

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-015416**Date Inspected:** 30-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 7AW (Traveler Brackets)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Traveler Rail Brackets to Side Panel and Side Panel to the Floor Beam at Panel Point (PP) 48 and PP 49 for Segment 7AW installed at the Counter Weight Side. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00402 Dated June 30, 2010.

Bolt sizes used were M20 x 95 RC Set# DHGM200018 and final torque required was 347 N-m,

Bolt sizes used were M20 x 160 RC Set# DHGM200006 and final torque required was 340 N-m,

Bolt sizes used were M22 x 90 RC Set# DHGM220048 and final torque required was 500 N-m and

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

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Manual Torque wrench was been used with Sr. No. X02-779. Please refer the pictures attached for more comprehensive details.

Segment 7BW (Traveler Brackets)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Traveler Rail Brackets to Side Panel and Side Panel to the Floor Beam at Panel Point (PP) 50, PP 51 and PP 52 for Segment 7BW installed at the Counter Weight Side. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00402 Dated June 30, 2010.

Bolt sizes used were M20 x 95 RC Set# DHGM200018 and final torque required was 347 N-m,

Bolt sizes used were M20 x 160 RC Set# DHGM200006 and final torque required was 340 N-m,

Bolt sizes used were M22 x 90 RC Set# DHGM220048 and final torque required was 500 N-m and

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Manual Torque wrench was been used with Sr. No. X02-779.

Segment 7CW (Traveler Brackets)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Traveler Rail Brackets to Side Panel and Side Panel to the Floor Beam at Panel Point (PP) 53, PP 54 and PP 55 for Segment 7CW installed at the Counter Weight Side. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00402 Dated June 30, 2010.

Bolt sizes used were M20 x 95 RC Set# DHGM200018 and final torque required was 347 N-m,

Bolt sizes used were M20 x 160 RC Set# DHGM200006 and final torque required was 340 N-m,

Bolt sizes used were M22 x 90 RC Set# DHGM220048 and final torque required was 500 N-m and

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Manual Torque wrench was been used with Sr. No. X02-779.

Segment 7DW (Traveler Brackets)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Traveler Rail Brackets to Side Panel and Side Panel to the Floor Beam at Panel Point (PP) 56, PP 57 and PP 58 for Segment 7DW installed at the Counter Weight Side. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00402 Dated June 30, 2010.

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Bolt sizes used were M20 x 95 RC Set# DHGM200018 and final torque required was 347 N-m,

Bolt sizes used were M20 x 160 RC Set# DHGM200006 and final torque required was 340 N-m,

Bolt sizes used were M22 x 90 RC Set# DHGM220048 and final torque required was 500 N-m and

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Manual Torque wrench was been used with Sr. No. X02-779.

Segment 7EW (Traveler Brackets)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bolts connecting Traveler Rail Brackets to Side Panel and Side Panel to the Floor Beam at Panel Point (PP) 59 and PP 60 for Segment 7BW installed at the Counter Weight Side. Inspected bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00402 Dated June 30, 2010.

Bolt sizes used were M20 x 95 RC Set# DHGM200018 and final torque required was 347 N-m,

Bolt sizes used were M20 x 160 RC Set# DHGM200006 and final torque required was 340 N-m,

Bolt sizes used were M22 x 90 RC Set# DHGM220048 and final torque required was 500 N-m and

Bolt sizes used were M22 x 120 RC Set# DHGM220051 and final torque required was 433 N-m.

Manual Torque wrench was been used with Sr. No. X02-779.

Segment 8BE to 8CE(Transverse Splice T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for T-Rib to T-Rib at Side Panel Bike Path Side between Panel Point (PP) 67 and PP 68 for Segment 8BE to 8CE. Inspected the T-Ribs along with 12mm Reinforcing Splice Plate above the Splice Plates on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00403 Dated June 30, 2010.

Between PP 67 and 68

1st, 2nd and 3rd location (T-Rib numbering starts from E1 towards E3).

Bolt sizes used were M22 x 80 RC Set# DHGM220091 and final torque required was 460 N-m and

Bolt sizes used were M22 x 85 RC Set# DHGM220104 and final torque required was 380 N-m.

Manual Torque wrench was been used with Sr. No. X0-666.

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Lift 7 West (T-Rib Clips)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel T-Rib Clips welded to the Floor beam at East and West side between at following locations. Inspected the T-Ribs connecting bolts tension on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00404 Dated June 30, 2010.

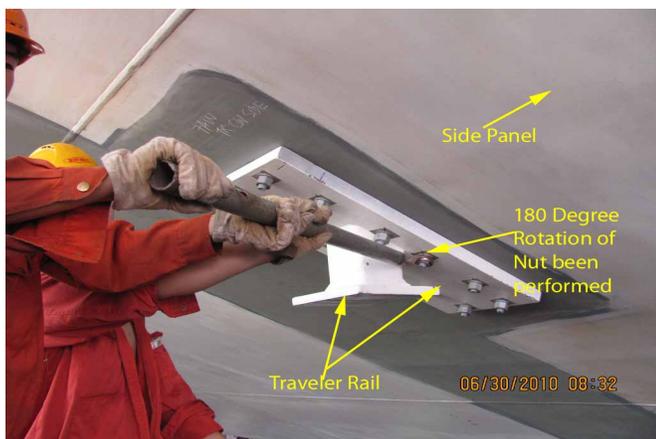
Segment 7BW at PP 50 and PP 51 at 1st T-Rib from W3 and W4 locations.

Segment 7DW at PP 57 and 58 at 1st T-Rib from W3 and W4 locations.

Bolt sizes used were M22 x 80 RC Set# DHGM220091 and final torque required was 460 N-m

Manual Torque wrench was been used with Sr. No. X0-666.

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

Reviewed By: Carreon,Albert

QA Reviewer