

**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-016566**Date Inspected:** 03-Sep-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

<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>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<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

Segment 10AW to Segment 10BW (Skin Flatness)

This QA Inspector performed Joint Inspection along with ABF QA Inspector to check the Skin Flatness between Segment 10AW to Segment 10BW between Panel Points (PP) 88 and PP 89 at the following locations:

The skin flatness was measured on North side (Counter Weight Side at B1 and B2 location) and South side (Cross Beam side at B3 and B4 location) at 100mm from the weld connecting Bottom Panel to Side Panel using 5000mm string line to verify overall flatness. Straight Edges of 600mm and 630 mm of length was also used to measure the localized flatness.

The skin flatness was measured on North side (Counter Weight side at T1 location) and South side (Cross Beam side at T2 location) at 100mm from the weld connecting Deck Panel to Edge Panel using 5000mm string line to verify overall flatness. The Straight Edge of 600mm and 630 mm length was also used to measure the localized flatness.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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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 Support (Bay #7)

This QA Inspector performed Dimension Inspection to check and measure various items of the Bike Path support at Bay # 7 and the following items was inspected.

Bike Path type identified as BK1A.

1. Overall length of support (end of cantilever to edge panel contact flange) at east and west side.
2. Distance from end of cantilever to nearest anchor bolt at east and west side.
3. Longitudinal center to center spacing between anchor bolts at east and west side
4. Transverse center to center spacing between anchor bolts at east and west side.

The inspected Bike Path supports identified as below.

BK001-037-PP 73

BK001-038-PP 75

BK001-039-PP 77

BK001-040-PP 79

BK001-041-PP 81

BK001-043-PP 83

BK001-042-PP 85

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.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## 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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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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