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

Bay Area Branch
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Contract #: 04-0120F4
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-023637
**Date Inspected:** 16-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

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|---|---|---|---|---|---|---|---|---|---|---|---|
| **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

Traveler Rails at Bay # 5

This QA Inspector performed Dimension Control Inspection on the Traveler Rails 3009TR1-001 for the following measurements and observed measured dimension in compliance contact document. Inspection was performed against the Inspection Notification # 09144 dated May 16, 2011 at Bay # 5.

Traveler Rails Thickness at typical section.

Traveler Rails Flange width at typical section.

Traveler Rails Depth at typical section.

Traveler Rails Flange curl at typical section.

Traveler Rails Traveler Rail length.

Traveler Rails Sweep.

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. The result of the inspection was informed to ZPMC QC Mr. Liu Fawen, ABF Mr. Wang Zhong Yuan and Caltrans Lead Inspector Mr. Mark Miller.

Please reference the pictures attached for more comprehensive details.

Segment 13AE, Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly

This QA Inspector performed Dimension Control Inspection on the Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly for Segment 13AE at the following locations along with ABF QA Mr. Wang at E4 locations.

Bearing Blocks are installed at PP 119 (-1500mm), Total 2 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119 (-1500mm), Total 4 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 to PP 119(-1500mm), Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119, Total 4 locations at West side of the Floor Beam.

Dimension inspection was performed after passing the anchor rod at between the holes of Bearing Block to Bottom Plate and recorded the various measurements as following.

Gap between the Bearing Blocks to Floor Beam.

Mill to Bear (MTB) measured between the Stools to Bearing Block.

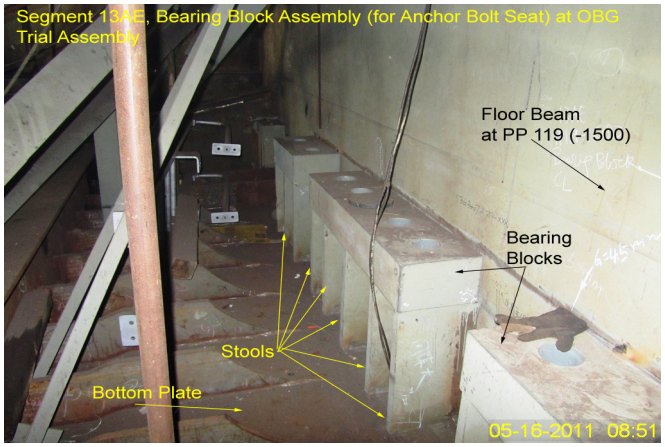
Mill to Bear (MTB) measured between the Stools to Bottom Plate.

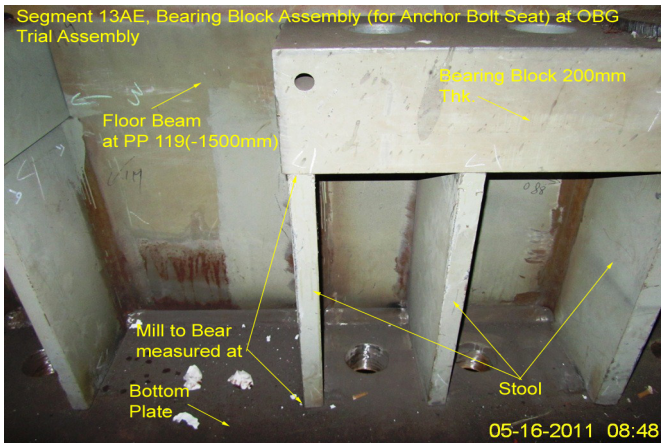
Please reference the pictures attached for more comprehensive details.

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

# WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*




**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.

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