

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-012439**Date Inspected:** 05-Mar-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

Segment 5AW (Corner Assembly)

This Quality Assurance (QA) Inspector witnessed final tension verification for Corner Assembly at Panel Point (PP) 29 and PP 29.5 for Segment 5AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00271 Dated March 05, 2010.

Bolt sizes used were M22 x 85 RC Set# DHGM220047 and final torque required was 427 N-m.

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-584.

Segment 6AW

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This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 and W4 locations Panel Point (PP) 48 and PP 49. Report forwarded to team leader for further action. Please refer the picture attached below for more comprehensive details of measurements locations.

Segment 6BW

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 and W4 locations Panel Point (PP) 50, PP 51 and PP 52. Report forwarded to team leader for further action.

Segment 6CW

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 and W4 locations Panel Point (PP) 53, PP 54 and PP 55. Report forwarded to team leader for further action.

Segment 5AW

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 location Panel Point (PP) 29, PP 30 and PP 31. Report forwarded to team leader for further action.

Segment 5BW

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 location Panel Point (PP) 32, PP 33 and PP 34. Report forwarded to team leader for further action.

Segment 5CW

This Quality Assurance (QA) Inspector measured and recorded the Dimension for Floor Beam Stiffener to Longitudinal Diaphragm Flange for the Radius and Distance from the Edge to Weld and Weld Length from Cope Hole at W3 location Panel Point (PP) 35 and PP 36. Report forwarded to team leader for further action.

Segment 6AW

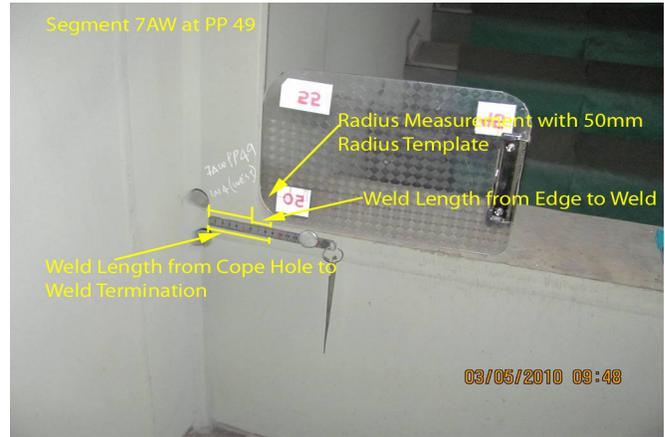
This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening on the deck panel diaphragm and Floor Beam flange at PP39 in OBG segment 6AW. Heat straightening record (HSR) identified as HSR1 (B)-8155.

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

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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