

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-011715**Date Inspected:** 31-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**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) Trial Assembly Areas

Segment 6AW (Lower Chevron)

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron (North and South side) from Panel Point (PP) 37, PP 38 and PP 39 for Segment 6AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00247 Dated January 31, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required was Rotation of Nut at 180 Degree.

Note: Torque wrench is not accessible due to design reasons.

Segment 6AW (Lower Chevron)

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This Quality Assurance (QA) Inspector witnessed final tension verification for U-Rib to U-Rib at Panel Point (PP) 31 and PP 32 for Segment 6AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00248 Dated January 31, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220033 and final torque required was 470 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-675.

Note: 30th location U-Rib tension verification was not performed as ZPMC has not installed ASTM A 325 bolts at Reinforcing Splice Plate.

Segment 7BE to 7CE

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for Side Panel Bike Path side. The weld joint was identified as SP 365-044 to SP 365-054. The welder was identified as 069683. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 7BE to 7CE

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for Side Panel Bike Path side. The weld joint was identified as SP 311-051 to SP 311-063. The welder was identified as 067829. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 7BE to 7CE

This QA Inspector observed ZPMC welding personnel performing repair welding by Shielded Metal Arc Welding (SMAW) for Side Panel Cross Beam side. The weld joint was identified as SP 311-051 to SP 311-063. The welder was identified as 067829. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-B-U2-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

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 Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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