

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-012438**Date Inspected:** 02-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:	Li Yang and 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 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 5BW to 5CW (U-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Rib to U-Rib at Panel Point (PP) 34 and PP 35 for Segment 5BW to 5CW. Inspected all of the U-Ribs including Big Reinforcing Splice Plate (details of location mentioned below) tension verified on random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00266 Dated March 02, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220035 and final torque required was 433 N-m,

Bolt sizes used were M22 x 80 RC Set# DHGM220012 and final torque required was 427 N-m and

Bolt sizes used were M22 x 85 RC Set# DHGM220013 and final torque required was 433 N-m.

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

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Locations where Big Reinforcing Plate installed are as mentioned below.

8th Location, 14th Location, 15th Location, 17th Location, 33rd Location, 34th Location, 35th Location, 36th Location, 38th Location and 39th Location.

Note: U-Ribs numbering reference taken from Counter Weight Side as 1st U-Rib and Cross Beam Side as 39th U-Rib.

Segment 6BW

This QA Inspector performed Offset measurement for Deck Panel to Deck Panel Diaphragm from West facing between the all U-Ribs to U-Ribs (Total 39 nos.) for Segment 6BW at Panel Point (PP) 42. Report forwarded to team leader for further action.

Segment 6BW

This QA Inspector performed Offset measurement for Deck Panel to Deck Panel Diaphragm from East facing between the all U-Ribs to U-Ribs (Total 39 nos.) for Segment 6BW at Panel Point (PP) 43. Report forwarded to team leader for further action.

Segment 6CW

This QA Inspector performed Offset measurement for Deck Panel to Deck Panel Diaphragm from West facing between the all U-Ribs to U-Ribs from U-Rib 22 through to 39 and from East facing between the all U-Ribs to U-Ribs from U-Rib 1 through to 21 for Segment 6CW at Panel Point (PP) 44. Report forwarded to team leader for further action.

Segment 6CW

This QA Inspector performed Offset measurement for Deck Panel to Deck Panel Diaphragm from West facing between the all U-Ribs to U-Ribs from U-Rib 1 through 18 for Segment 6CW at Panel Point (PP) 45. Report forwarded to team leader for further action.

While doing Offset survey notice weld connecting the FL2 to Deck Panel Diaphragm was ground off and weld was missing between U-Rib 19 and 20, included the information in the Punch List for further action, for more comprehensive details please refer the picture attached below.

Segment 6BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037932 performing welding by Shielded Metal Arc Welding process (SMAW) for weld OBW6F-006. ZPMC Quality Control (QC) is identified as Mr. Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

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Segment 6AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing welding by Shielded Metal Arc Welding process (SMAW) for weld SSD16-PP038-170. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G-SMAW-4G(4F)-FCM-Repair-1. The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR10782.

Segment 6CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067183 performing welding by Shielded Metal Arc Welding process (SMAW) for weld SSD27-PP045-174. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G-SMAW-4G(4F)-FCM-Repair-1. The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR10783.

Segment 6BE to 6CE

Punch List item 340

The QA inspector performed inspection for the punch list item 340 for Transverse Splice for segment 6BE to 6CE between PP 43 and 44. The Corner Assembly Horizontal weld was 7mm out of flatness when measured referring to Transverse Splice weld, dimension verification performed, found the dimension meeting the requirements.

Report forwarded to team leader for further action.

Segment 6BW to 6CW

Punch List item 394

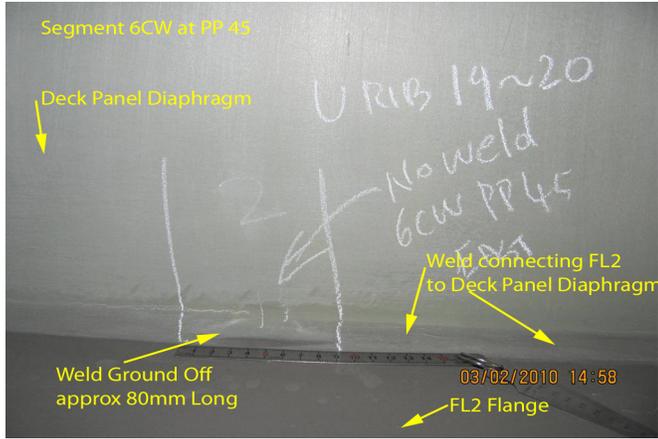
The QA inspector performed inspection for the punch list item 340 for Transverse Splice for segment 6BW to 6CW between PP 43 and 44. The T-Ribs and I-Rib web offset was out of acceptable limit at following locations 1st I-Rib on SP from top CB side, 6th T-Rib on BP from work point W3 and 7th T-Rib on SP from Bottom CW side, dimension verification performed, found the dimension meeting the requirements.

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