

**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-023653**Date Inspected:** 17-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

Traveler Rails at Bay # 5

This QA Inspector performed Dimension Control Inspection on the Traveler Rails 3022TR1-001 for the following measurements and observed measured dimension in compliance contact document. Inspection was performed against the Inspection Notification # 09152 dated May 17, 2011 at Bay # 5.

Traveler Rails Thickness at typical section.

Traveler Rails Flange width at typical section.

Traveler Rails Depth at typical section.

Traveler Rails Flange curl at typical section.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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Traveler Rails Traveler Rail length.

Traveler Rails Camber.

Traveler Rails Side Wise Bend.

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. The result of the inspection was informed to ZPMC QC Mr. Huang Min, ABF Mr. Wang Zhong Yuan and Caltrans Lead Inspector Mr. Mark Miller.

Traveler Rails at Bay # 5

This QA Inspector performed Dimension Control Inspection on the Traveler Rails 3020TR1-001 for the following measurements and observed measured dimension in compliance contact document. Inspection was performed against the Inspection Notification # 09152 dated May 17, 2011 at Bay # 5.

Traveler Rails Thickness at typical section.

Traveler Rails Flange width at typical section.

Traveler Rails Depth at typical section.

Traveler Rails Flange curl at typical section.

Traveler Rails Traveler Rail length.

Traveler Rails Camber.

Traveler Rails Side Wise Bend.

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. The result of the inspection was informed to ZPMC QC Mr. Huang Min, ABF Mr. Wang Zhong Yuan and Caltrans Lead Inspector Mr. Mark Miller.

Please reference the pictures attached for more comprehensive details.

Segment 13AE, Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly

This QA Inspector performed Dimension Control Inspection on the Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly for Segment 13AE at the following locations along with ABF QA Mr. Wang at E3 locations.

Bearing Blocks are installed at PP 119 (-1500mm), Total 4 locations at West side of the Floor Beam.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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Bearing Blocks are installed at PP 119 (-1500mm), Total 4 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 to PP 119(-1500mm), Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119, Total 2 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119, Total 2 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 to PP 119(+1500mm), Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119 (+1500mm), Total 4 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119 (+1500mm), Total 4 locations at East side of the Floor Beam.

Dimension inspection was performed after passing the anchor rod at between the holes of Bearing Block to Bottom Plate and recorded the various measurements as following.

Gap between the Bearing Blocks to Floor Beam.

Mill to Bear (MTB) measured between the Stools to Bearing Block.

Mill to Bear (MTB) measured between the Stools to Bottom Plate.

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

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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# WELDING INSPECTION REPORT

*( Continued Page 4 of 4 )*

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