

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-016625**Date Inspected:** 06-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

Segment 9AW

This QA Inspector performed Dimension Control Inspection for the Segment 9AW 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) 71.25 and PP 71.75, Counter Weight side.

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

At Panel Points(PP) 72.25 and PP 72.75, Counter Weight side.

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

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Segment 9BW

This QA Inspector performed Dimension Control Inspection for the Segment 9BW 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, Counter Weight side.

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

At Panel Points(PP) 74.25 and PP 74.75, Counter Weight side.

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

At Panel Points(PP) 75.25 and PP 75.75, Counter Weight side.

At Panel Points(PP) 75.25 and PP 75.75, Cross Beam 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 9CW

This QA Inspector performed Dimension Control Inspection for the Segment 9CW 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, Counter Weight side.

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

At Panel Points(PP) 77.25 and PP 77.75, Counter Weight side.

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

At Panel Points(PP) 78.25 and PP 78.75, Counter Weight side.

At Panel Points(PP) 78.25 and PP 78.75, Cross Beam 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 9DW

This QA Inspector performed Dimension Control Inspection for the Segment 9DW 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, Counter Weight side.

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

At Panel Points(PP) 80.25 and PP 80.75, Counter Weight side.

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

At Panel Points(PP) 81.25 and PP 81.75, Counter Weight side.

At Panel Points(PP) 81.25 and PP 81.75, Cross Beam 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 9EW

This QA Inspector performed Dimension Control Inspection for the Segment 9EW 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, Counter Weight side.

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

At Panel Points(PP) 83.25 and PP 83.75, Counter Weight side.

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

At Panel Points(PP) 84.25 and PP 84.75, Counter Weight side.

At Panel Points(PP) 84.25 and PP 84.75, Cross Beam 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 9CW, Segment 9DW and Segment 9EW (Cope Holes)

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

Segment 9CW at Panel Point (PP) 79 at east side of work point W3 and work point W4.

Segment 9DW at PP 82 at east side of work point W3 and work point W4.

Segment 9EW at PP 85 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

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Lead Inspector and Engineer for review and disposition.

Anchorage Bearing Stiffeners at Machine Shop # 1(for Lift 14)

This QA Inspector performed Dimension Control Inspection to check and measure the Anchorage Bearing Stiffeners at machine shop # 1. The following below mentioned dimensions was inspected.

Anchoring Bearing Stiffeners, anchor rod scribe line distance.

Anchoring Bearing Stiffeners, anchor rod offset #1 and offset # 2 from scribe line.

Anchoring Bearing Stiffeners, vertical spacing between the bearing stiffeners at four ends of bearing stiffener.

Anchoring Bearing Stiffeners, vertical offset.

Anchoring Bearing Stiffeners, surface condition meeting mill to bear condition at MTB1, MTB2 and MTB3 locations.

The Anchorage Bearing Stiffeners piece marks are identified as below.

- Anchorage Bearing Stiffeners identified as SA3349A and top plate piece mark identified as X4737D.
- Anchorage Bearing Stiffeners identified as SA3427A and top plate piece mark identified as X5037A.
- Anchorage Bearing Stiffeners identified as SA3351B and top plate piece mark identified as X4737Z.
- Anchorage Bearing Stiffeners identified as SA3350B and top plate piece mark identified as X4737M.
- Anchorage Bearing Stiffeners identified as SA3349J and top plate piece mark identified as X4737J.
- Anchorage Bearing Stiffeners identified as SA3351A and top plate piece mark identified as X4737Y.
- Anchorage Bearing Stiffeners identified as SA3427F and top plate piece mark identified as X5037F.
- Anchorage Bearing Stiffeners identified as SA3422B and top plate piece mark identified as X5030B.
- Anchorage Bearing Stiffeners identified as SA3349E and top plate piece mark identified as X4737E.
- Anchorage Bearing Stiffeners identified as SA3349B and top plate piece mark identified as X4737B.

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 150000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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