

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-013806**Date Inspected:** 02-May-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 8AE (Side Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs (Total 19 Nos.) between Panel Point (PP) 62 to PP 62.5; PP 63 to PP 63.5 and PP 63.5 to PP 64 cross beam side for Segment 8AE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00339 Dated May 02, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220018 and final torque required was 447 N-m.

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

Note: The vertical offset measured as 4.5mm at 15th T-Rib for Segment 8AE between PP 62 to 62.5. Reinforcing splice plate to be installed at this location as per ABF No. 2004 Dated Dec 17, 2009 and reference taken from 1st T-Rib (Longitudinal Diaphragm) towards 19th T-Ribs.

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Segment 8CE (Side Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs (Total 19 Nos.) between Panel Point (PP) 68 to PP 68.5; PP 69 to PP 69.5 and PP 69.5 to PP 70 cross beam side for Segment 8CE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00339 Dated May 02, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220018 and final torque required was 447 N-m and

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 380 N-m.

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

Note: The vertical offset measured as 6.2mm, 5mm, 5.5mm, 6mm and 7.1mm at 15th, 16th, 17th, 18th and 19th T-Rib for Segment 8CE between PP 69 to 69.5. Reinforcing splice plate to be installed at this location as per ABF No. 2004 Dated Dec 17, 2009 and reference taken from 1st T-Rib (Longitudinal Diaphragm) towards 19th T-Ribs.

Segment 8AE to 8BE (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8AE to 8BE (Shop Segment Splice) between Panel Point (PP) 64 and PP 65. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 7CW to 7DW (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7CW to 7DW (Shop Segment Splice) between Panel Point (PP) 55 and PP 56. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 7EE to 8AE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 7EE to 8AE (Shop Segment Splice) between Panel Point (PP) 60 and PP 61 North(Cross Beam) and South (Bike Path) side for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet, generated the report and submitted to the Lead and Engineer for review.

Segment 8BE to 8CE (T-Rib Transverse Splice)

This QA Inspector performed dimension Inspection along with Mr. Manoj Prabhune for measuring and recording the Vertical Offset (at Flange), Horizontal Offset(at Web) for Segment 8BE to 8CE (Shop Segment Splice)

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between Panel Point (PP) 67 and PP 68 at the following locations

Side Panel from work point E1 to E3.

Bottom Panel from work point E3 to E4.

Side Panel from work point E4 to E6.

The measured and recorded values were submitted to Lead and Engineer for further action.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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