DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 99.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-020561
Date Inspected: 21-Apr-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC)

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: N/A

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ 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

Incident Report for Segment 9DE (Deck Panel Extension)

This Quality Assurance (QA) Inspector wrote an Incident Report for Deformation at Deck Panel Extension for Segment 9DE between PP 80 to PP 81 and PP 81 to PP 82 at E5 location for more comprehensive details please refer the Incident Report # 04-0120F4_TL-15_B278_04-21-10_9DE_Distorted Deck Panel Extension at FL3_PP 80 to PP 82 Dated April 21, 2010.

Segment 8AW (T-Ribs Connecting Clips)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting Side Panel (Counter Weight and Cross Beam Side) and Bottom Panel T-ribs to the Floor Beam at Panel Point (PP) 61, PP 62, PP 63 and PP 64 for Segment 8AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00324 Dated April 21, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

Bolt sizes used were M16 x 50 RC Set# DHGM160003 and final torque required was 200 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-118.

Note: 8AW at PP 64 T-Ribs at 2nd, 3rd and 4th from W4 Work Point clips bolts not installed at Floor Beam as Floor had got deformed/buckled due to handling.

Segment 8BW (T-Ribs Connecting Clips)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting Side Panel (Counter Weight and Cross Beam Side) and Bottom Panel T-ribs to the Floor Beam at Panel Point (PP) 65, PP 66 and PP 67 for Segment 8BW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00324 Dated April 21, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

Bolt sizes used were M16 x 50 RC Set# DHGM160003 and final torque required was 200 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-118.

Segment 8CW (T-Ribs Connecting Clips)

This Quality Assurance (QA) Inspector witnessed final tension verification for Clips connecting Side Panel (Counter Weight and Cross Beam Side) and Bottom Panel T-ribs to the Floor Beam at Panel Point (PP) 68, PP 69, PP 70 and PP 71 for Segment 8CW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00324 Dated April 21, 2010.

Bolt sizes used were M16 x 45 RC Set# DHGM160001 and final torque required was 210 N-m

Bolt sizes used were M16 x 50 RC Set# DHGM160003 and final torque required was 200 N-m and

Bolt sizes used were M16 x 65 RC Set# DHGM160006 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-118.

Segment 7DE to 7EE (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.)

for Segment 7DE to 7EE (Shop Segment Splice) between Panel Point (PP) 58 and PP 59 North and South side. The measured readings were submitted to Lead and Engineer for review.

Segment 7EE to 8AE (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7EE to 8AE (Shop Segment Splice) between Panel Point (PP) 60 and PP 61 North and South side. The measured readings were submitted to Lead and Engineer for review.

Segment 8BW

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 8AW from Panel Point (PP) 66 and PP 67 for the following items.

Deck Panel Diaphragm to Deck Panel Plumbness and Flatness measured from the East side and the recorded measurements submitted to lead as well to the engineer for further action.

Segment 8CW

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 8AW from Panel Point (PP) 68, PP 69, PP 70 and PP 71 for the following items.

Deck Panel Diaphragm to Deck Panel Plumbness and Flatness measured from the East side and the recorded measurements submitted to lead as well to the engineer 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 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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer