

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-010236**Date Inspected:** 18-Nov-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:****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 date Caltrans OSM Quality Assurance (QA) Inspector, 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) Assembly Area

Signed Off Green Tag's

This Quality Assurance (QA) Inspector witnessed final tension verification for following depicted locations. Inspected 10% on a random basis and found the tension to be in general compliance and thus signed off the Green Tags.

At Segment 5AW at Panel Point 29 to 30 T-Stiffener Splice (Interior North SP) and Bolt Size used was M22 x 70 RC Set# DHGM220020 and final torque required was 520 N-m and Green Tag No. 431.

At Segment 5AW at Panel Point 29 to 30 T-Stiffener Splice (Interior North SP) and Bolt Size used was M22 x 75 RC Set# DHGM220005 and final torque required was 473 N-m and Green Tag No. 432.

Segment 6AW at PP 42

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This QA Inspector measured and recorded the distortion for Deck Panel to Deck Panel Diaphragm for all the 39 U-Ribs and noticed 4mm distortion between U-Rib no. 27 and 28 when measured from west side. Prepared the report and submitted to Engineer for reviewing. U-Rib numbering 1(one) start from Counter Weight side towards Cross Beam side 39(Thirty nine).

Segment 6AW at PP 43

This QA Inspector measured and recorded the distortion for Deck Panel to Deck Panel Diaphragm for all the 39 U-Ribs and noticed 4.5mm distortion between U-Rib no. 28 and 29 when measured from west side. Prepared the report and submitted to Engineer for reviewing. U-Rib numbering 1(one) start from Counter Weight side towards Cross Beam side 39(Thirty nine).

Segment 6AE to 6BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Side Panel T-Rib. The welder is identified as 049769. The Weld Joint is identified as SP565-001-086 and 087. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-B-U2-FCM-1.

Segment 6AE to 6BE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Panel T-Rib. The welder is identified as 220066. The Weld Joint is identified as SP525-001-029 and 030. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-B-U2-F.

Segment 6AE to 6BE

This QA Inspector observed ZPMC welding personnel performing Flux Cored Arc Welding (FCAW) for Side Panel T-Rib. The welder is identified as 067942. The Weld Joint is identified as SP605-001-064 and 065. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-2233-B-U2-F.

Segment 6AE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Side Panel Corner Assembly I-Rib. The welder is identified as 068764. The Weld Joint is identified as PP516-001-013/014. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-4114-1.

Segment 6BE

This QA Inspector observed ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Side Panel Corner Assembly I-Rib. The welder is identified as 068764. The Weld Joint is identified as

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PP517-001-003/004. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-T-4114-1.

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
