R00: USI Documents Clearing USI KFM NCR #57 (METS #43)

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

The Engineer has reviewed KFM-SUB-003831R00: USI Documents Clearing USI KFM NCR #57 (METS #43). The Engineer takes exception to the Contractor's response in KFM-SUB-3831 that the required flatness measurement "would not serve any purpose." The Engineer understands the Contractor's "Shop Traveler – Web Plate" contains a panel flatness check prior to assembly. As such, the Engineer is satisfied the Contractor has taken steps that sufficiently address the Engineer's concerns expressed in State Letter #5714. Note the Engineer could not approve changes to page 26 of 115 of KFM-SUB-391R13 because the submittal did not include the referenced "Shop Traveler – Web Plate." The Engineer agrees the Contractor has sufficiently addressed this NCR. As a result, USI NCR No. 43 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