

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-012284**Date Inspected:** 23-Feb-2010**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:****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, 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) Trial Assembly Areas

OBG Trial Assembly Yard (Lift 5 East)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 29 to PP 36, East and West side of Floor Beam.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Lift 5 West)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at W3 Location from Panel Point (PP) 29 to PP 36, East and West side of Floor Beam.

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Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Lift 6 East)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 37 to PP 47, East and West side of Floor Beam.

Report forwarded to team leader for further action, kindly refer to the pictures attached below when measured with 25mm Radius template and 50mm Radius template.

OBG Trial Assembly Yard (Lift 6 West)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at W3 Location from Panel Point (PP) 37 to PP 47, East and West side of Floor Beam.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5AE/5BE)

Punch List item 306

The QA inspector performed inspection for the punch list item 306 for Longitudinal Diaphragm Web to Floor Beam web CJP was been cut apart and re-welded at E3 Bike Path side PP 31 and PP 32 and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5AE/5BE)

Punch List item 307

The QA inspector performed inspection for the punch list item 307 for Longitudinal Diaphragm Web to Floor Beam web CJP was been cut apart and re-welded at E4 Bike Path side PP 31 and PP 32 and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5AW/5BW)

Punch List item 308

The QA inspector performed inspection for the punch list item 308 for Longitudinal Diaphragm Web to Floor

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Beam web CJP and Longitudinal Diaphragm Flange to Floor Beam Web CJP was been cut apart and re-welded at W4 Cross Beam side PP 31 and PP 32 and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5BW/5CW)

Punch List item 309

The QA inspector performed inspection for the punch list item 309 for Longitudinal Diaphragm Web to Floor Beam web CJP was been cut apart and re-welded at W4 Cross Beam side PP 34 and PP 35 and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5BE/5CE)

Punch List item 310

The QA inspector performed inspection for the punch list item 310 for Longitudinal Diaphragm Web to Floor Beam web CJP was been cut apart and re-welded at E4 Cross Beam side PP 34 and PP 35 and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5CE)

Punch List item 312

The QA inspector performed inspection for the punch list item 312 for Longitudinal Diaphragm Flange to Floor Beam web CJP joint bevel was not prepared with a bevel landing per the approved drawing. This caused a 15mm gap between the Flange and Floor Beam web located at PP 36 Bike Path side and dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5CE)

Punch List item 315

The QA inspector performed inspection for the punch list item 315 for Side Panel to Bottom Panel weld splice between PP 36 and PP 37 Bike Path side was cut apart by the contractor for dimensional issues. Dimension verification performed, found the dimension meeting the requirements.

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Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 6AE/6BE)

Punch List item 319

The QA inspector performed inspection for the punch list item 319 for Excessive 20mm root opening was located on Side Plate to WT stiffener Web Splice weld SP361-001-027 at the 6AE to 6BE segment splice. Dimension verifications performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 5AW/5BW)

Punch List item 344

The QA inspector performed inspection for the punch list item 344 for I-Rib joining weld between 5AW to 5BW Cross beam side (W5) were misaligned and welded the weld joint identified as DP620A-001-025. Dimension verifications performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 6BW/6CW)

Punch List item 346

The QA inspector performed inspection for the punch list item 346 for misaligned area on weld joint OBE6A-003 closest to cross beam side of segment. Dimension verifications performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

OBG Trial Assembly Yard (Segment 6BW/6CW)

Punch List item 394

The QA inspector performed inspection for the punch list item 394 for T-Ribs to T-Ribs web misaligned area for SP083-002-044 (1st I-Rib on SP from top CB side), SP087-001-030 (6th T-Rib on BP from work point W3) and SP122-001-042(7th T-Rib on SP from bottom CW side). Dimension verifications performed, found the dimension meeting the requirements except for the SP122-001-042.

Report forwarded to team leader for further action.

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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 Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
