

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023324**Date Inspected:** 26-Jun-2009**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:	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, 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

Lift 2 East (2AE to 2BE)

This Quality Assurance (QA) Inspector witnessed final tension verification against document no. 00044 Dated 06.25.2009. for Lower Chevron for Segment 2AE to 2BE between PP 13 to 18. Inspected 10% of bolt final tensioning only for PP 13 found satisfactory for North and South side. Bolt sizes used are M22 x 70 RC Lot No. DHGM220004 final Torque required was 453 N-m Manual calibrated torque wrench is been used bearing Sr. No. X02-584 been used and the and Bolt sizes used are M22 x 80 RC Lot No. DHGM220006 final Torque required was 440 N-m tightening been carried out by the Hydraulic wrench.

2AE to CB1

This QA Inspector observed ZPMC welding personnel performing Shielding Metal Arc Welding (SMAW) of 2AE to CB1. The weld joint no. Seg 008-77 and 78; 86 and 87. The welders are identified as 06765. Welder was welding fillet weld. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved

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welding procedure i.e., WPS-B-P-2114-FCM-1.

2AE to CB1

This QA Inspector observed ZPMC welding personnel performing Shielding Metal Arc Welding (SMAW) of 2AE to CB1. The weld joint no. Seg 008-122 and 123; 145 and 146. The welders are identified as 037840. Welder was welding fillet weld. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2114-FCM-1.

CB2 connecting to (3AE to 3AW)

This Quality Assurance (QA) Inspector carried out dimension inspection along with Mr. Joe for Cross Beam CB 2 to FL3 of 3AE and 3AW and the report submitted to Mr. Eric Tsang. The dimension were been carried out for 4th, 8th and 12th stiffener at PP 20, 21 and 22.

CB2 connecting to (4BE to 4BW)

This Quality Assurance (QA) Inspector along with Mr. Joe approached to carry out the Cross Beam CB 3 to FL3 of 4BE and 4BW and noticed splice plates are at position. Thus interfering with the location of interest therefore dimension for offset not been carried out.

Lift 2 East (2AE to 2BE)

This Quality Assurance (QA) Inspector randomly witnessed in-progress rotation of nut for Upper and Lower Chevron from PP 13 and PP 18 for North and South Side.

Lift 2 West (2AW to 2BW)

This Quality Assurance (QA) Inspector randomly witnessed in-progress rotation of nut for Upper Chevron from PP 13 and PP 18 for North and South Side.

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

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Reviewed By: Miller, Mark

QA Reviewer