

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-009955**Date Inspected:** 14-Oct-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 day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trail Assembly Area

Signed Off Green Tag's

This Quality Assurance (QA) Inspector witnessed final tension verification for following depicted locations. Inspected 10% on a random basis and found the tension to be in general compliance and thus signed off the Green Tags.

At Segment 5AE, 5BE and 5CE at Panel Point 29, 30, 31, 32, 33, 34, 35 and 36 Lower Chevron Brace and Bolt Size used was M22 x 65 RC Set# DHGM220033 and witnessed at random 180 Degree Turn of Nut and Green Tag No. 376.

At Segment 5AE, 5BE and 5CE at Panel Point 29, 30, 31, 32, 33, 34, 35 and 36 Lower Chevron Brace and Bolt Size used was M22 x 75 RC Set# DHGM220005 and final torque required was 473 N-m and Green Tag No. 377.

At Segment 2AW at Panel Point 14, 15 and 16 for CB1 Diaphragm to Side Panel plate and Bolt Size used was M24 x 65 RC Set# DHGM240009 and final torque required was 567 N-m and Green Tag No. 378.

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At Segment 2AW at Panel Point 14, 15 and 16 for CB1 Diaphragm to Side Panel plate and Bolt Size used was M24 x 70 RC Set# DHGM240010 and final torque required was 560 N-m and Green Tag No. 379.

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.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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