

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-023534**Date Inspected:** 13-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

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

Segment 12CW (Bottom Panel)

This QA Inspector performed Dimensional Inspection, to check the skin flatness at the Transverse Splice at the Deck Panel using 2380mm string line.

Observed work point W4 towards W14 (Cross Beam side), the Bottom Panel flatness as 9mm after rectification, by re-welding the I-Stiffeners to the Floor Beam.

Observed work point W3 towards W13 (Counter Weight side), the Bottom Panel flatness as 12mm after rectification by heat straightening.

The measurements were recorded and informed to the Mr. Mark Miller and SMR Mr. Eric Tsang, the item was added in the punch list for further processing.

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Segment 13AW to Segment 13BW (Deck Panel)

This QA Inspector performed Dimensional Inspection, to check the skin flatness at the Transverse Splice at the Deck Panel using 630mm straight edge.

Observed work point W4 (Cross Beam side) out of flatness by 10 mm and Y location was pulled from Transverse splice as 600mm towards PP 120.5 and 970mm towards PP 121.

Observed work point W3 (Counter Weight side) out of flatness by 8mm and Y location was pulled from Transverse splice as 275mm towards PP 120.5 and 1060mm towards PP 121.

The measurements were recorded and informed to the Mr. Mark Miller and SMR Mr. Eric Tsang, the item was added in the punch list for further processing.

Segment 13BW to Segment 13CW (Deck Panel)

This QA Inspector performed Dimensional Inspection, to check the skin flatness at the Transverse Splice at the Deck Panel using 630mm straight edge.

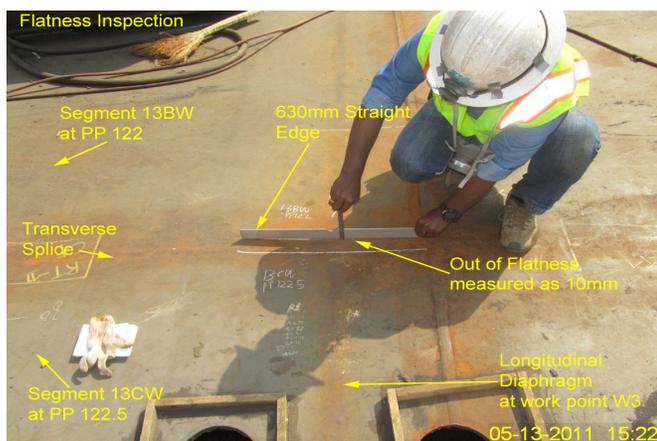
Observed work point W4 (Cross Beam side) out of flatness by 7 mm and Y location was pulled from Transverse splice as 560mm towards PP 122 and 1200mm towards PP 122.5.

Observed work point W3 (Counter Weight side) out of flatness by mm and Y location was pulled from Transverse splice as 710mm towards PP 122 and 1000mm towards PP 122.5.

The measurements were recorded and Informed to the Mr. Mark Miller and SMR Mr. Eric Tsang, the item was added in the punch list for further processing.

Please reference the pictures attached for more comprehensive details.

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.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
