

**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-023347**Date Inspected:** 05-Jun-2009**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>	OBG Trial Assembly	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, 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) Trial Assembly Areas

4AW and 4BW

This Quality Assurance (QA) Inspector final tension verification carried out for 4AE to 4BE from PP24 to PP 28 Floor Beam Chevron (Upper Connecting Plate) were inspected on 10% random basis found satisfactory and green tag not signed off as held for calibration certificate. Bolt sizes used are M22x2.5x70 RC Set# DHGM220004 and final Torque required is 453 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled at 1000 Hrs. as ZPMC was not ready with the tightening the Inspection was been postponed to 1300 Hrs.

This Quality Assurance (QA) Inspector carried out the dimension inspection for 4AE to 4BE from PP 24 to PP28 at location W3 and W4 and recorded the dimension for the Bottom Panel deflection due to resting on the saddle so straightness from the W3 and W4 measure within 700 mm.

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

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# WELDING INSPECTION REPORT

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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 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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