

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-007191**Date Inspected:** 28-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	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 Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the trial assembly area:

ZPMC workers were performing installation of ASTM A325 bolt sets in the deck plate U-rib connections at OBG sections 4AE/4BE. The metal containers containing the bolt sets were marked as follows: ASTM A325 – M22 x 65; Lot #'s MD191Z, MF421Z, B9924Z; Set # DHGM220016. It appeared to this QA Inspector, George Goulet, that the ZPMC workers were snug tightening the bolt sets with a hand wrench. However, this QA Inspector, George Goulet, observed many bolts only hand tight.

Bolt sets had been installed in many connections between panel point 24 and panel point 26, but many were missing and the condition was undetermined. Also, many bolts installed were less than flush with the outer face of the nuts.

This QA Inspector, George Goulet, reviewed the Caltrans-approved SFOBB Project HS Bolt Installation and Inspection Plan, and also the RCSC Specification for Structural Joints Using ASTM A325 or A390 Bolts.

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

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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 Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
