

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017216**Date Inspected:** 03-Oct-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)**Location:** Shanghai, China

CWI Name:	N/A	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		Component:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. 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) at Trial Assembly Areas

Incident Report generated at Segment 10CW (Longitudinal Diaphragm)

This Quality Assurance (QA) Inspector wrote an Incident Report for thermal cutting the weld connecting the longitudinal diaphragm web to flange at work point W3 and work point W4 without engineer approval and for manual thermal cutting more than allowable length for Segment 10CW. Please reference the Incident Report # 04-0120F4_TL-15_B278_10-03-2010_10CW_PP94~95_LD_Web_Flange_Thermal Cut_without Engineer Approval_W3_W4 location dated October 03, 2010 for further detail.

Please reference the pictures attached for more comprehensive details.

Segment 10CW (Side Panel T-Ribs at FL3)

This QA Inspector performed Dimension Control Inspection on the side panel T-Rib at FL3 areas after bolting for the Segment 10CW at Panel Points (PP) 92, PP 93 and PP 94 at the following locations:

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Work Point W4 towards Work Point W6 (Side Panel Cross Beam Side) total 19 T-Ribs at each Panel Points.

The QA Inspector measured the Vertical Offset using 1(One) Meter Straight Edge.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 10AE (Lower Chevron)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Lower Chevron X3D Bracket connected to floor beam flange and to the splice plate at Panel Point (PP) 86, PP 87 and PP 88 for Segment 10AE at Cross Beam and Bike Path side. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00504 Dated October 03, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 690 N-m.

Bolt sizes used were M22 x 75 RC Set# DHGM220034 and final torque required was 453 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

Segment 10BE (Lower Chevron)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Lower Chevron X3D Bracket connected to floor beam flange and to the splice plate at Panel Point (PP) 89, PP 90 and PP 91 for Segment 10BE at Cross Beam and Bike Path side. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00504 Dated October 03, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 690 N-m.

Bolt sizes used were M22 x 75 RC Set# DHGM220034 and final torque required was 453 N-m.

The Manual Torque wrench used was Serial No. XO2-114.

Segment 10CE (Lower Chevron)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Lower Chevron X3D Bracket connected to floor beam flange and to the splice plate at Panel Point (PP) 92, PP 93 and PP 94 for Segment 10CE at Cross Beam and Bike Path side. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00504 Dated October 03, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 690 N-m.

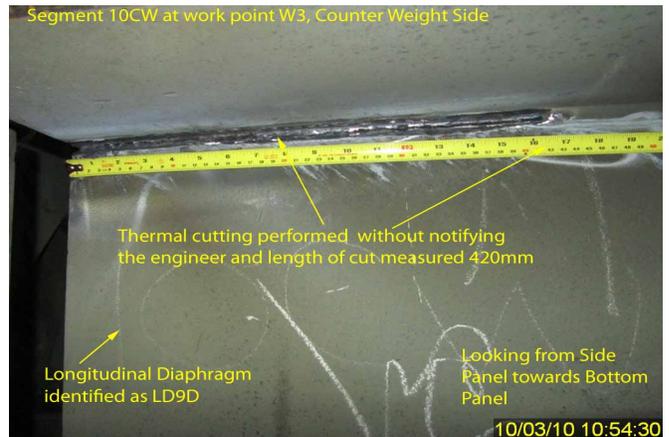
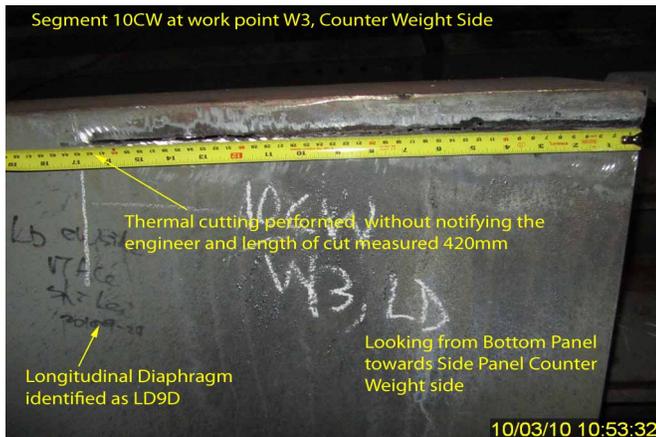
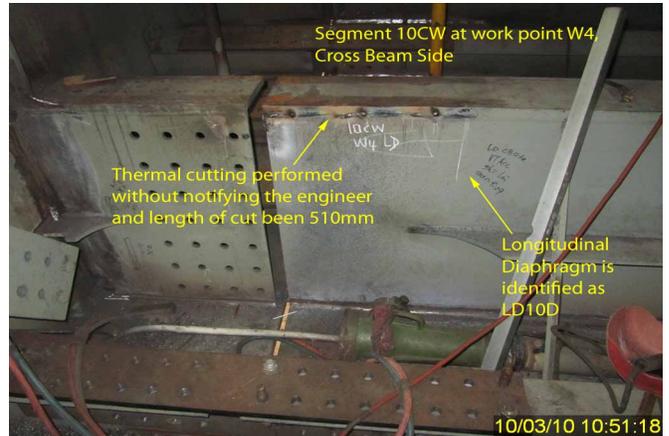
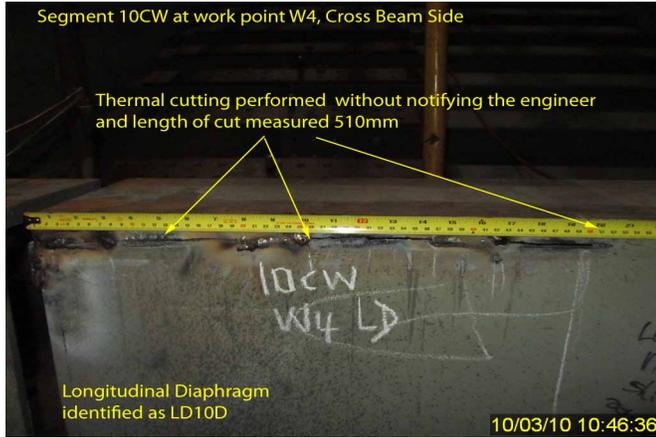
Bolt sizes used were M22 x 75 RC Set# DHGM220034 and final torque required was 453 N-m.

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The Manual Torque wrench used was Serial No. XO2-114.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

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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 Tsang 150000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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