

**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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023536**Date Inspected:** 10-May-2011**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), Changxing Island **Location:** Shanghai, China

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

This QA Inspector along with Caltrans QA Inspector Mr. Manoj Prabhune photographed the interior structural parts of the OBG Segment at various locations prior to the shipment of (Voyage 8) of Lift 12 West en-route to Yerba Buena Island, California, USA. The Lift 12 East is located on OBG Trial Assembly.

The Segments are identified as following.

Segment 12AE

At Panel Points (PP) 109, PP 109.5, PP 110, PP 110.5, PP 111, PP 111.5, PP 112 and PP 112.5 (Cross Beam and Bike Path side).

1. Segment 12AE overall structure of OBG, from external side.

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2.Segment 12AE, FL3 extension at PP 110, PP 111 and PP 112.

3.Corner Assembly covering overall view, Deck Panel I-stiffeners, Edge Panel I-Stiffeners and Corner Assembly, Side Panel I-Stiffeners.

4.Longitudinal Diaphragm (LD) at work point W4 and work point W3, North and South facing of the LD.

5.Lower Chevron covering Overall view, North facing, South facing, East facing and West facing at work point W4 and work point W3.

6.Upper Chevron covering Overall view, North facing, South facing, East facing and West facing at Cross Beam and Counter Weight side.

7.Intermediate Panel Points at Corner Assembly, Cross and Vertical Truss Post bolting area (Cross Beam and Counter Weight Side).

8.FL3 extension area (connecting to CB # 17) at PP 110, PP 111 and PP 112.

Segment 12BE

At Panel Points (PP) 113, PP 113.5, PP 114 and PP 114.5 (Cross Beam and Bike Path side).

1.Corner Assembly covering overall view, Deck Panel I-stiffeners, Edge Panel I-Stiffeners and Corner Assembly, Side Panel I-Stiffeners.

2.Longitudinal Diaphragm (LD) at work point W4 and work point W3, North and South facing of the LD.

3.Lower Chevron covering Overall view, North facing, South facing, East facing and West facing at work point W4 and work point W3.

4.Upper Chevron covering Overall view, North facing, South facing, East facing and West facing at Cross Beam and Counter Weight side.

5.Intermediate Panel Points at Corner Assembly, Cross and Vertical Truss Post bolting area (Cross Beam and Counter Weight Side).

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

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remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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