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 #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016663
Date Inspected: 10-Sep-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Li Yang and Zhu Zhong Hai

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

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 SA3423F and top plate piece mark identified as X5030R.

-Anchorage Bearing Stiffeners identified as SA3427E and top plate piece mark identified as X5037E.

-Anchorage Bearing Stiffeners identified as SA3422F and top plate piece mark identified as X5030E.

-Anchorage Bearing Stiffeners identified as SA3421E and top plate piece mark identified as X5028E.

-Anchorage Bearing Stiffeners identified as SA3422F and top plate piece mark identified as X5030F.

-Anchorage Bearing Stiffeners identified as SA3426E and top plate piece mark identified as X5025N.

-Anchorage Bearing Stiffeners identified as SA3421H and top plate piece mark identified as X5028H.

-Anchorage Bearing Stiffeners identified as SA3437H and top plate piece mark identified as X5039H.

-Anchorage Bearing Stiffeners identified as SA3348B and top plate piece mark identified as X4735B.

-Anchorage Bearing Stiffeners identified as SA3428A and top plate piece mark identified as X5037J.

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. Please reference the pictures attached for more comprehensive details.

Segment 10AE

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg060B-024. The welder identification was 044515 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-Repair-1. The piece mark was identified as the Longitudinal Diaphragm (LD) flange welded to floor beam at Work Point E4.

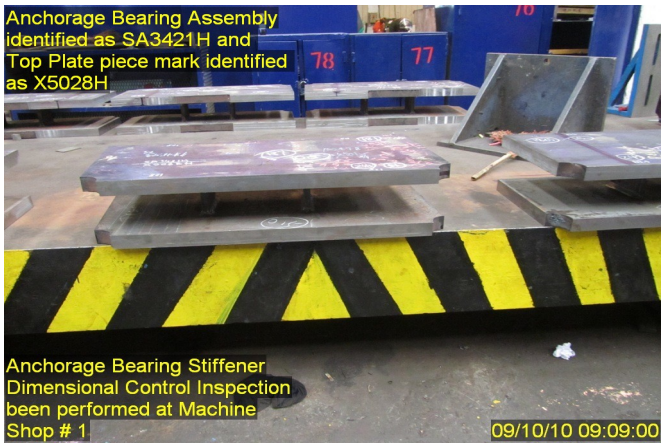
Segment 10AE

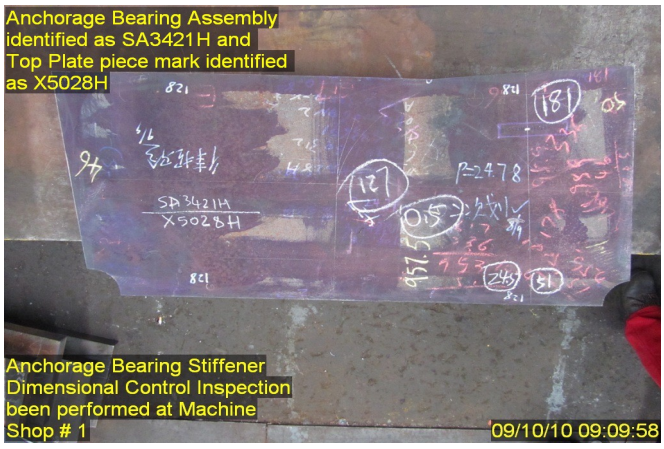
This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg060B-026. The welder identification was 044515 and was observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G(3F)-Repair-1. The piece mark was identified as the Longitudinal Diaphragm (LD) web welded to floor beam at Work Point E4.

Segment 10AE

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg060C-026. The welder identification was 044504 and was observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G(3F)-Repair-1. The piece mark was identified as the Longitudinal Diaphragm (LD) web welded to floor beam at Work Point E3.

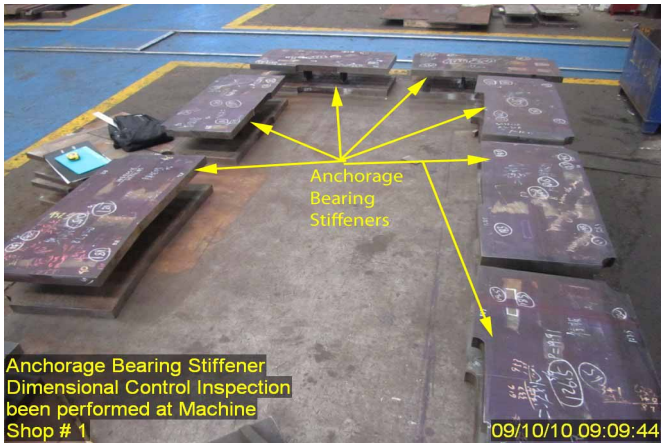
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

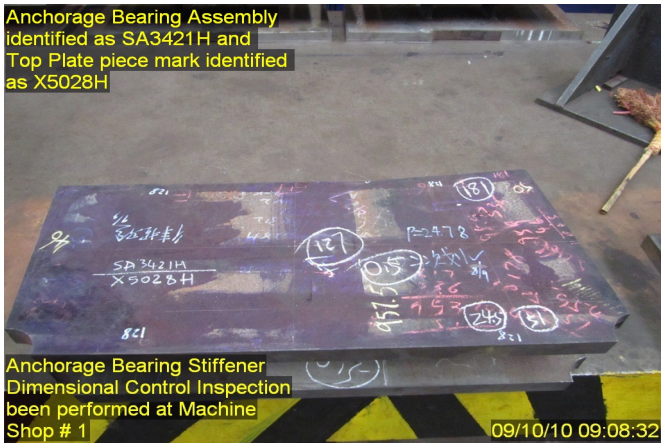




WELDING INSPECTION REPORT

(Continued Page 4 of 4)





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