

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-014835**Date Inspected:** 04-Jun-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 8AW to 8BW (Skin Flatness) Joint Survey

This QA Inspector performed Joint Inspection along with Caltrans QA Mr. Manoj Prabhune and with ABF Survey Team for the Skin Flatness between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 64 and PP 65 North.

(Counter Weight side at B1 and B2 locations) and South (Cross Beam side at B3 and B4 Locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

(Counter Weight side at T1 location) and South (Cross Beam side T2 Location) at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

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The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8BW to 8CW (Skin Flatness) Joint Survey

This QA Inspector performed Joint Inspection along with Caltrans QA Mr. Manoj Prabhune and with ABF Survey Team for the Skin Flatness between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 North.

(Counter Weight side at B1 and B2 locations) and South (Cross Beam side at B3 and B4 Locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

(Counter Weight side at T1 location) and South (Cross Beam side T2 Location) at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8CW to 9AW

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Transverse Splice T-Ribs from Work Point W6 to Work Point W4 (Side Panel Cross Beam Side) and from Work Point W4 to Work Point W3 (Bottom Panel) and from Work Point W3 to Work Point W1 (Side Panel Counter Weight Side).

Segment 8CW to 9AW

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Root Gap and Offset for the Segment 8CW to 9AW between Panel Point (PP) 71 and PP 72 at the following locations.

Edge Panel (Cross Beam Side) Work Point W5 to W6

Side Panel (Cross Beam Side) Work Point W6 to W4

Bottom Panel Work Point W4 to W3

Side Panel (Cross Beam Side) Work Point W3 to W1

Edge Panel (Cross Beam Side) Work Point W1 to W2

Deck Panel from Work Point W2 to W5

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Segment 8CE to 9AE

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Root Gap and Offset for the Segment 8CE to 9AE between Panel Point (PP) 71 and PP 72 at the following locations.

Edge Panel (Cross Beam Side) Work Point E2 to E1

Side Panel (Cross Beam Side) Work Point E1 to E3

Bottom Panel Work Point E3 to E4

Side Panel (Cross Beam Side) Work Point E4 to E6

Edge Panel (Cross Beam Side) Work Point E6 to E5

Deck Panel from Work Point E5 to E2

Cope Hole Dimension Inspection

This QA Inspector performed dimension Inspection along with Caltrans QA Mr. Manoj Prabhune for the Cope Holes at Bottom Panel to Floor Beam and Side Panel to Floor Beam for the following locations.

Work Point W3 and W4 at Panel Point (PP) 89, PP 90 and PP 91 (East and West Side)

The reports submitted to the Lead and Engineer for review and further action.

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
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Reviewed By:	Carreon,Albert	QA Reviewer
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