DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023533
Date Inspected: 09-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
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

Lift 12 East (X37B Brackets)

This QA Inspector performed Dimension Control Inspection for the Segment 12AE, Segment 12BE and Segment 12CE and verified the steel plate installation for non-conformance locations, verified the fillet weld machining for installing the plain washer between road barrier bolt hole drilled at X37B from deck panel to the cope hole at X37B bracket installed at Corner Assembly at east and west side of the X37B brackets at following locations and verified the locations where ZPMC has taken corrective action for rectifying the out of tolerance areas.

At Panel Point (PP) 109.75, Cross Beam side.
At Panel Point (PP) 109.75, Bike Path side.

At Panel Points (PP) 110.25 and PP 110.75, Cross Beam side.
At Panel Points (PP) 110.25 and PP 110.75, Bike Path side.

At Panel Points (PP) 111.25 and PP 111.75, Cross Beam side.
At Panel Points (PP) 111.25 and PP 111.75, Bike Path side.

At Panel Points (PP) 112.25 and PP 112.75, Cross Beam side.
At Panel Points (PP) 112.25 and PP 112.75, Bike Path side.

At Panel Points (PP) 113.25 and PP 113.75, Cross Beam side.
At Panel Points (PP) 113.25 and PP 113.75, Bike Path side.

At Panel Points (PP) 114.25 and PP 114.75, Cross Beam side.
At Panel Points (PP) 114.25 and PP 114.75, Bike Path side.

At Panel Points (PP) 115.25 and PP 115.75, Cross Beam side.
At Panel Points (PP) 115.25 and PP 115.75, Bike Path side.

At Panel Points (PP) 116.25 and PP 116.75, Cross Beam side.
At Panel Points (PP) 116.25 and PP 116.75, Bike Path side.

At Panel Points (PP) 117.25, Cross Beam side.
At Panel Points (PP) 117.25, Bike Path side.

Note: Observed at following locations steel plates installed to compensate the edge distance less area.

Cross Beam side.

PP 117.25 (East side)

Bike Path side.

PP 109.25 (West side).
PP 111.25 (West side).
PP 113.25 (East side).
PP 114.75 (East side).
PP 115.25 and PP 115.75 (East side)
PP 116.25 (East side).
PP 117.25 (East and West side).

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.

Lift 12 West (X37B Brackets)

This QA Inspector performed Dimension Control Inspection for the Segment 12AW, Segment 12BW and Segment 12CW and verified the steel plate installation for non-conformance locations, verified the fillet weld machining for

installing the plain washer between road barrier bolt hole drilled at X37B from deck panel to the cope hole at X37B bracket installed at Corner Assembly at east and west side of the X37B brackets at following locations and verified the locations where ZPMC has taken corrective action for rectifying the out of tolerance areas.

At Panel Point (PP) 109.75, Cross Beam side.
At Panel Point (PP) 109.75, Counter Weight side.

At Panel Points (PP) 110.25 and PP 110.75, Cross Beam side.
At Panel Points (PP) 110.25 and PP 110.75, Counter Weight side.

At Panel Points (PP) 111.25 and PP 111.75, Cross Beam side.
At Panel Points (PP) 111.25 and PP 111.75, Counter Weight side.

At Panel Points (PP) 112.25 and PP 112.75, Cross Beam side.
At Panel Points (PP) 112.25 and PP 112.75, Counter Weight side.

At Panel Points (PP) 113.25 and PP 113.75, Cross Beam side.
At Panel Points (PP) 113.25 and PP 113.75, Counter Weight side.

At Panel Points (PP) 114.25 and PP 114.75, Cross Beam side.
At Panel Points (PP) 114.25 and PP 114.75, Counter Weight side.

At Panel Points (PP) 115.25 and PP 115.75, Cross Beam side.
At Panel Points (PP) 115.25 and PP 115.75, Counter Weight side.

At Panel Points (PP) 116.25 and PP 116.75, Cross Beam side.
At Panel Points (PP) 116.25 and PP 116.75, Counter Weight side.

At Panel Points (PP) 117.25, Cross Beam side.
At Panel Points (PP) 117.25, Counter Weight side.

Note: Observed at following locations steel plates installed to compensate the edge distance less area.

Cross Beam side.

PP 112.75 (East side).
PP 113.25 (West side).
PP 114.75 (East side).
PP 115.75 (East side).
PP 117.25 (East side).

Counter Weight side.

PP 113.25 (East side) and PP 113.75 (West side).

PP 115.75 (East side).
PP 116.75 (East side).

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.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer