

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017087**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), Changxing Island **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:	Orthotropic Box Girder (OBG)	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**Segment # 12AW (Green Tag)**

This QA performed a joint survey dimensional inspection of corner assembly Side Panel to Corner Assembly Longitudinal Weld Flatness & Deck Panel to Corner Assembly on segment 12AW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math; Measurements of the Flatness were taken from PP109 to PP112 Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly SP-SP & DP-DP Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 12CW (Green Tag) Joint Survey Dimensional Inspection:-

This QA performed a joint survey dimensional inspection of Plumbness & Flatness on segment 12CW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the Deck Panel

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diaphragm plate plumbness & Flatness were taken from PP115 to PP117. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Deck Panel Diaphragm Plate Plumbness & Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of Flatness on segment 12CW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the Floor Beam Flatness were taken from PP115 (Cross Beam & Counter Weight Side). Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: FB Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of corner assembly cope holes on segment 12CW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the cope holes were taken from PP115 to PP117 at the following locations: E1~E4, S1~S5 and T1~T3 on both the crossbeam and bike path sides. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly Cope Holes". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed a joint survey dimensional inspection of corner assembly Side Panel to Corner Assembly Longitudinal Weld Flatness & Deck Panel to Corner Assembly on segment 12CW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math; Measurements of the Flatness were taken from PP115 to PP117. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly SP-SP & DP-DP Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune, Manoj	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
