

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017495**Date Inspected:** 21-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 12AE (Green Tag DCP)

This QA Inspector performed Green Tag Dimension Control Inspection for the Segment 12AE from Panel Point (PP) 109 to PP 110 at the following locations:

The skin flatness was verified and measured across the longitudinal butt weld at Deck Panel (DP) to Corner Assembly (CA) at the Cross Beam (CB) side from Panel Point (PP) 109 to PP 110. The QA Inspector measured the skin flatness using 600mm straight edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 11AW to Segment 11BW (Transverse Splice T-Ribs)

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This QA Inspector performed Dimension Control Inspection along with ABF QA personnel on the Transverse Splice T-Ribs to T-Ribs for the Segment 11AW to Segment 11BW between Panel Point (PP) 97 to PP 98 at the following locations:

Work Point W6 towards Work Point W4 (Side Panel Cross Beam Side) total 19 T-Ribs.

Work Point W4 towards Work Point W3 (Bottom Panel) total 18 T-Ribs.

Work Point W3 towards Work Point W1 (Side Panel Counter Weight Side) total 19 T-Ribs.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge and measured the Horizontal Offset on the web using a Bridge Cam gauge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check and bike path identified as following.

BK4A-011 dimension measured as out of tolerance.

BK4A-008 dimension measured within the tolerance.

BK5A-001 dimension measured within the tolerance.

The QA Inspector measured the flatness using 1500mm long straight edge.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Mark Miller and ABF Mr. Peter Shaw.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150000422372, who represents the Office of Structural Materials for your project.

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Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer