

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-013127**Date Inspected:** 07-Apr-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 9CW

This QA Inspector performed two (Caltrans QA and ABF QC) party joint Survey Inspection for the following Segment 9CW from Panel Point 77 to 79.

Corner Assembly Cope Holes dimension measurements at PP 76.5, PP 77, PP 77.5, PP 78, PP 78.5 and at PP 79 Cross Beam and Bike Path side.

Flatness measurement for Floor Beam at PP 77, PP 78 and PP 79 Cross Beam and Bike Path side.

Flatness measurement for Deck Panel to Corner Assembly from PP 76.25 to PP 79 Cross Beam and Bike Path side.

Flatness measurement for Side Panel to Corner Assembly from PP 76.25 to PP 79 Cross Beam and Bike Path side

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and

Plumbness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 77, PP 78 and PP 79 East and West side of the Diaphragm.

Segment 7CE (T-Ribs Connecting Clips to Floor Beam)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting T-Ribs to the Floor Beam at Bottom Panel, Side Panel Bike Path Side and Cross Beam side at Panel Point (PP) 53, PP 54 and PP 55 for Segment 7CE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00315 Dated April 07, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Segment 7DE (T-Ribs Connecting Clips to Floor Beam)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting T-Ribs to the Floor Beam at Bottom Panel, Side Panel Bike Path Side and Cross Beam side at Panel Point (PP) 56, PP 57 and PP 58 for Segment 7DE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00315 Dated April 07, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Segment 7EE (T-Ribs Connecting Clips to Floor Beam)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting T-Ribs to the Floor Beam at Bottom Panel, Side Panel Bike Path Side and Cross Beam side at Panel Point (PP) 59 and PP 60 for Segment 7EE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00315 Dated April 07, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

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Bolt sizes used were M16 x 50 RC Set# DHGM160004 and final torque required was 180 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

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
