

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

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

Report No: WIR-023331
Date Inspected: 29-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 Bolting Inspection Notification Sheet No. 00052 Dated 06.29.2009. for Bottom Panel T-Rib the last 1(one) clip on North and South side at Panel Point 14, Panel Point 17 and Panel Point 18 for Segment 2AE to 2BE. Inspected 10% found satisfactory. Bolt sizes used are M22 x 80 RC Lot No. DHGM220050 and final Torque required was 486 N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-578.

Lift 2 West (2AW to 2BW)

This Quality Assurance (QA) Inspector witnessed final tension verification against Bolting Inspection Notification Sheet No. 00051 Dated 06.29.2009., for Corner Assembly for segment 2AW to 2BW (Except for PP15.5 Bike Path Side) North and South side at Panel Point 13 to 18. Inspected 10% found satisfactory. Bolt sizes used are as mentioned below.

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1.M22 x 55 RC Lot No. DHGM220044 Torque Value used was 457 N-m.

2.M24 x 80 RC Lot No. DHGM240011 Torque Value used was 533 N-m.

3.M22 x 85 RC Lot No. DHGM220047 Torque Value used was 427 N-m.

4.M24 x 60 RC Lot No. DHGM240014 Torque Value used was 567 N-m.

5.M24 x 65 RC Lot No. DHGM220009 Torque Value used was 567 N-m.

6.M22 x 120 RC Lot No. DHGM220051 Torque Value used was 433 N-m.

Final Torque required was 486 N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-578.

Note: 1.PP18.5 to PP 19 back to back angles not been connected as it is between 2BW to 3AW.

2. PP13 to 14 and PP 14 to 15 North and South side does not have back to back angle connections thus only for road barrier angles bolt tension verification carried out.

2. Lift 2 West (2AW to 2BW)

This Quality Assurance (QA) Inspector randomly witnessed in-progress splice plate installation for Side Panel to Side Panel for North and South side and Bottom plate bolt installation Panel Point No. 16 and 17.

Lift 2 West (2AW to 2BW)

This Quality Assurance (QA) Inspector randomly witnessed in-progress bolt snug tightening for bottom panel and bottom panel T-Rib Panel Point No. 16 and 17.

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
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