

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-013137**Date Inspected:** 26-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**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 6BE (Suspender Bracket)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Suspender Bracket at Panel Point (PP) 42 for Segment 6BE Bike Path Side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 2010.

Bolt sizes used were M24 x 95 RC Set# DHGM240021 and final torque required was 540 N-m

Bolt sizes used were M24 x 75 RC Set# DHGM240020 and final torque required was 600 N-m and

Bolt sizes used were M27 x 85 RC Set# DHGM270001 and final torque required was 853 N-m

Manual Torque wrench was been used with Sr. No. XQ2-654.

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Note: Please refer the attached pictures with Tag No. 1 for more comprehensive details.

Segment 6AE (Road Barrier Angle)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Road Barrier at Panel Point (PP) 37 for Segment 6AE Bike Path Side and Cross Beam side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 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. XQ2-654.

Segment 6CE (Road Barrier Angle)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Road Barrier at Panel Point (PP) 47 for Segment 6CE Bike Path Side and Cross Beam side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 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. XQ2-654.

Segment 6AE (Corner Assembly Vertical Stiffener Road Barrier)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Vertical Assembly Vertical Stiffener Corner Assembly for Road Barrier between Panel Point (PP) 39 and PP 40 for Segment 6AE Cross Beam side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 2010.

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

Bolt sizes used were M24 x 140 RC Set# DHGM240026 and final torque required was 520 N-m

Bolt sizes used were M24 x 150 RC Set# DHGM240060 and final torque required was 563 N-m and

Bolt sizes used were M24 x 160 RC Set# DHGM240074 and final torque required was 443 N-m

Manual Torque wrench was been used with Sr. No. XQ2-654.

Segment 6BE (Corner Assembly Vertical Stiffener Road Barrier)

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This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Vertical Assembly Vertical Stiffener Corner Assembly for Road Barrier between Panel Point (PP) 41, PP 42 and PP 43 for Segment 6BE Cross Beam side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 2010.

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

Bolt sizes used were M24 x 140 RC Set# DHGM240026 and final torque required was 520 N-m

Bolt sizes used were M24 x 150 RC Set# DHGM240060 and final torque required was 563 N-m and

Bolt sizes used were M24 x 160 RC Set# DHGM240074 and final torque required was 443 N-m

Manual Torque wrench was been used with Sr. No. XQ2-654.

Segment 6CE (Corner Assembly Vertical Stiffener Road Barrier)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at Vertical Assembly Vertical Stiffener Corner Assembly for Road Barrier between Panel Point (PP) 44 and PP 45 for Segment 6CE Cross Beam side. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00306 Dated March 26, 2010.

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

Bolt sizes used were M24 x 140 RC Set# DHGM240026 and final torque required was 520 N-m

Bolt sizes used were M24 x 150 RC Set# DHGM240060 and final torque required was 563 N-m and

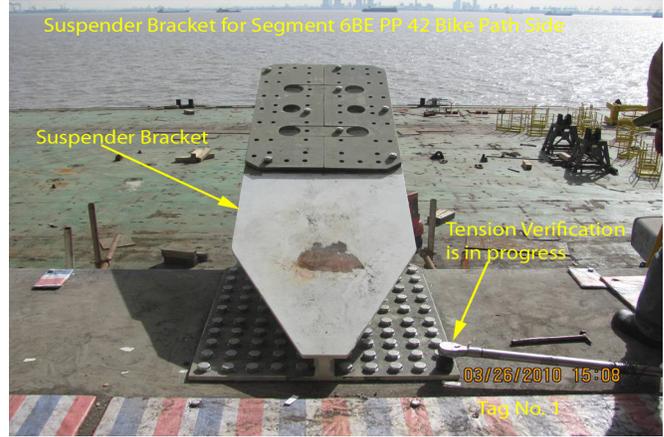
Bolt sizes used were M24 x 160 RC Set# DHGM240074 and final torque required was 443 N-m

Manual Torque wrench was been used with Sr. No. XQ2-654.

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