

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-012205**Date Inspected:** 22-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 Trial 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

OBG Trial Assembly Yard (Segment 7BW to 7CW and 7BE to 7CE)

The QA inspector performed offset measurement for the following locations.

The T-Ribs to T-Ribs web offset at Bottom Panel, Side Panel (Cross Beam and Counter Weight Side) for Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53 and

The T-Ribs to T-Ribs web offset at Side Panel (Cross Beam side) for Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53.

Please refer the Incident Report 04-0120F4_TL-15_B278_02-22-09_7BW-7CW_T-Rib Offset for more comprehensive details for non-complying areas, for quick reference kindly refer the pictures attached below. Report forwarded to team leader for further action.

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OBG Trial Assembly Yard (Segment 5AE at PP 29)

Punch List item 332

The QA inspector performed inspection for the punch list item 332 for high strength bolt which received arc strike installed at Lower Chevron Bike Path side.

Asked the ZPMC QC to change the bolt with same grade and size and tension verified and found satisfactory.

Bolt Size M22 x 70 mm, R.C. # DHGM 220020, Tension Verified at 520 N-m. Report forwarded to team leader for further action.

OBG Trial Assembly Yard (6AE to 6BE at PP 40 and PP 41)

Punch List item 366

The QA inspector performed inspection for the punch list item 366 for(Dimension) Three T-Rib web weld between 6AE to 6BE (Transverse Splice) for misalignment.

Inspected the SP307-001-032 (3rd T-Rib on Side Panel from Top) Bike Path side and measured dimension as 1mm.

Inspected the SP334-001-023 (12th T-Rib on Side Panel from Top) Bike Path side and measured dimension as 2.5mm.

Inspected the SP526-002-070 (1st T-Rib on Side Panel from Top) Cross Beam side and measured dimension as 2mm.

Report forwarded to team leader for further action as all the dimension were within the acceptable range i.e., 3mm.

OBG Trial Assembly Yard (Lift 6 West)

Punch List item 339

The QA inspector performed inspection for the punch list item 339 for Longitudinal Diaphragm LD 16E to LD 10A at 6AW to 6BW between PP 40 and PP 41 for Heat Straightening.

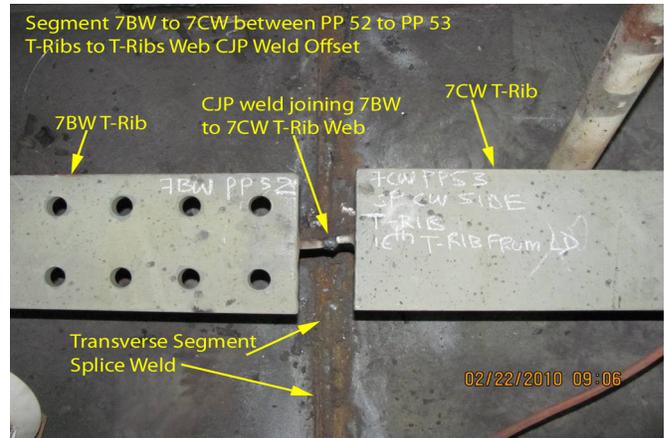
Dimension verification performed and found satisfactory.

Report forwarded to team leader for further action.

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

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Summary of Conversations:

As stated above.

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