

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-010237**Date Inspected:** 16-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:****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 6AW

This QA Inspector observed the Heat Straightening was been performed at Deck Panel Diaphragm as during fabrication it got 20 mm distorted (dimension confirmed from HSR Report No. HSR 1(B)-7886 Rev.0) Measured the distortion for Deck Panel to Deck Panel Diaphragm for all the 39 U-Ribs and noticed 16.4mm distortion between U-Rib 16 and 17 when measured from west side and when measured from east side found >20mm. Prepared the report and submitted to Engineer for reviewing.

Segment 1AW to 1BW

This QA Inspector observed at Segment 1AW to 1BW Transverse Segment Splice between PP 10 and PP 10.5 Bottom Panel Weld No. OBW1A-008 repair excavated areas welded and Post heating electric resistance pad is on and Post Weld completed areas flush grinding of the weld was in progress.

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Segment 1AW

This QA Inspector observed at Segment 1AW between PP 8.5 to PP 9 Bike Path side for Bottom Panel to Side Panel connecting weld repair welding completed and flush grinding has been performed.

Segment 6AE to 6BE

This QA Inspector observed at Segment 6AE to 6BE Transverse Segment Splice between PP 40 and PP 41 side panel Bike Path side welding completed thus grinding been performed.

Segment 6AE to 6BE

This QA Inspector observed at Segment 6AE to 6BE Transverse Segment Splice between PP 40 and PP 41 Side Panel Corner Assembly Bike Path side "I" Rib Hold Back area grinding has been performed to remove the paint and surface preparation for base metal was been performed for fillet welding.

Segment 6AE

This QA Inspector observed at Segment 6AE at PP 38 Side Panel to Side Panel Cross Beam T-Rib first bolt hole to the next T-Rib first bolt hole distance measurement taken by ZPMC as to fabricate the proper splice plate with exact hole match.

Segment 6AW

This QA Inspector observed at Segment 6AW at PP 38 Deck Panel Diaphragm connecting to floor beam flange got distorted thus heat straightening been performed by ZPMC to straight the flange and work is been performed against Heat Straightening Record (HSR1) Record No. HSR1(B)-7886 Rev. 0 Dated Nov 12, 2009 maximum deformation as per report observe as 20mm.

Segment 6BW

This QA Inspector observed at Segment 6BW between PP 38 and PP 39 for Corner Assembly Counter Weight side back to back cross and fitment/installation has been performed.

Segment 2AW

This QA Inspector observed at Segment 2AW at PP 16 Longitudinal Diaphragm Short Length one got distorted and heat straightening was performed but could not straighten as Offset and Sweep Dimension. Thus stiffener identified as X76N was cut and straightening the LD was performed and welded the stiffener from one side and other side back gouging and welding is balance.

Segment 6AE

This QA Inspector observed at Segment 6AE at PP 38, 39 and 40 FL3 location floor beam extended portion

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stiffener to Side Panel stiffener plate installation has been performed so that bolt connection can be installed.

Segment 6AW

This QA Inspector observed at Segment 6AE at PP 38, 39 and 40 FL3 area extended floor beam fit-up is in progress.

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
