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-016803
Date Inspected: 19-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:	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 10BE to Segment 10CE (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring Offset along with ABF QA Inspector on the U-Rib to U-Rib from Cross Beam side towards Bike Path side at a total of 39 locations on Segment 10BE to Segment 10CE between Panel Point (PP) 91 to PP 92 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

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 10CE to Segment 11AE (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring Offset along with ABF QA Inspector on the U-Rib to U-Rib from Cross Beam side towards Bike Path side at a total of 39 locations on Segment 10CE to Segment 11AE between Panel Point (PP) 94 to PP 95 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

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 10BW to 10CW (Transverse Splice T-Ribs)

This QA Inspector performed Dimension Control Inspection along with ABF QA personnel on the Transverse Splice T-Ribs to T-Ribs for the Segment 10BW to Segment 10CW between Panel Point (PP) 91 to PP 92 at the following locations:

Work Point W6 towards Work Point W4 (Side Panel Cross Beam Side) total 19 T-Ribs.

Work Point W4 towards Work Point W3 (Bottom Panel) total 18 T-Ribs.

Work Point W3 towards Work Point W1 (Side Panel Counter Weight Side) total 19 T-Ribs.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge and measured the Horizontal Offset on the web using a Bridge Cam gauge.

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.

Anchorage Bearing Stiffeners at Machine Shop # 1(for Lift 14- East and West)

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 SA3426F and top plate piece mark identified as X5025P.

-Anchorage Bearing Stiffeners identified as SA3428E and top plate piece mark identified as X5037N.

-Anchorage Bearing Stiffeners identified as SA3427D and top plate piece mark identified as X5037D.

-Anchorage Bearing Stiffeners identified as SA3353G and top plate piece mark identified as X4740G.

-Anchorage Bearing Stiffeners identified as SA3354J and top plate piece mark identified as X4742J.

-Anchorage Bearing Stiffeners identified as SA3355F and top plate piece mark identified as X4742Q.

-Anchorage Bearing Stiffeners identified as SA3428H and top plate piece mark identified as X5037S.

-Anchorage Bearing Stiffeners identified as SA3353A and top plate piece mark identified as X4740A.

-Anchorage Bearing Stiffeners identified as SA3425B and top plate piece mark identified as X5025B.

-Anchorage Bearing Stiffeners identified as SA3423J and top plate piece mark identified as X5030V.

-Anchorage Bearing Stiffeners identified as SA3422J and top plate piece mark identified as X5030J.

-Anchorage Bearing Stiffeners identified as SA3428C and top plate piece mark identified as X5037L.

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.

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