

**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-008753**Date Inspected:** 29-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**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

Lift 3 East

This Quality Assurance (QA) Inspector witnessed final tension verification against Bolting Inspection Notification Sheet No. 00079 Dated 7.28.2009. for U-Rib to U-Rib (for replaced big splice) at location 34 U-Rib between PP 22 and 23 for Segment 3AE. Inspected 10% of the bolts on random basis and found the tension to be in general compliance. Bolt sizes used are M22 x 65 RC Lot No. DHGM220033 and final Torque required was 470 N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-578

3AE to 3BE

This Quality Assurance (QA) Inspector inspected along with ABF QA the distortion that occurred at the Bottom Panel from external side the reading are been recorded the Segment to Segment weld been checked by 600mm straight edge and rest of area such as Bottom Panel to Side Panel connection distortion been checked by 630mm straight edge.

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### 3AW to 3BW

This Quality Assurance (QA) Inspector inspected along with ABF QA the distortion that occurred at the Bottom Panel from external side the reading are been recorded the Segment to Segment weld been checked by 600mm straight edge and rest of area such as Bottom Panel to Side Panel connection distortion been checked by 630mm straight edge.

### 4AE to 4BE

This Quality Assurance (QA) Inspector inspected along with ABF QA the distortion that occurred at the Bottom Panel from external side the reading are been recorded the Segment to Segment weld been checked by 600mm straight edge and rest of area such as Bottom Panel to Side Panel connection distortion been checked by 630mm straight edge.

### 4AW to 4BW

This Quality Assurance (QA) Inspector inspected along with ABF QA the distortion that occurred at the Bottom Panel from external side the reading are been recorded the Segment to Segment weld been checked by 600mm straight edge and rest of area such as bottom panel to Side Panel connection distortion been checked by 630mm straight edge.

### 2AE to 2BE

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 16 and 17.

### 2AW to 2BW

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 16 and 17.

### 2BE to 3AE

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 18 and 19.

### 2BW to 3AW

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 18 and 19.

### 3AE to 3BE

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This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 22 and 23.

3AW to 3BW

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 22 and 23.

4AE to 4BE

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 25 and 26.

4AW to 4BW

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 25 and 26

4BE to 5AE

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 28 and 29

4BW to 5AW

This Quality Assurance (QA) Inspector prepared the Punch list for Longitudinal Stiffener for misalignment (offset) and for Sweep too between PP 28 and 29.

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

### Summary of Conversations:

No Relevant Conversation

### 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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<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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