

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-008392**Date Inspected:** 04-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****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 Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (4AE)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Counter weight. The weld designations reviewed are as follows:

SSD19-PP024-004

SSD19-PP024-005

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed 10% final tension verification for U-Rib (Big spliced plate) on 2AW. The panel point, U-Rib numbers and bolt size designations are as follows:

PP-13.5 to PP-14.5-M22 X 85, M22 X 65, M22 X 80

U-Rib locations from counter weight side (North) – 4, 17, and 21

OBG # TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA inspector witnessed 10% final tension verification on Floor Beam angle brace – X321 (Bottom and side plate) on 1BW and 2AW. The panel point and bolt size designations are as follows:

PP-10.5, PP12.5, PP13.5 – M22 X 75, M22 X 55, M22 X 65

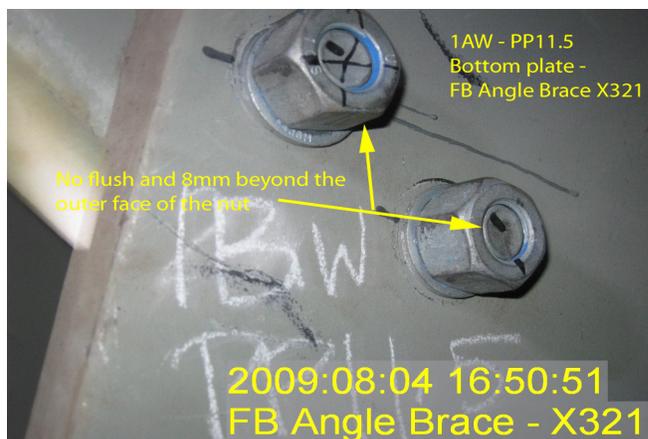
PP-11.5 – M22 X 55, M22 X 65

OBG # TRIAL ASSEMBLY YARD

PP- 11.5 – M22 X 75 (Bottom Plate)

This QA inspector observed no flush and also threaded end of bolt is 8mm beyond the outer face of the nut on PP 11.5 of 1BW floor beam angle brace – X321(Bottom plate).ZPMC provided Caltrans a notification to perform QA Inspections for these welds on Aug. 04, 2009 which indicated ZMPC’s acceptance of the final tensioning. please see the attached pictures below.

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



Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in 1BW- PP11.5. And prior to issue it was informed to ZPMC QC and ABF QA.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer