

**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-008393**Date Inspected:** 24-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**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 Trail 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 4AE to 4BE

This Quality Assurance (QA) Inspector carried out inspection for bottom panel to floor beam connecting clips and side panel to floor beam connecting clips and noticed from PP 24 to 28 all of them are installed.

Segment 3AE to 3BE

This Quality Assurance (QA) Inspector carried out inspection for bottom panel to floor beam connecting clips and side panel to floor beam connecting clips and noticed from PP 19 to 23 all of them are installed.

Segment 4AW to 4BW

This Quality Assurance (QA) Inspector carried out inspection for bottom panel to floor beam connecting clips and side panel to floor beam connecting clips and noticed from PP 24 to 28 all of them are installed.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

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## Segment 3AW to 3BW

This Quality Assurance (QA) Inspector carried out inspection for bottom panel to floor beam connecting clips and side panel to floor beam connecting clips and noticed from PP 19 to 23 all of them are installed.

## Segment 3AW

This Quality Assurance (QA) Inspector observed temporary sea fastening structure bolt tightening in progress at PP 19.

## Segment 2BW

This Quality Assurance (QA) Inspector observed floor beam flange to deck panel diaphragm connecting weld excavation by grinding in progress for repair both side i.e., east and west side of the deck panel diaphragm at PP 18.

## Segment 2BW and 2AW

This Quality Assurance (QA) Inspector observed floor beam flange to deck panel diaphragm connecting weld excavation by grinding in progress for repair both side i.e., east and west side of the deck panel diaphragm at PP 17 and 16.

## Segment 2BW and 2AW

This Quality Assurance (QA) Inspector observed heavy splice plate installation in progress for U-Rib between PP 17 and 16 bolts sizes used were M22x85; M22x80 and M22x65.

## Segment 2AW

This Quality Assurance (QA) Inspector observed floor beam flange to deck panel diaphragm connecting weld excavation by grinding in progress for both side i.e., east and west side of the deck panel diaphragm at PP 15 due to MT and UT reject.

## Segment 1AW

This Quality Assurance (QA) Inspector observed bolts and taper pins installation for stiffener connection above the manhole which facilitates the entrance to side panel at PP 8.5 at internal side of longitudinal shear plates.

## Segment 1AW

This Quality Assurance (QA) Inspector observed deck panel diaphragm to floor beam connecting weld excavation by grinding is in progress at PP 8.5.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

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## Segment 1AE

This Quality Assurance (QA) Inspector observed cross beam side lower chevron window opening for bolts installation cover plate fitting in progress at PP 8.5.

## Segment 1AE to 1BE

This Quality Assurance (QA) Inspector observed holes drilled on segment splice of longitudinal shear plate burring of all holes in progress manually for cross beam and bike path side at segment 1AE to 1BE at PP 10 and PP10.5.

## Segment 1AE

This Quality Assurance (QA) Inspector observed flush grinding in progress for segment splice between 1AE to 1BE bolts and taper pins installation for stiffener connection above the manhole which facilitates the entrance to side panel at PP 8.5.

## Segment 1AE to 1BE

This Quality Assurance (QA) Inspector observed overhead position flush grinding for segment weld next to U-Rib in progress at bike path side at PP 10 and 10.5.

## Segment 1BE

This Quality Assurance (QA) Inspector observed bike path side bolts installation for longitudinal shear plate in progress grade A325 at PP 12 and 12.5.

## Segment 4AW

This Quality Assurance (QA) Inspector observed sea fastening structure bolt installation in progress.

## Segment 1AE to 1BE

This Quality Assurance (QA) Inspector observed overhead position flush grinding for segment weld next to U-Rib in progress at bike path side at PP 10 and 10.5.

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

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# WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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