

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023341**Date Inspected:** 04-Aug-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

3AW to 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Rib to U-Rib for Segment 3AW to 3BW between PP 22 to PP 23. Inspected 10% of the bolt on random basis found satisfactory. Except 4 Nos. of U-Ribs as ZPMC has not installed the heavy thickness splice plates and not ready for inspection the U-Ribs as per dimension control plan as recorded on June 03, 2009 specify or calls for installation of heavy thickness splice plates at locations like 6th U-Rib (Left side -5); 7th U-Rib (Left -5 and Right -5); 15th U-Rib (Right -5) and 16th U-Rib (Right -5). Bolt sizes used are M22x2.5x65 RC Set No. DHGM220021 and final Torque required is 543 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26.

3AW to 3BW

This Quality Assurance (QA) Inspector noticed bolt snug tightening for the lower chevron angle in progress which connects the floor beam flange to splice plate.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2BE to 3AE

This Quality Assurance (QA) Inspector noticed gouging in progress for the temporary attachment for bottom panel between 2BE to 3AE.

1AE

This Quality Assurance (QA) Inspector noticed ABF QA performing MAG on Fillet/CJP weld for deck panel floor beam diaphragm to FL2 in progress at PP 10 (1AE).

2BE to 3AE

This Quality Assurance (QA) Inspector noticed match drilling been performed for Longitudinal Stiffener and Longitudinal Stiffener for segment 2BE to 3AE Cross Beam Side and Bike Path Side.

3AE and 3BE

This Quality Assurance (QA) Inspector noticed U-Rib turn of nut in progress for segment 3AE to 3BE between PP 22 and 23.

3AE and 3BE

This Quality Assurance (QA) Inspector noticed ZPMC performing MT on longitudinal diaphragm welds on Heat straightened areas between PP 22 and 23 for bike path side.

3BE

This Quality Assurance (QA) Inspector noticed carbon arc gouging at Corner assembly for CA-004-034 for X37 road barrier. The X37A was earlier Magnetic Particle Tested and accepted by ZPMC and CT.

3BW

This Quality Assurance (QA) Inspector noticed CJP welding in progress between PP 23 and PP 24 for Road barrier X37A at Corner assembly CA-005-034 and welder was identified as 045138.

3BW

This Quality Assurance (QA) Inspector noticed CJP welding in progress between PP 22 and PP 23 for Road barrier X37A at Corner assembly CA-003-022.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
