

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-012706**Date Inspected:** 12-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 6AE to 6BE (U-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Rib to U-Rib at Panel Point (PP) 40 and PP 41 for Segment 6AE to 6BE. Inspected the all the splice plates including Big Reinforcing Splice Plate installed at U-Rib locations at 27th on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00277 Dated March 12, 2010.

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

Bolt sizes used were M22 x 65 RC Set# DHGM220018 and final torque required was 447 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Note: U-Ribs numbering reference taken from Cross Beam as 1st U-Rib and Bike Path side as 39th U-Rib.

Signed Off Green Tag's

This Quality Assurance (QA) Inspector witnessed final tension verification for following depicted locations. Inspected 10% on a random basis and found the tension to be in general compliance and thus signed off the Green Tags.

At Segment 5AE, 5BE and 5CE for Cable Tray Support (Angle frame location except PP 32 to 33 due to sea fastener) Green Tag No. 643.

At Segment 5AW to 5BW for Segment Splice to T-Stiffeners (South) Green Tag No. 644.

At Segment 5AW to 5BW for Segment Splice to T-Stiffeners (North) Green Tag No. 645.

At Segment 5AW to 5BW for Segment Splice to T-Stiffeners (Bottom Panel) Green Tag No. 646.

At Segment 5AW to 5BW for Longitudinal Diaphragm to Longitudinal Diaphragm Splice (North and South) Green Tag No. 647.

At Segment 5AW to 5BW for Longitudinal Diaphragm to Longitudinal Diaphragm Splice (North and South) Green Tag No. 648.

Segment 7BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058087 performing Shielded Metal Arc Welding process for weld CA036-004 located on PCMK the weld between deck panel and edge panel (bike path side). ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-2G (2F)-FCM-Repair-1. Critical weld repair report identified as B-CWR1224.

Segment 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066361 performing Shielded Metal Arc Welding process for weld SEG035A-021 located on PCMK the weld between side panel and bottom panel (cross beam side). ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

Segment 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing Shielded Metal Arc Welding process for weld SEG035A-031 located on PCMK the weld between side panel and bottom panel (counter weight side). ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

Segment 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067589 performing Shielded Metal Arc Welding process for weld DP640-001-12 located on PCMK the weld between deck panel "I" rib and deck panel. ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

Segment 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing Shielded Metal Arc Welding process for weld DP648-001-12 located on PCMK the weld between deck panel "I" rib and deck panel. ZPMC QC Mr. Zang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

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.

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

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