

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-013139**Date Inspected:** 23-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 6BE to 6CE (T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at T-Ribs to T-Ribs at Segment Transverse Splice Side Panel (Cross Beam Side) and Side Panel (Bike Path side) and Bottom Panel at Panel Point (PP) 43 and PP 44 for Segment 6BE to 6CE. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00299 Dated March 23, 2010.

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

Bolt sizes used were M22 x 70 RC Set# DHGM220004 and final torque required was 453 N-m

Offset between the T-Ribs to T-Ribs measured and the dimension recorded were within the acceptable limit.

Manual

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

Note: Bottom Panel T-Ribs bolts at Segment 6BE Panel Point (PP) 43 (2 Columns and 4 Rows) bolts not installed and not offered for tension verification due the temporary sea fasteners interfering at that location. Please refer the pictures attached with Tag No. 1 below for more comprehensive detail.

Segment 6AE to 6BE (T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts Installed at T-Ribs to T-Ribs at Segment Transverse Splice Side Panel (Cross Beam Side) at 13th T-Rib between Panel Point (PP) 40 and PP 41 for Segment 6AE to 6BE. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00299 Dated March 23, 2010.

Bolt sizes used were M22 x 70 RC Set# DHGM220004 and final torque required was 453 N-m.

Offset between the T-Ribs to T-Ribs measured and the dimension recorded were within the acceptable limit. Manual Torque wrench was been used with Sr. No. XQ2-654.

Please refer the pictures attached with Tag No. 2 below for more comprehensive detail.

Segment 6AE (Cable Tray Sling)

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Sling Installed at Segment 6AE at area between PP 37, PP 38, PP 39 and PP 40. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00299 Dated March 23, 2010.

Tension verification by manual pulling and pushing performed and found satisfactory.

Note: Cable Tray not installed between PP 38 to PP 39 due to interference with Temporary Sea Fasteners.

Segment 6BE (Cable Tray Sling)

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Sling Installed at Segment 6BE at area between PP 41, PP 42 and PP 43. Inspected 10% on a random basis and found the Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00299 Dated March 23, 2010.

Tension verification by manual pulling and pushing performed and found satisfactory.

Segment 6CE (Cable Tray Sling)

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Sling Installed at Segment 6CE at area between PP 44, PP 45, PP 46 and PP 47. Inspected 10% on a random basis and found the

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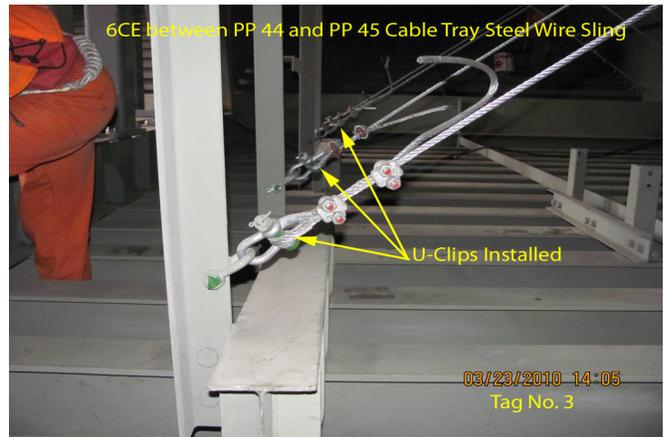
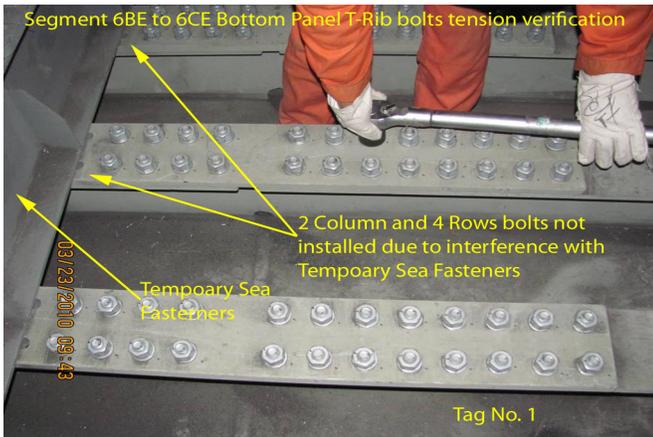
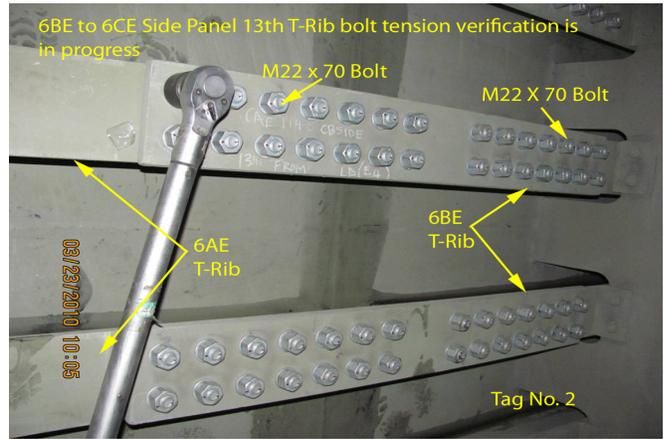
Rotation of Nut to be in general compliance. Inspection was performed against the Notification No. 00299 Dated March 23, 2010.

Tension verification by manual pulling and pushing performed and found satisfactory.

Please refer the pictures attached with Tag No. 2 below for more comprehensive detail.

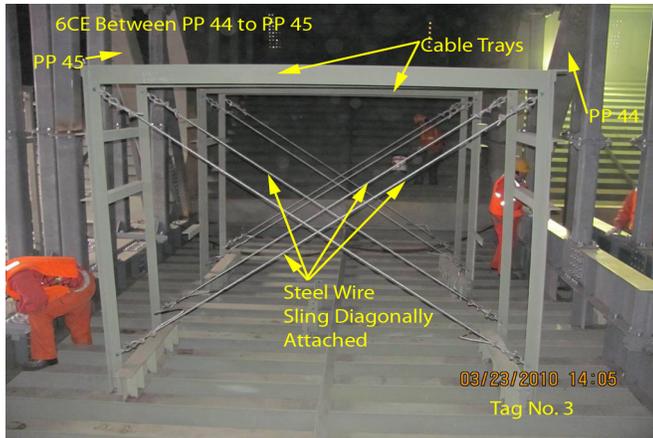
Note: Cable Tray not installed between PP 44 to PP 45 due to interference with Temporary Sea Fasteners.

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