

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-026031**Date Inspected:** 19-Jul-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

Cross Beam (CB) # 18 to Segment 13AE

This QA Inspector performed Dimension Control Inspection for measuring Gap between the stiffeners at the following locations.

At Vertical Floor Beam (FL3) extension at Segment 13AE to Cross Beam # 18 stiffeners.

At Panel Point (PP) 118, Segment 13AE Gap measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 119 (-1500), Segment 13AE Gap measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 119, Segment 13AE Gap measurement performed between Floor Beam (FL3) stiffeners to

WELDING INSPECTION REPORT

(*Continued Page 2 of 4*)

west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 119 (+1500), Segment 13AE Gap measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Panel Point (PP) 120, Segment 13AE Gap measurement performed between Floor Beam (FL3) stiffeners to west side Vertical Web Plate stiffeners of cross beam # 18 total 13 stiffeners.

At Deck Panel extension at Segment 13AE to Cross Beam # 18 stiffeners.

Between Panel Point (PP) 118 to PP 119 (-1500), Segment 13AE Gap measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 7 stiffeners.

Between Panel Point (PP) 119 (-1500) to 119, Segment 13AE Gap measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 3 stiffeners.

Between Panel Point (PP) 119 to 119 (+1500), Segment 13AE Gap measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 3 stiffeners.

Between Panel Point (PP) 119(+1500) to PP 120, Segment 13AE Gap measurement performed between Deck Panel (FL3) stiffeners to Deck Panel stiffeners of cross beam # 18 total 7 stiffeners.

At Bottom Panel extension at Segment 13AE to Cross Beam # 18 stiffeners.

Between Panel Point (PP) 118 to PP 119 (-1500), Segment 13AE Gap measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 7 stiffeners.

Between Panel Point (PP) 119 (-1500) to 119, Segment 13AE Gap measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 3 stiffeners.

Between Panel Point (PP) 119 to 119(+1500), Segment 13AE Gap measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 3 stiffeners.

Between Panel Point (PP) 119(+1500) to 120, Segment 13AE Gap measurement performed between Bottom Plate stiffeners to Bottom Panel stiffeners of cross beam # 18 total 3 stiffeners.

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 13AE to Segment 13BE (I-Stiffener Offset)

This QA Inspector performed Dimension Control Inspection for measuring I-Stiffeners Offset at the Transverse Field Splice for the Segment 13AE to Segment 13BE between Panel Point (PP) 120 to PP 120.5 at the following locations:

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Work Point E20 towards Work Point E18, at 8 locations (Edge Panel Bike Path side).

Work Point E18 towards Work Point E13, at 9 locations (Side Panel, Bike Path side).

Work Point E13 towards Work Point E3, at 12 locations (Bottom Panel, Bike Path side).

Work Point E3 towards Work Point E4, at 18 locations (Bottom Panel).

Work Point E4 towards Work Point E14, at 6 locations (Bottom Panel, Cross Beam side).

Work Point E14 towards Work Point E16, at 17 locations (Cross Beam side).

Work Point E16 towards Work Point E5, at 5 locations (Edge Panel Cross Beam side).

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.

Segment 13AW to Segment 13BW (I-Stiffener Offset)

This QA Inspector performed Dimension Control Inspection for measuring I-Stiffeners Offset at the Transverse Field Splice for the Segment 13AW to Segment 13BW between Panel Point (PP) 120 to PP 120.5 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 (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 12 locations (Bottom Panel, Counter Weight side).

Work Point W13 towards Work Point W18, at 9 locations (Side Panel, Counter Weight side).

Work Point E20 towards Work Point E18, at 8 locations (Edge Panel Counter Weight side).

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

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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.

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