

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008799**Date Inspected:** 29-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Jia			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 Trail Assembly		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 2AE

This Quality Assurance (QA) Inspector witnessed final tension verification for Suspender Bracket at PP 16 for Segment 2AE, Bike Path Side. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M24 x 75 RC Set# DHGM240020 and final Torque required was 600 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Bolt sizes used were M24 x 85 RC Set# DHGM240015 and final Torque required was 517 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Bolt sizes used were M27 x 85 RC Set# DHGM270001 and final Torque required was 853 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Segment 4AW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector witnessed final tension verification for Suspender Bracket at PP 26 for Segment 4AE, Counter Weight Side. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M24 x 75 RC Set# DHGM240020 and final Torque required was 600 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Bolt sizes used were M24 x 85 RC Set# DHGM240015 and final Torque required was 517 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Bolt sizes used were M27 x 85 RC Set# DHGM270001 and final Torque required was 853 N-m. Manual Torque wrench is been used with Sr. No. XQ2 - 584.

Segment 5BW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Longitudinal Diaphragm LD 10B. The weld joint no. Seg 023C-026 welding was in progress. The welder is identified as 220068. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-Tc-U4b-F and welding being carried out against Critical Welding Repair Procedure No. BWR 7051.

Segment 5BW to 5CW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Side Panel to Side Panel Transverse Weld Counter Weight Side. The weld joint no. OBW 5A – 11 and 12 welding was in progress. The welder is identified as 066571 and 037743. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2214-B-U2-FCM.

Segment 5BW to 5CW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Corner Assembly Counter Weight Side. The weld joint no. CA 019-005 and CA 021 -001 welding was in progress. The welder is identified as 068764. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2214-Tc-U4b-FCM.

CB4

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Stiffeners. The weld joint no. SSD10-A- 175 and 178 welding was in progress. The welder is identified as 202841. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i. e., WPS-B-T-2214-Tc-U4b-FCM.

Segment 1AE to 1AAE

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for repairing the Transverse Weld for Segment to Segment Bike Path side the Weld No. OBE 1A -004 as 65% weld been removed reviewed the approved CWR No. B-CWR-685 Rev. 0. The welder is identified as 045246. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-4G (4F)-Repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

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 , who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
