

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-012436**Date Inspected:** 01-Mar-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

Segment 6CW (T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for T-Rib to T-Rib at Side Panel Cross Beam side between Panel Point (PP) 44 to PP 44.5, PP 45 to PP 45.5 and PP 45.5 to PP 46 for Segment 6CW. Inspected the T-Ribs along with 12mm Reinforcing Splice Plate above the Splice Plates. Tension verified on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00264 Dated March 01, 2010.

The following locations identified where 12mm Reinforcing plate installed on the Splice Plate.

At PP 44 to 44.5

4th location, 5th location, 7th location, 8th location, 10th location, 11th location, 12th location, 13th location, 14th location, 15th location, 16th location, 17th location, 18th location and 19th location.

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At PP 45 to PP 45.5

10th location, 12th location, 13th location, 17th location, 18th location and 19th location.

At PP 45.5 to PP 46

6th location, 10th location, 11th location, 11th location, 12th location, 13th location, 14th location, 17th location, 18th location and 19th location.

Bolt sizes used were M22 x 80 RC Set# DHGM220050 and final torque required was 486 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-584.

Note: At PP 45 to PP 45.5 14th location, 15th location and 16th location and at PP 45.5 to PP 46 15th location 12mm Thk. Splice plate not installed on the Splice plate, for more comprehensive details kindly refer the pictures attached.

Lift 5 East (Corner Assembly)

This Quality Assurance (QA) Inspector witnessed final tension verification for Corner Assembly at Panel Point (PP) 29, PP 32 and PP 35 for Segment 5AE, 5BE and 5CE (Cross Beam and Bike Path Side). Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00265 Dated March 01, 2010.

Bolt sizes used were M22 x 120 RC Set# DHGM220053 and final torque required was 440 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-584.

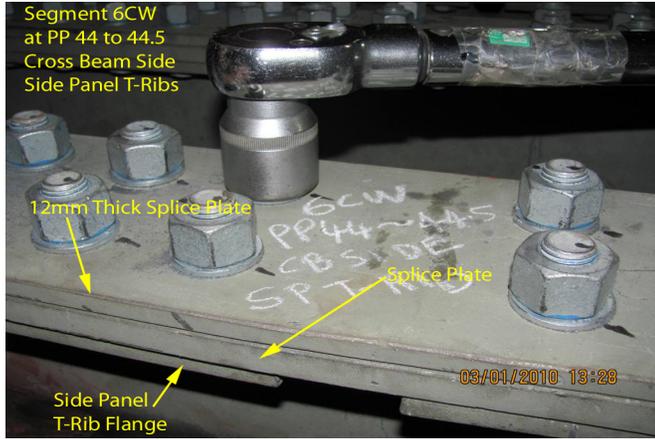
Segment 7AE to 7BE (U-Ribs)

This QA Inspector performed Dimension Control Inspection for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7AE to 7BE (Shop Segment Splice) between Panel Point (PP) 49 and PP 50 North and South side. 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:

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.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer