

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-016576**Date Inspected:** 05-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

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

Incident Report generated at Lift 9 (Segment 9AE, 9BE, 9CE, 9DE and 9EE)

This Quality Assurance (QA) Inspector wrote an Incident Report for drilling hole too close the Fillet weld (which is designated as Fracture Critical Weld (FCW) as per approved shop drawing) and grinding off the fillet weld. The hole is drilled to facilitate installation of fasteners assembly connecting Suspender Bracket to Corner assembly, Bike Path Side at Panel Points (PP) 72, PP 74, PP 76, PP 78, PP 80, PP 82 and PP 84. Please reference the Incident Report # 04-0120F4_TL-15_B278_09-05-10_Lift 9E_drilled bolt hole_close to fillet weld_I-Stiffener_Bike Path side_at SPCA dated September 05, 2010 for further detail.

Please reference the pictures attached for more comprehensive details

Segment 9AE

This QA Inspector performed Dimension Control Inspection for the Segment 9AE and measured the distance

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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.

At Panel Points(PP) 71.25 and PP 71.75, Cross Beam Side.

At Panel Points(PP) 71.25 and PP 71.75, Bike Path side.

At Panel Points(PP) 72.25 and PP 72.75, Cross Beam Side.

At Panel Points(PP) 72.25 and PP 72.75, Bike Path 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.

Segment 9BE

This QA Inspector performed Dimension Control Inspection for the Segment 9BE and measured the distance 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.

At Panel Points(PP) 73.25 and PP 73.75, Cross Beam Side.

At Panel Points(PP) 73.25 and PP 73.75, Bike Path side.

At Panel Points(PP) 74.25 and PP 74.75, Cross Beam Side.

At Panel Points(PP) 74.25 and PP 74.75, Bike Path side.

At Panel Points(PP) 75.25 and PP 75.75, Cross Beam Side.

At Panel Points(PP) 75.25 and PP 75.75, Bike Path 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.

Segment 9CE

This QA Inspector performed Dimension Control Inspection for the Segment 9CE and measured the distance 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.

At Panel Points(PP) 76.25 and PP 76.75, Cross Beam Side.

At Panel Points(PP) 76.25 and PP 76.75, Bike Path side.

At Panel Points(PP) 77.25 and PP 77.75, Cross Beam Side.

At Panel Points(PP) 77.25 and PP 77.75, Bike Path side.

At Panel Points(PP) 78.25 and PP 78.75, Cross Beam Side.

At Panel Points(PP) 78.25 and PP 78.75, Bike Path side.

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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.

Segment 9DE

This QA Inspector performed Dimension Control Inspection for the Segment 9DE and measured the distance 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.

At Panel Points(PP) 79.25 and PP 79.75, Cross Beam Side.

At Panel Points(PP) 79.25 and PP 79.75, Bike Path side.

At Panel Points(PP) 80.25 and PP 80.75, Cross Beam Side.

At Panel Points(PP) 80.25 and PP 80.75, Bike Path side.

At Panel Points(PP) 81.25 and PP 81.75, Cross Beam Side.

At Panel Points(PP) 81.25 and PP 81.75, Bike Path 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.

Segment 9EE

This QA Inspector performed Dimension Control Inspection for the Segment 9EE and measured the distance 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.

At Panel Points(PP) 82.25 and PP 82.75, Cross Beam Side.

At Panel Points(PP) 82.25 and PP 82.75, Bike Path side.

At Panel Points(PP) 83.25 and PP 83.75, Cross Beam Side.

At Panel Points(PP) 83.25 and PP 83.75, Bike Path side.

At Panel Points(PP) 84.25 and PP 84.75, Cross Beam Side.

At Panel Points(PP) 84.25 and PP 84.75, Bike Path 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.

Suspender Bracket at Bay # 19

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector to check and measure the Suspender Bracket (SB) lifting rod hole spacing by placing the socket template at the following suspender

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brackets.

SB 74E which will be installed at Segment 9BE, Bike Path side.

SB 82E which will be installed at Segment 9DW, Counter Weight 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.

Segment 9AW, Segment 9BW and Segment 9CW (Cope Holes)

This QA Inspector performed Dimension Control Inspection for the Segment 9AW, Segment 9BW and Segment 9CW and measured the Cope holes dimensions located at the Longitudinal Diaphragms (East side) at the following locations:

Segment 9AW at Panel Point (PP) 73 at east side of work point W3 and work point W4.

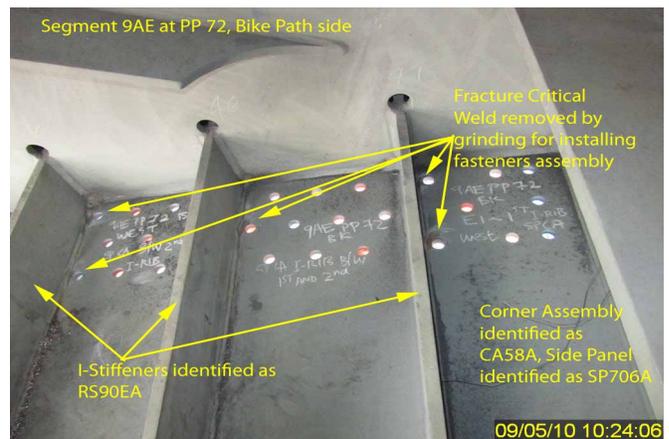
Segment 9BW at PP 76 at east side of work point W3 and work point W4.

Segment 9CW at PP 79 at east side of work point W3 and work point W4.

The QA Inspector measured the cope holes dimension using a 150mm steel ruler.

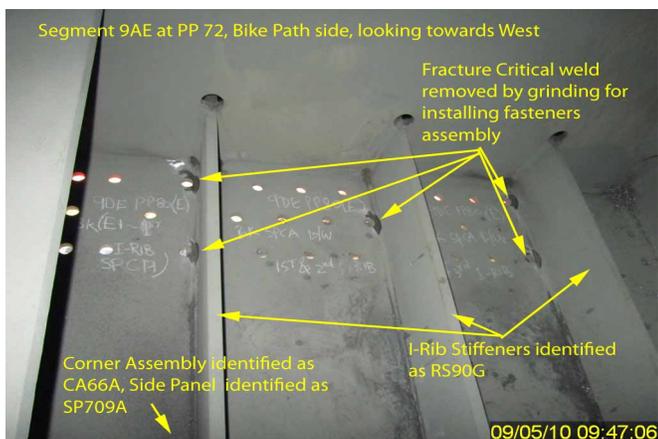
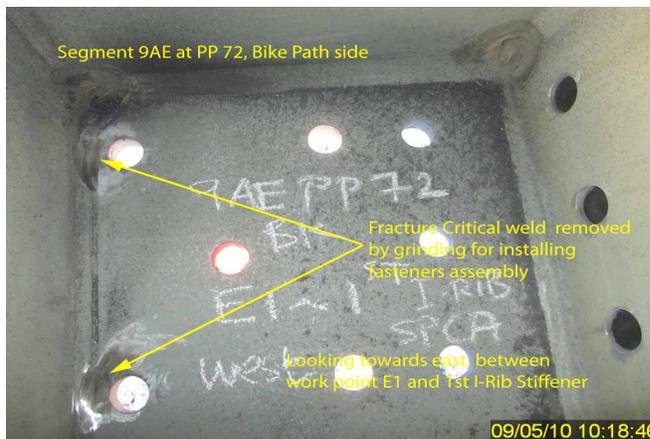
The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

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



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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.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer