

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-017084**Date Inspected:** 29-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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		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 12AW (Green Tag DCP)

This QA Inspector performed Green Tag Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Segment 12AW from Panel Point (PP) 109 to PP 112.5 at the following locations:

The skin flatness was verified and measured across the longitudinal butt weld at Side Panel (SP) to Corner Assembly (CA) at the Counter Weight (CW) side and Cross Beam (CB) side from Panel Point (PP) 109 to PP 112.5. The QA Inspector measured the skin flatness using 600mm Straight Edge.

The skin flatness was verified and measured across the longitudinal butt weld at Deck Panel (DP) to Corner Assembly (CA) at the Counter Weight (CW) side and Cross Beam (CB) side from Panel Point (PP) 109 to PP 112.5. The QA Inspector measured the skin flatness using 600mm Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Lead Inspector and Engineer for review and disposition.

Segment 12CW (Green Tag DCP)

This QA Inspector performed Green Tag Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Segment 12CW from Panel Point (PP) 115 to PP 117.5 at the following locations:

The Floor Beam (FB) flatness was verified and measured from East and West side of the FB at Panel Points (PP) 115. The QA Inspector measured the flatness using 1500mm Straight Edge.

The Deck Panel to the Deck Panel Diaphragm plate plumbness and flatness was verified and measured from east and west side of the Deck Panel Diaphragm at Panel Points (PP) 115, PP 115.2, PP 115.5, PP 116, PP 116.5 and PP 117. The QA Inspector measured the plumbness using carpenter square and performed a flatness check using 710mm Straight Edge.

The skin flatness was verified and measured across the longitudinal butt weld at Side Panel (SP) to Corner Assembly (CA) at the Counter Weight (CW) side and Cross Beam (CB) side from Panel Point (PP) 115 to PP 117.5. The QA Inspector measured the skin flatness using 600mm Straight Edge.

The skin flatness was verified and measured across the longitudinal butt weld at Deck Panel (DP) to Corner Assembly (CA) at the Counter Weight (CW) side and Cross Beam (CB) side from Panel Point (PP) 115 to PP 117.5. The QA Inspector measured the skin flatness using 600mm Straight Edge.

The diameter of the cope holes at the Corner Assembly (CA) were verified and measured at Panel Points (PP) 115, PP 115.2, PP 115.5, PP 116, PP 116.5 and PP 117 at the Counter Weight (CW) side and Cross Beam (CB) side. The QA Inspector measured the diameter of the cope holes using a 150mm steel ruler.

The protrusion of the Deck Panel (DP) stiffener inside cope holes area at the Corner Assembly (CA) were verified and measured at the Panel Points (PP) 115, PP 115.2, PP 115.5, PP 116, PP 116.5 and PP 117 at the Counter Weight (CW) side and Cross Beam (CB) side. The QA Inspector measured the protrusion of stiffener 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.

Segment 10AE to Segment 10BE (Skin Flatness)

This QA Inspector performed Joint Inspection along with ABF QA Inspector to check the skin flatness between Segment 10AE to Segment 10BE between Panel Points (PP) 88 and PP 89 at the following locations after heat straightening:

The skin flatness was measured on North side (B2 location) and South side (Bike Path Side at B3) at 100mm from the weld connecting Bottom Panel to Side Panel straight edge of 630 mm of length to measure the localized flatness.

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.

Segment 10BE to Segment 10CE (Skin Flatness)

This QA Inspector performed Joint Inspection along with ABF QA Inspector to check the skin flatness between Segment 10BE to Segment 10CE between Panel Points (PP) 91 and PP 92 at the following locations after heat straightening.

The skin flatness was measured on North side (Cross Beam Side B2 location) and South side (Bike Path Side at B3 location) at 100mm from the weld connecting Bottom Panel to Side Panel using 5000mm string line to verify overall flatness. The straight edges of 600mm and 630 mm of length were also used to measure the localized flatness.

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
