

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-024273**Date Inspected:** 06-Jun-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 13CW to Segment 14AW (Skin Flatness)

This QA Inspector performed Joint Inspection along with ABF QA Inspector to check the skin flatness between Segment 13CW to Segment 14AW between Panel Points (PP) 124.5 and PP 125 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 5000mm 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.

Segment 13CW to Segment 14AW (Root Gap and Offset)

This QA Inspector performed Dimension Control Inspection for measuring I-Stiffeners Offset at the Transverse Field Splice for the Segment 13CW to Segment 14AW between Panel Point (PP) 124.5 to PP 125 at the following locations:

Work Point W5 towards Work Point W16, at 5 locations (Edge Panel Cross Beam side).

Work Point W16 towards Work Point W14, at 17 locations (Side Panel, Cross Beam side).

Work Point W14 towards Work Point W4, at 6 locations (Bottom Panel, Cross Beam side).

Work Point W4 towards Work Point W3, at 18 locations (Bottom Panel).

Work Point W3 towards Work Point W13, at 21 locations (Bottom Panel, Counter Weight side).

Work Point W13 towards Work Point W17, at 5 locations (Side Panel Counter Weight Side).

Work Point W17 towards Work Point W19, at 7 locations (Edge Panel Counter Weight Side).

Work Point W20 towards Work Point W5, at 47 locations (Deck Panel).

The QA Inspector measured the I-Stiffeners Offset at the Transverse Field Splice using Taper Gauge and 1(One) meter Straight Edge.

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.

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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Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer