

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-012708**Date Inspected:** 08-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**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 6AW (Lower Chevron X3D)

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron X3D Angle (North and South side) at Panel Point (PP) 37, PP 38, PP 39 and 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. 00273 Dated March 08, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220033 and final torque required was Rotation of Nut.

Segment 6BW (Lower Chevron X3D)

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron X3D Angle (North and South side) at Panel Point (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. 00273

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Dated March 08, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220033 and final torque required was Rotation of Nut.

Note: At PP 41 rotation of the nut not offered by ZPMC QC. Note: During verifying the rotation of the nut noticed visually Floor Beam Base material had received scar mark at PP 43 West Side due to cutting of jammed temporary bolt before installing the ASTM A 325 bolt. Please refer the attached pictures below for more comprehensive detail. Details forward to the team leader for further action and added in the punch list.

Segment 6CW (Lower Chevron X3D)

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron X3D Angle (North and South side) at Panel Point (PP) 44 and PP 45 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. 00273
Dated March 08, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220033 and final torque required was Rotation of Nut.

Note: During verifying the rotation of the nut noticed visually Floor Beam Base material had received scar mark at PP 45 West Side due to cutting of jammed temporary bolt before installing the ASTM A 325 bolt. Please refer the attached pictures below for more comprehensive detail. Details forward to the team leader for further action and added in the punch list.

Segment 7BW to 7CW (U-Ribs)

This QA Inspector performed Survey Inspection for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7BW to 7CW (Shop Segment Splice) between Panel Point (PP) 52 and PP 53 from North towards South side i.e., from Counter Weight side to Cross Beam Side. Report forwarded to team leader for further action.

Segment 6CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is identified as SSD27-PP045-171. The welder is identified as 048659 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-345-SMAW-1G (1F)-repair-1.

Segment 6CE

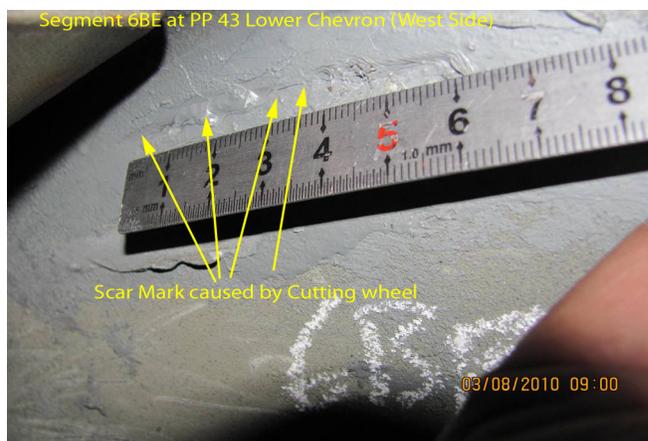
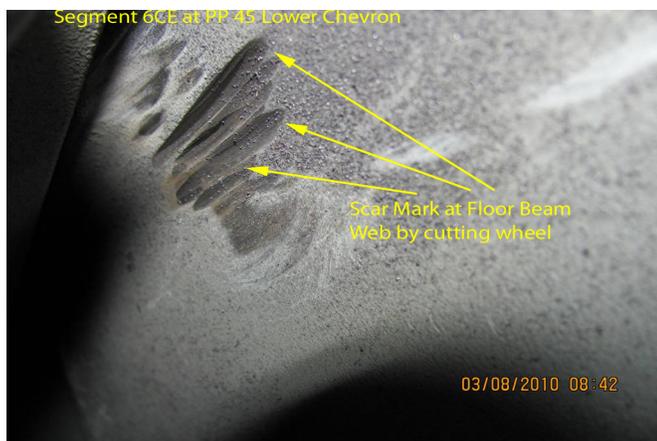
This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD27-PP045-174. The welder is identified as 048659 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-repair-1.

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

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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