

**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-023339**Date Inspected:** 05-May-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>              | <b>Yes</b>         | <b>No</b>            |
| <b>Inspected CWI report:</b>       | <b>Yes</b> <b>No</b> <b>N/A</b> | <b>Rod Oven in Use:</b>          | <b>Yes</b>         | <b>No</b> <b>N/A</b> |
| <b>Electrode to specification:</b> | <b>Yes</b> <b>No</b> <b>N/A</b> | <b>Weld Procedures Followed:</b> | <b>Yes</b>         | <b>No</b> <b>N/A</b> |
| <b>Qualified Welders:</b>          | <b>Yes</b> <b>No</b> <b>N/A</b> | <b>Verified Joint Fit-up:</b>    | <b>Yes</b>         | <b>No</b> <b>N/A</b> |
| <b>Approved Drawings:</b>          | <b>Yes</b> <b>No</b> <b>N/A</b> | <b>Approved WPS:</b>             | <b>Yes</b>         | <b>No</b> <b>N/A</b> |
| <b>Bridge No:</b>                  | 34-0006                         | <b>Delayed / Cancelled:</b>      | <b>Yes</b>         | <b>No</b> <b>N/A</b> |
|                                    |                                 | <b>Component:</b>                | 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 13BW to Segment 13CW (Skin Flatness)

This QA Inspector performed Dimensional Inspection, to check the skin flatness between Segment 13BW to Segment 13CW between Panel Points (PP) 122 and PP 112.5 at the following locations:

The skin flatness was measured on North side (Counter Weight side at B1 and B2 locations) and South side (Cross Beam side at B3 and B4 locations) at 100mm from the weld connecting Bottom Panel to Side Panel using 2500mm 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 skin flatness was measured on North side (Counter Weight side at T1 location) and South side (Cross Beam side at T2 location) at 100mm from the weld connecting Deck Panel to Edge Panel using 2500mm string line to verify overall flatness. The straight edges of 600mm and 630 mm length were also used to measure the localized flatness.

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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.

Note:

1. Observed Skin Flatness at B1 location out of tolerance thus, measurements were taken at locations B1-1 at 500mm from work point W13.

2. Observed Skin Flatness at B2 location out of tolerance thus, measurements were taken at locations B2-1 at 500mm and B2-2 at 900mm from work point W13.

3. Observed Skin Flatness at B4 location out of tolerance thus, measurements were taken at locations B4-1 at 500mm, at location B4-2 at 900 mm, at location B4-3 at 1200mm.

Bike Path at Bay # 10

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 Paths and Bike Path are identified as:

BK010A-001.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge between the stiffeners which are plug weld to bottom plate.

Observed flatness within the allowable tolerance.

The result of the inspection was informed to ZPMC QC Mr. Yu Zhi Zai, ABF Mr. Zhao Xian He and Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

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



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

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| <b>Inspected By:</b> | Math,Manjunath | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Miller,Mark    | QA Reviewer                 |

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