

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016807**Date Inspected:** 20-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

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 dimensional inspection was performed.

The scribe line distances of anchor rod were measured.

The offset were measured from scribe line.

The vertical spacing between the bearing stiffeners at four locations were measured.

The vertical offset between bearing stiffeners at two locations were measured.

The QA Inspector verified the surface condition met the mill to bear condition at MTB1, MTB2 and MTB3

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

locations.

The Anchorage Bearing Stiffeners piece marks are identified below.

- Anchorage Bearing Stiffeners identified as SA3426D and top plate piece mark identified as X5025M.
- Anchorage Bearing Stiffeners identified as SA3425C and top plate piece mark identified as X5025C.
- Anchorage Bearing Stiffeners identified as SA3427G and top plate piece mark identified as X5037G.
- Anchorage Bearing Stiffeners identified as SA3425D and top plate piece mark identified as X5025D.
- Anchorage Bearing Stiffeners identified as SA3423D and top plate piece mark identified as X5030N.
- Anchorage Bearing Stiffeners identified as SA3428B and top plate piece mark identified as X5037K.
- Anchorage Bearing Stiffeners identified as SA3348A and top plate piece mark identified as X4735A.
- Anchorage Bearing Stiffeners identified as SA3422D and top plate piece mark identified as X5030D.
- Anchorage Bearing Stiffeners identified as SA3426A and top plate piece mark identified as X5025J.
- Anchorage Bearing Stiffeners identified as SA3351D and top plate piece mark identified as X4737AB.
- Anchorage Bearing Stiffeners identified as SA3350C and top plate piece mark identified as X4737N.
- Anchorage Bearing Stiffeners identified as SA3427B and top plate piece mark identified as X5037B.

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 10AW to Segment 10BW (Longitudinal Diaphragm to Longitudinal Diaphragm)

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector on the Longitudinal Diaphragm to Longitudinal Diaphragm at Work Point W3 (Counter Weight side) and at Work Point W4 (Cross Beam side) for the Segment 10AW to Segment 10BW between Panel Point (PP) 88 to PP 89 at the following locations:

The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area. The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The Sweep was measured at 100 mm from both sides of the Floor Beam and 800mm from both sides of floor Beam and at Center (Total 5 Locations) using string line.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
