

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009239**Date Inspected:** 27-Sep-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 Jha and Xu Yumin**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 5AW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Brace for bolt connecting H-Beam to Floor Beam Flange North (Counter Weight) side and South (Cross Beam) side at PP 29, PP 30 and PP 31 for Segment 5AE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x80 RC Lot No. DHGM220012 and final Torque required was 427 N-m (23 Mpa).

Hydraulic Wrench was been used with Model No. MP532-2 and with Serial No. PW090331002.

Segment 5BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Brace for bolt connecting H-Beam to Floor Beam Flange North (Counter Weight) side and South (Cross Beam) side at PP 32, PP 33 and PP 34 for Segment 5BE. Inspected 10% on a random basis and found the tension to be in general

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compliance.

Bolt sizes used are M22x80 RC Lot No. DHGM220012 and final Torque required was 427 N-m (23 Mpa).

Hydraulic Wrench was been used with Model No. MP532-2 and with Serial No. PW090331002.

Segment 5CE

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Brace for bolt connecting H-Beam to Floor Beam Flange for North (Counter Weight) side and South (Cross Beam) side for PP 35 and PP 36 and at PP 36 North side (Counter Weight) side the Lower Chevron not been offered by ZPMC and ABF for Segment 5CE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x80 RC Lot No. DHGM220012 and final Torque required was 427 N-m (23 Mpa)

Hydraulic Wrench was been used with Model No. MP532-2 and with Serial No. PW090331002.

CB4

This Quality Assurance (QA) Inspector recorded the dimension along with Mr. Manikandan (QA) for Offset and Mis-alignment.

CB4

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for CB4 at 5BE side. The weld joint is identified as CB201A-004. The welder is identified as 067758. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-Tc-U4b-FCM-1.

Segment 5BE to 5BW

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW). The weld joint is identified as SSD010A-170. The welder is identified as 067756. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-Tc-U4b-FCM-1.

CB4

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for CB4 at 5BW side. The weld joint is identified as CB201A-006. The welder is identified as 067758. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2214-Tc-U4b-FCM-1.

Segment 5BE to 5BW

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This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW). The weld joint is identified as FB017-128. The welder is identified as 220066. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2232-Tc-U4c-F.

Segment 2AW

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Mis-drilled hole repair to cable tray bolt hole in T-Stiffener at PP 14 and 15. Welding was performed against Critical Welding Report B-CWR-755 Rev.1. The welder is identified as 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-1G(1F)-Repair-Misdrilled hole.

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
