

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-017226**Date Inspected:** 04-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	
		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 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

Segment 10AW (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel T-Ribs between Panel Points (PP) 85.25 to PP 86, PP 86 to PP 87 and PP 87 to PP 88 for Segment 10AW at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00505 Dated October 04, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160010 and final torque required was 200 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160011 and final torque required was 200 N-m.

The Manual Torque wrench used was Serial No. XO2-114. Please reference the pictures attached for more comprehensive details.

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Segment 10BW (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel T-Ribs between Panel Points (PP) 88 to PP 89, PP 89 to PP 90 and PP 90 to PP 91 for Segment 10BW at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00505 Dated October 04, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160010 and final torque required was 200 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160011 and final torque required was 200 N-m.

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

Segment 10CW (Catwalk)

This Quality Assurance (QA) Inspector witnessed final bolt tension verification for Catwalk structure which is connected to Bottom Panel T-Ribs between Panel Points (PP) 91 to PP 92, PP 92 to PP 93 and PP 93 to PP 94 for Segment 10CW at Bottom Panel. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00505 Dated October 04, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160010 and final torque required was 200 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160011 and final torque required was 200 N-m.

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

Segment 11AW to Segment 11BW (U-Rib to U-Rib)

This QA Inspector performed Dimension Control Inspection for measuring offset along with ABF QA Inspector on the U-Rib to U-Rib from Cross Beam side towards Bike Path side at a total of 39 locations on Segment 11AW to Segment 11BW between Panel Points (PP) 97 to PP 98 at the following locations:

The offset was measured within 50mm from the Deck Panel on U-Rib on the South and North side. The QA Inspector measured the 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.

Cross Beam (CB) # 14

This QA Inspector performed Dimension Control Inspection along with ABF QA Inspector for measuring offset between the stiffeners at floor beam (FL3) extension at Segment 10CE and Segment 10CW to Cross Beam # 14 stiffeners at bottom panel, vertical web plate and deck plate at following locations:

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At Panel Point (PP) 92, Segment 10CW offset measurement performed between floor beam stiffeners to west side Vertical Web Plate stiffeners of cross beam # 14 total 13 stiffeners.

At Panel Point (PP) 93, Segment 10CW offset measurement performed between floor beam stiffeners to centre Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

At Panel Point (PP) 94, Segment 10CW offset measurement performed between floor beam stiffeners to east side Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

Between Panel Points (PP) 92 to PP 93, Segment 10CW offset measurement performed between deck panel stiffeners to deck panel stiffeners of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 93 to PP 94, Segment 10CW offset measurement performed between deck panel stiffeners to deck panel stiffener of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 92 to PP 93, Segment 10CW offset measurement performed between bottom panel stiffeners to bottom panel stiffeners of cross beam # 14, total 5 stiffeners.

Between Panel Points (PP) 93 to PP 94, Segment 10CW offset measurement performed between bottom panel stiffeners to bottom panel stiffener of cross beam # 14, total 5 stiffeners.

At Panel Point (PP) 92, Segment 10CE offset measurement performed between floor beam stiffeners to west side Vertical Web Plate stiffeners of cross beam # 14 total 13 stiffeners.

At Panel Point (PP) 93, Segment 10CE offset measurement performed between floor beam stiffeners to centre Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

At Panel Point (PP) 94, Segment 10CE offset measurement performed between floor beam stiffeners to east side Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

Between Panel Points (PP) 92 to PP 93, Segment 10CE offset measurement performed between deck panel stiffeners to deck panel stiffeners of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 93 to PP 94, Segment 10CE offset measurement performed between deck panel stiffeners to deck panel stiffener of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 92 to PP 93, Segment 10CE offset measurement performed between bottom panel stiffeners to bottom panel stiffeners of cross beam # 14, total 5 stiffeners.

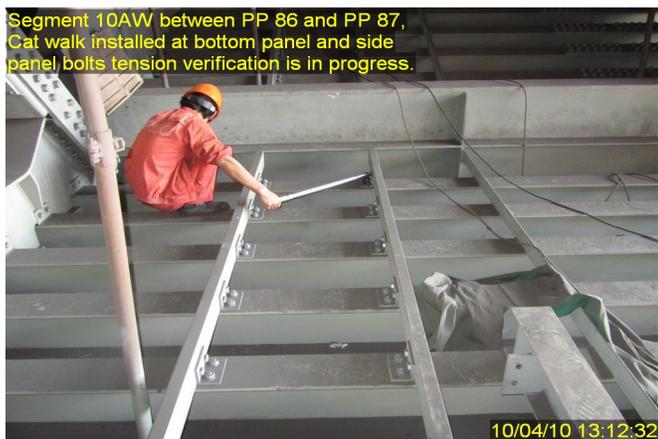
Between Panel Points (PP) 93 to PP 94, Segment 10CE offset measurement performed between bottom panel stiffeners to bottom panel stiffener of cross beam # 14, total 5 stiffeners.

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.

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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.

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

Reviewed By: Peterson,Art

QA Reviewer