

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-023346**Date Inspected:** 04-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

4AW and 4BW

This Quality Assurance (QA) Inspector final tension verification carried out for 4AE to 4BE from PP24 to PP 28 Floor Beam Chevron (Lower Connecting Plate) were inspected on 10% random basis found satisfactory and green tag not signed off as held for calibration certificate. Bolt sizes used are M22x2.5x70 RC Set# DHGM220004 and final Torque required is 453 N-m. Small angle connecting to Floor beam flange to Lower Chevron Splice plate Bolt size used are M22x2.5x75 RC Set # DHGM220005 and final Torque required is 473 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.10.20.

This Quality Assurance (QA) Inspector final tension verification carried out for 4AE to 4BE from PP24 to PP 28 Floor Beam Chevron (Lower I-Beam) were inspected on 10% random basis found satisfactory and green tag not signed off as held for calibration certificate. Bolt sizes used are M22x80 RC Set# DHGM220006 and final Torque required is 440 N-m. Small angle connecting to Floor beam flange to Lower Chevron Splice plate Bolt size used are M22x2.5x75 RC Set # DHGM220005 and final Torque required is 473 N-m. Hydraulic Torque wrench is been

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used with Sr. No. Y090520001 and Hydraulic Machine No. PW090331002 with no calibration certificate on it.

This Quality Assurance (QA) Inspector final tension verification carried out for 4AE to 4BE from PP24 to PP 27 Floor Beam and Bottom Plate Clips (M16 x 65) were inspected on 10% random basis found satisfactory and green tag not signed off as held for calibration certificate. Bolt sizes used are M16x65 RC Set# DHGM160006 and final Torque required is 180 N-m but used 200 N-m as wrench minimum capacity was 200 N-m. Manual Torque wrench is been used with Sr. No. X02-118 with Calibration Due date as 2009.10.09.

4AE and 4BE ; 4AW and 4BW; 3AE and 3BE and 3AW and 3BW

This Quality Assurance (QA) Inspector along with Mr. Weiping Yang (ABF) went to cross check the Longitudinal Diaphragm (LD) dimension for offset but noticed splice plates been fitted with bolts except few misaligned holes. Mr. Weiping Yang told that he will arrange ZPMC to remove all of the bolts from locations and make it available for dimension verification and few location splice plates are held by taper pins which will be removed too for dimension verification as per ABF.

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
