

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-011840**Date Inspected:** 01-Feb-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:****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 to 6BW (Longitudinal Diaphragm) Individual QA Survey

This QA Inspector performed Individual QA Survey along with Mr. Manoj Prabhune for the Longitudinal Diaphragm to Longitudinal Diaphragm for Segment 6AW to 6BW (Shop Segment Splice) between Panel Point (PP) 40 and PP 41 North and South side. The measured readings were data recorded and fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 6BW (Lower Chevron X3D Angle)

This Quality Assurance (QA) Inspector witnessed final Rotation of Nut for Lower Chevron (North and South side) from Panel Point (PP) 41, PP 42 and PP 43 for Segment 6BW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00249 Dated February 01, 2010.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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 6CW (Lower Chevron X3D Angle)

This Quality Assurance (QA) Inspector witnessed final Rotation of Nut for Lower Chevron (North and South side) from Panel Point (PP) 44, PP 45, PP 46 and PP 47 for Segment 6CW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00249 Dated February 01, 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 X3D Angle)

This Quality Assurance (QA) Inspector witnessed final Rotation of Nut for Lower Chevron (North and South side) from Panel Point (PP) 39 for Segment 6AW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00250 Dated February 01, 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 X3D Angle)

This Quality Assurance (QA) Inspector witnessed final Rotation of Nut for Lower Chevron (North and South side) from Panel Point (PP) 40 for Segment 6AW. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00251 Dated February 01, 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.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(*Continued Page 3 of 3*)

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.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
----------------------	----------------	-----------------------------

Reviewed By:	Miller,Mark	QA Reviewer
---------------------	-------------	-------------