

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-010239**Date Inspected:** 09-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 5BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel to Side Panel T-Rib, Cross Beam Side between PP 32.5 and PP 33 for Segment 5BW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required is 543 N-m.

Manual Torque wrench is been used with Sr. No. XO2 - 675.

Segment 5BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel to Side Panel T-Rib, Cross Beam Side between PP 33 and PP 33.5 for Segment 5BW. Inspected 10% on a random basis and found the

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tension to be in general compliance.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required is 543 N-m.

Manual Torque wrench is been used with Sr. No. XO2 - 675.

Note: Between PP 33 and PP 33.5 4th T-Rib from Longitudinal Stiffener Splice plate and bolts not installed thus, ZPMC did not offered for inspection.

Segment 5BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel to Side Panel T-Rib, Cross Beam Side between PP 33.5 and PP 34 for Segment 5BW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required is 543 N-m.

Manual Torque wrench is been used with Sr. No. XO2 - 675.

Segment 5BW to 5CW

This QA Inspector measured and recorded the dimension for Longitudinal Stiffener for Offset at the Segment 5BW to 5CW between PP 34 to 35 and found the following readings at following locations as per approved DPC drawing.

Location 1: 0 and +1mm

Location 2: 0 and 0

Location 3: +5mm and +5mm

Location 4: 0 and +4.2mm

Location 5: +4.1 and +4.8mm

Segment 2AE to 2BE

This QA Inspector measured and recorded the dimension for Longitudinal Stiffener for Sweep at the Segment 2AE to 2BE between PP 16 to 17 and found the following readings at following locations as per approved DPC drawing.

Longitudinal Stiffener SWEEP at survey point between Floor Beam to Floor Beam, Cross Beam Side observed as 3mm.

100mm to FB 1 Sweep found as 0mm

800mm to FB 1 Sweep found as 5mm

Mid Point Sweep found as 6mm

100mm to FB 2 Sweep found as 3mm

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800mm to FB 2 Sweep found as 0mm

Longitudinal Stiffener SWEEP at survey point between Floor Beam to Floor Beam, Bike Path Side observed as 5mm.

100mm to FB 1 Sweep found as 0mm

800mm to FB 1 Sweep found as 3mm

Mid Point Sweep found as 8mm

100mm to FB 2 Sweep found as 6mm

800mm to FB 2 Sweep found as 0mm

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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