

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-024716**Date Inspected:** 17-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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		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

Bike Path at Bay # 19

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:

BK-024A.

BK-025A.

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.

Note: 1. Bike Path Bottom Plate dimension inspection performed observed several locations dimension out of

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tolerance, observed ZPMC performing Heat Straightening for BK-024A.

2. Bike Path Bottom Plate dimension inspection performed observed several locations dimension out of tolerance, observed ZPMC performing Heat Straightening for BK-025A.

The result of the inspection was informed to ZPMC QC Mr. Guo Xing Hiu, ABF Mr. Peng Wen Jung and Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

Segment 13BE and Segment 13CE at Blast Shop "C"

This QA Inspector performed pre-blasting Inspection from PP 120.5 towards PP 124.5 and marked the location which does not meet the pre-blast requirements.

Marked those locations on the drawing for further processing, informed and shown the locations to ABF and ZPMC QC.

Bike Path Railing at Bay # 1

This QA Inspector performed Dimension Control Inspection on the following Bike Path Railing against the Inspection Notification # 09501 dated June 17, 2011 at Bay # 1.

Bike Path Railing Identified as BKR-NS-3-PP18.

Bike Path Railing Identified as BKR-NS-3-PP36.

Bike Path Railing Identified as BKR-NS-3-PP50.

Bike Path Railing Identified as BKR-NS-3-PP52.

Bike Path Railing Identified as BKR-NS-3-PP64.

The following measurements were performed and observed dimensions are in compliance with the contact document.

Measured the Overall Length at 3 (Three) at various locations viz., A1, B1 and C1.

Measured the Overall Sweep at 3 (Three) at various locations viz., A1, B1 and C1.

Measured the distance between the Bike Path Railing Top Tubular section to the Bike Path Railing Middle Tubular section at various locations viz., B1, B2, B3; B4, B5, B6; B7, B8 and B9.

Measured the distance between the Bike Path Railing Bottom Tubular section to the Bike Path Flat Bed at various locations viz., C1, C2, C3; C4, C5, C6; C7, C8 and C9.

The measurements were informed to the Lead Inspector and Engineer for review and disposition. The result of the

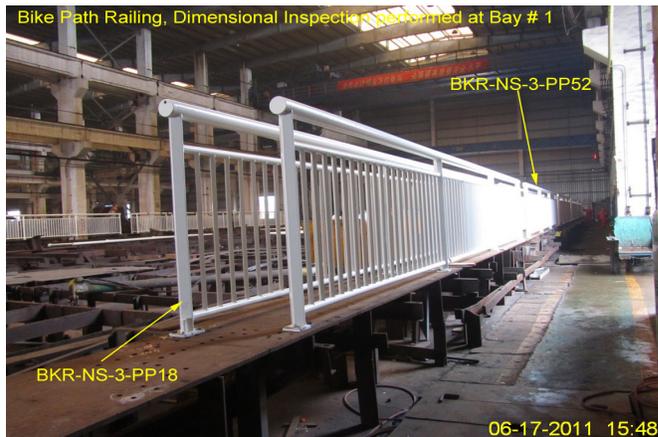
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inspection was informed to ZPMC QC Liu Fawen and Caltrans Lead Inspector Mr. Mark Miller.

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.



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
