

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-014377**Date Inspected:** 11-May-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

Incident Report for Segment 7BW

This Quality Assurance (QA) Inspector wrote an Incident Report for flatness of match drilling Template installed between Deck Panel Extension of Segment 7BW to the Cross Beam (CB) #7 between Panel Point (PP) 50, PP 51 and PP 52 for more comprehensive details please refer the Incident Report # 04-0120F4_TL-15_B278_05-11-2010_Gap between the faying surface of Match Drilling plate to CB7 and 7BW Deck Panel between PP50 to PP52 Dated May 10, 2010. Please refer the attached pictures below for more comprehensive details.

Segment 7BW to 7CW (Blasting Inspection)

During Quality Assurance (QA) random in-process visual inspection this QA inspector observed at Segment 7EW to 8AW between PP 60 to PP61 Corner Assembly Edge Panel I-Stiffener are misaligned by 25mm and 28mm

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respectively. Please refer the pictures attached below for more comprehensive detail.

Traveler Rail

This QA Inspector performed dimension Inspection along with Caltrans QA Mr. Surendra Prabhu for the Traveler Rail Bracket 11TR3-001-001~014 at Bay #7 and measured the following

Rail Length

Rail Longitudinal Elevation

Rail Sweep

Thickness at Typical Section

Thickness at Sliding Section

Flange width at typical section

Flange width at Sliding Connection

Flange Width at sliding connection

Web to Flange Offset

Depth Typical Section

Depth Sliding Section

Flange Tilt

Cut Angle at Sliding Connection

The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8AE to 8BE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 8AE to 8BE (Shop Segment Splice) between Panel Point (PP) 64 and PP 65 North(Cross Beam) and South (Bike Path) side for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured and recorded readings were submitted to the Lead and Engineer for review.

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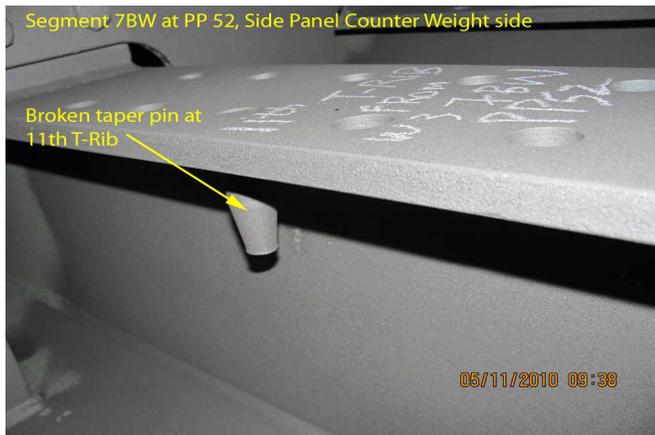
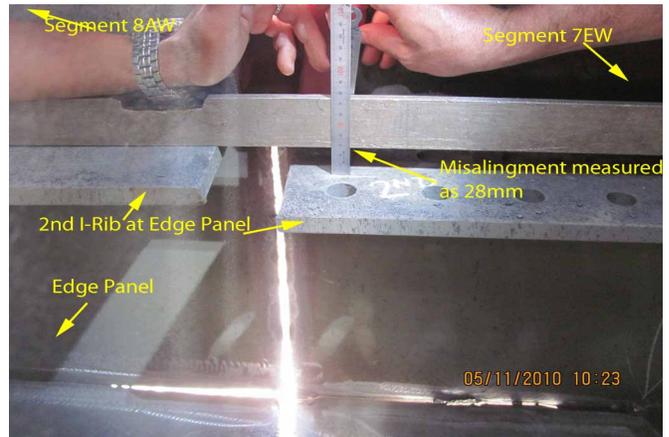
Segment 8BE to 8CE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 8BE to 8CE (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 North(Cross Beam) and South (Bike Path) side for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 7EW to 8AW Edge Panel

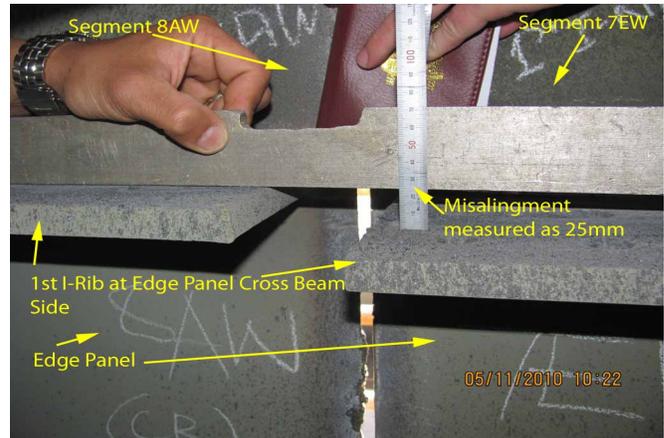
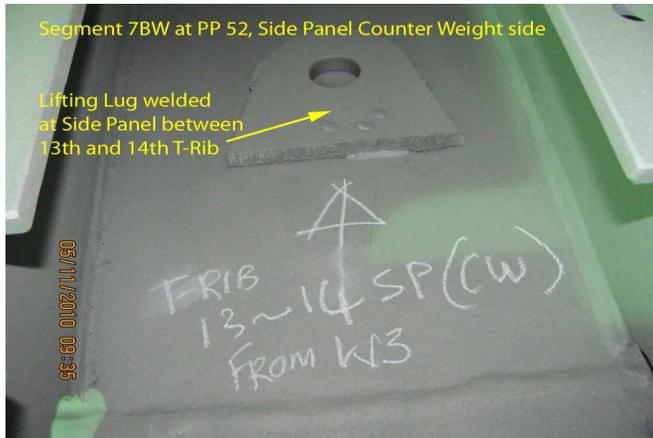
This QA Inspector observed during random visual inspection misaligned Edge Panel Stiffener between Segment 7EW to 8AW (PP 60 and PP61) the deformation for 1st I-Rib measured as 25mm and misalignment at 2nd I-Rib measured as 28mm. The measured and recorded readings were submitted to the Lead and Engineer for review. Please refer the pictures attached below for more comprehensive details.

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: Carreon,Albert

QA Reviewer