

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-015074**Date Inspected:** 19-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:****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

Lift 7 (East)

This Quality Assurance (QA) Inspector measured and recorded the dimension and smoothness for the Cope Holes at Corner Assembly at following location after rectification.

Segment 7AE

Cope Hole T1 at Panel Point (PP) 48 Cross Beam Side.

Note: Cope Hole T1 at Panel Point (PP) 48 Cross Beam Side does not meet the acceptance criteria.

Segment 7CE

Cope Hole T2 at Panel Point (PP) 53 Cross Beam Side.

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Cope Hole T1 at Panel Point (PP) 54 Cross Beam Side.

Cope Hole T1 at Panel Point (PP) 55 Cross Beam Side and Bike Path side.

Note: Cope Hole T1 at Panel Point (PP) 55 Cross Beam Side does not meets the acceptance criteria.

Segment 7DE

Cope Hole T1 at Panel Point (PP) 56 Bike Path Side.

Cope Hole T2 at Panel Point (PP) 57.5 Bike Path Side.

Cope Hole T1 at Panel Point (PP) 58 Bike Path side.

Cope Hole T3 at Panel Point (PP) 58 Cross Beam Side.

Cope Hole T2 at Panel Point (PP) 58.5 Cross Beam Side.

Note: Cope Hole T2 at Panel Point (PP) 58.5 Cross Beam Side does not meets the acceptance criteria.

Segment 7EE

Cope Hole T3 at Panel Point (PP) 59 Bike Path Side.

Cope Hole T1 and T3 at Panel Point (PP) 60 Bike Path Side.

Lift 8 (East)

This Quality Assurance (QA) Inspector measured and recorded the dimension and smoothness for the Cope Holes at Corner Assembly at following location after rectification.

Segment 8AE

Cope Hole T1 at Panel Point (PP) 61 Bike Path Side.

Segment 8BE

Cope Hole T2 at Panel Point (PP) 65.5 Cross Beam Side.

Segment 8CE

Cope Hole T2 at Panel Point (PP) 70 Bike Path Side.

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Lift 8 (West)

This Quality Assurance (QA) Inspector measured and recorded the dimension and smoothness for the Cope Holes at Corner Assembly at following location after rectification.

Segment 8AW

Cope Hole T1 and T2 at Panel Point (PP) 61 Counter Weight Side.

Cope Hole T1, T2 and T3 at Panel Point (PP) 61 Cross Beam Side.

Cope Hole T1 and T2 at Panel Point (PP) 61.5 Cross Beam Side.

Cope Hole T1, T2 and T3 at Panel Point (PP) 62 Cross Beam Side.

Cope Hole T1 and T2 at Panel Point (PP) 62.5 Cross Beam Side.

Cope Hole T2 at Panel Point (PP) 63 Counter Weight Side.

Cope Hole T1, T2 and T3 at Panel Point (PP) 63 Cross Beam Side.

Cope Hole T1 and T2 at Panel Point (PP) 63.5 Cross Beam Side.

Segment 8BW

Cope Hole T3 at Panel Point (PP) 66 Counter Weight Side.

Cope Hole T1 and T2 at Panel Point (PP) 67 Cross Beam Side.

Segment 8CW

Cope Hole T1 at Panel Point (PP) 67.5 Counter Weight and Cross Beam Side.

Cope Hole T1, T2 and T3 at Panel Point (PP) 68 Cross Beam Side.

Cope Hole T2 at Panel Point (PP) 69 Cross Beam Side.

Cope Hole T1 Panel Point (PP) 70.5 Cross Beam Side.

Inspection was performed against the Notification No. 006005 Dated June 18, 2010, unless otherwise mentioned all the Cope Holes mentioned above meets the requirements.

Segment 7DE

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This QA Inspector performed Dimension Inspection for the FL3 extension at Cross Beam side for the distortion occurred due to handling reasons the Inspection was performed against Incident Report # 1397 Dated June 16, 2010. Observed that dimension is not meeting the requirement.

The measured reading observed as 1mm when measured with 1000mm Straight Edge conveyed to the lead for 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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