

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-009982**Date Inspected:** 02-Nov-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:** Li Yang and Xu Yumin**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) Assembly Area

Segment 5BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel to Side Panel T-Rib Splice Plate between PP 33 and PP 34 for Segment 5BE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x65 RC Lot No. DHGM220016 and final Torque required was 495 N-m.

Manual Torque wrench has been used with Serial No. XQ2-625.

Segment 1AE to 1BE

This QA Inspector observed Transverse Segment to Segment Splice weld for Bottom Panel Weld No. OBE1A-008 repair as per Critical Weld Report B-CWR874 has been performed and Y Datum locations determined as

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following.

Excavation Performed from Internal Side

1. Y Location = 630mm
2. Y Locations = 1520 and 1540mm.
3. Y Location = 2965mm.
4. Y Locations = 3545 and 3685mm.
5. Y Location = 5240mm.
6. Y Locations = 6185 and 6255mm.
7. Y Location = 7105mm.

In which from Sr. No. 1 to 4 external side repairs performed and completed and from internal side flush grinding being performed and form 5 to 7 (3 locations) excavation preparation from internal side was in progress.

Segment 1AE to 1BE

This QA Inspector observed Transverse Segment to Segment Splice weld for Side Panel Weld No. OBE1A-007 repair as per Critical Weld Report B-CWR874 has been performed and Y Datum locations are as following.

Excavation Performed from Internal Side

1. Y Location = 2380mm
2. Y Location = 4200.
3. Y Location = 5060mm.
4. Y Location = 5890mm.
5. Y Location = 6325mm.

Segment 1AW to 1AAW

This QA Inspector observed stiffeners welded in front of Transverse Splice the Retro Plates welded earlier been flame cut and removed at Side Panel side of Cross Beam and Bike Path side and flush grinding for base metal and weld of stiffener is in progress noticed fresh lot of stiffeners with steel backing bars are laying down which is about to be fitted at location.

Segment 1AW to 1AAW

This QA Inspector observed Bottom Panel Transverse Segment to Segment Weld from inside excavated and weld is identified as OBW1A-008 for the Bottom Panel and Critical Welding Report No. B-CWR 875. The whole weld from inside have to be excavated and excavation was been performed as per the UT report the whole weld excavation from Y Datum location from 0 to 8500mm except the sample withdrawn area 300mm long.

Bike Path Cantilever

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This QA Inspector observed Bike Path Cantilever BK-001-016-3GK, BK-001-018-3GK and BK-001-020-3GK Base Plate are cut removed by flame cutting and preparation for fit-up is in progress reason for cutting the Base Plate is unknown and ZPMC is having Caltrans Engineer approval or not to be confirmed by Caltrans Engineer.

Lift 5

This QA Inspector observed Big Spice Plate fabrication was in progress as the wind speed measured by Anemometer and found to be 10.7 miles per hour when informed to ZPMC QC and ABF QA they arranged to stop the FCAW welding.

Segment 5BW to 5CW

This QA Inspector observed Side Panel to Side Panel T-Rib for Segment 5BW to 5Cw between PP 34 and PP 35 Cross Beam side bolt installation in progress ASTM A 325 Grade Bolt.

Segment 5BE

This QA Inspector observed Side Panel to Side Panel T-Rib for Segment 5BE to 5BE between PP 33 and PP 35 Cross Beam East and West side bolt installation was in progress ASTM A 325 Grade.

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.

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