

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-017473**Date Inspected:** 19-Oct-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

Tower Cross Bracing

This QA Inspector witnessed final bolt tension verification on bolts connecting Cross Bracing pin. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00515 Dated October 19, 2010.

The bolt sizes used were M 3/4" x 3 3/4" RC Lot # DHG60625 and the final torque value established was 487 N-m.

The Manual Torque wrench used was Serial No. XO2-74. Please reference the pictures attached for more comprehensive details.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom panel for flatness check and

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

bike path identified as BK004-004.

The QA Inspector measured the flatness using 1500mm long straight edge and observed flatness dimensions within the allowable tolerance.

Suspender Bracket at Bay # 19

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector to check and measure the Suspender Bracket (SB) lifting rod hole spacing by placing the socket template at the following suspender brackets.

SB 86W which will be installed at Segment 10AW, Counter Weight side.

SB 88W which will be installed at Segment 10AW, Counter Weight side.

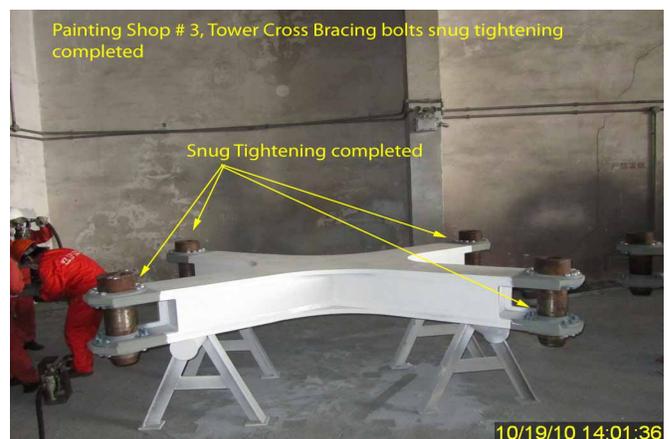
SB 90W which will be installed at Segment 10BW, Counter Weight side.

SB 92W which will be installed at Segment 10CW, Counter Weight side.

SB 94W which will be installed at Segment 10CW, Counter Weight side.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
