

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-015419**Date Inspected:** 04-Jul-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 9BE to 9CE (U-Rib to U-Rib) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 9BE to 9CE (Shop Segment Splice) between Panel Point (PP) 76 and PP 77 from North (Cross Beam Side) and South side (Bike Path Side). The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Task Leader and Engineer for review.

Segment 7AE (Bottom Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel T-Ribs (Total 18 Nos.) Bottom Panel at Panel Point (PP) 49 for Segment 7AE next to Temporary Sea Fasteners Total 52 Bolts. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00408 Dated July 04, 2010.

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Bolt sizes used were M22 x 70 RC Set# DHGM220009 and final torque required was 447 N-m.

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

Please refer the pictures attached below for more comprehensive detail.

Segment 7BE (Bottom Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel T-Ribs (Total 18 Nos.) Bottom Panel at Panel Point (PP) 52 for Segment 7BE next to Temporary Sea Fasteners Total 52 Bolts. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00408 Dated July 04, 2010.

Bolt sizes used were M22 x 70 RC Set# DHGM220009 and final torque required was 447 N-m.

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

Segment 7CE (Bottom Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel T-Ribs (Total 18 Nos.) Bottom Panel at Panel Point (PP) 55 for Segment 7CE next to Temporary Sea Fasteners Total 52 Bolts. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00408 Dated July 04, 2010.

Bolt sizes used were M22 x 70 RC Set# DHGM220009 and final torque required was 447 N-m.

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

Segment 7DE (Bottom Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel T-Ribs (Total 18 Nos.) Bottom Panel at Panel Point (PP) 55 for Segment 7DE next to Temporary Sea Fasteners Total 52 Bolts. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00408 Dated July 04, 2010.

Bolt sizes used were M22 x 70 RC Set# DHGM220009 and final torque required was 447 N-m.

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

Suspender Bracket (At Bay # 19)

This QA Inspector performed Dimension Control Inspection for the Suspender Bracket Lifting Rod Hole Spacing by placing the Socket (Template). Inspection performed jointly along with ABF Survey Team for the following mentioned Suspender Bracket at Bay # 19.

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East Bound

SB50E

SB52E

SB54E

SB56E

SB58E

SB62E

SB64E

SB68E

SB70E and

West Bound

SB52W

SB56W

SB60W

The measured readings were recorded in the Dimension Control Form (DCP) and submitted to the Caltrans Engineer for review. Please refer the pictures attached below for more comprehensive detail.

Segment 9AW to 9BW

This QA Inspector observed welding by Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP). The Weld joint is designated as Seg9B-001. The welder number is identified as 067588 and was observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-Repair-FCM-1. PMCK identified as Transverse Splice Weld at Edge Panel. The repair weld is been performed against the Welding Repair Report # BWR13908.

Segment 9AW to 9BW

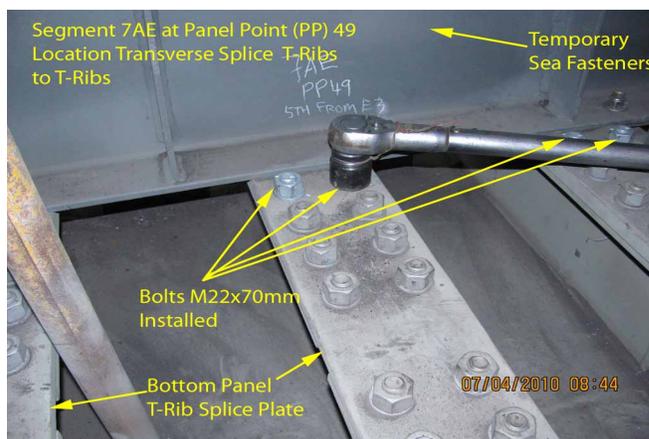
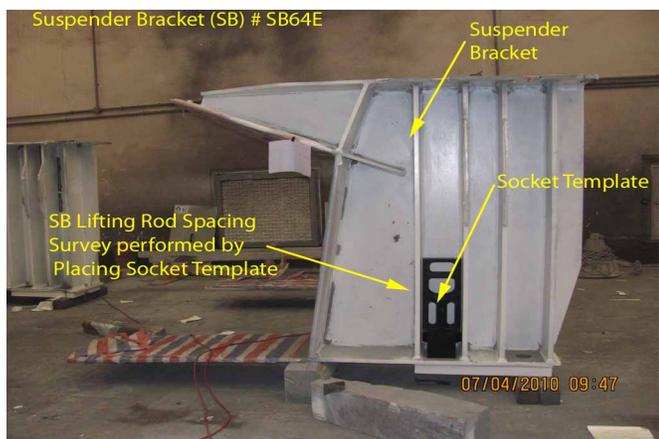
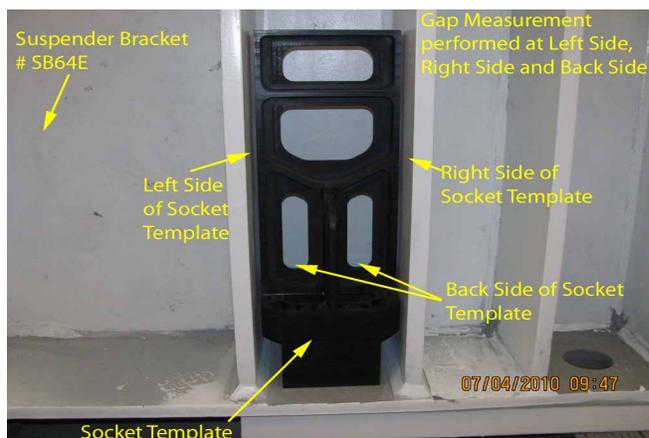
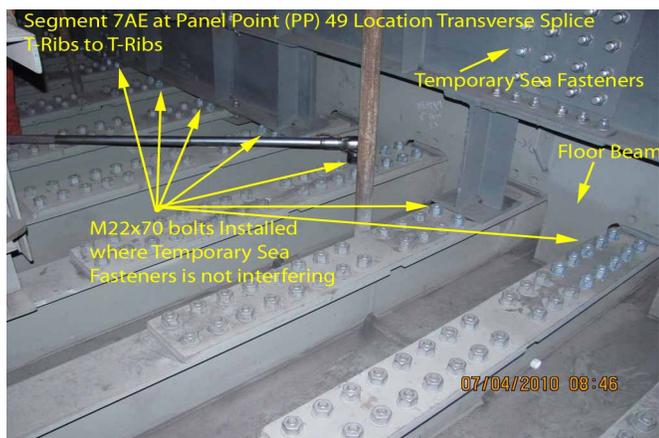
This QA Inspector observed welding by Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP). The Weld joint is designated as Seg9B-003. The welder number is identified as 067588 and was

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observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-Repair-FCM-1. PMCK identified as Transverse Splice Weld at Bottom Panel. The repair weld is been performed against the Welding Repair Report # BWR13906.

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