

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: 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-021495**Date Inspected:** 06-Mar-2011**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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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****DCP:****Segment 12AE ~ 12BE**

This QA Inspector performed dimensional Joint Inspection with American Bridge Fluor (ABF) for the Longitudinal Diaphragm to Longitudinal Diaphragm E3 location (Cross Beam side) and E3 location (Bike Path side) for Segment 12AE to 12BE between Panel Point (PP) 112 and PP 113. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: LD Offset and Sweep". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA Inspector performed dimensional Joint Inspection with American Bridge Fluor (ABF) for the Longitudinal Diaphragm to Longitudinal Diaphragm E4 location (Cross Beam side) and E4 location (Bike Path side) for Segment 12AE to 12BE between Panel Point (PP) 112 and PP 113. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: LD Offset and Sweep". This QA

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recorded the measurements and submitted the information to CT / QA lead inspector for review.

### Bay 19 (Bike Path)

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom plate for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Path.

BK005A-001-002.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge between across the longitudinal butt weld.

Observed flatness within the allowable tolerance.

The result of the inspection was informed to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

### Bay 8 (Bike Path)

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom plate for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Path.

BK004A-001-063.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge between across the longitudinal butt weld.

Observed flatness 5.6mm to 7mm using 600mm long straight edge out of tolerance.

The result of the inspection was informed to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

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

### Summary of Conversations:

No significant 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 phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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