

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-023349**Date Inspected:** 09-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

4AE and 4BE (North and South Side)

This Quality Assurance (QA) Inspector witnessed final tension verification for Floor Beam to Bottom Panel Clips 2 Nos. for Segment 4AE to 4BE from PP 28. Inspected 100% found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M22 x 80 RC Set# DHGM220050 and final Torque required is 486 N-m. Manual Torque wrench is been used with Sr. No. X02-654 with calibration due date as 2009.08.10. The Inspection was scheduled at 0830 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Floor Beam to Bottom Panel Clips 2 Nos. for Segment 4AW to 4BW from PP 24 to PP 27. Inspected 100% found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M16x 2.0 x 65 RC Set# DHGM160006 and final Torque required is 180 N-m. Manual Torque wrench is been used

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with Sr. No. X02-118 with calibration due date as 2009.10.20. The Inspection was scheduled at 1430 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Floor Beam to Bottom Panel Clips 16 Nos. for Segment 4AW to 4BW from PP 24 to PP 28. Inspected 10% found satisfactory and green tag not signed off as no ABF QC was available and held for calibration certificate for torque wrench. Bolt sizes used are M16x 2.0 x 45 RC Set# DHGM160002 and final Torque required is 250 N-m. Manual Torque wrench is been used with Sr. No. X02-118 with calibration due date as 2009.10.20. The Inspection was scheduled at 1500 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector received Bolting Inspection Notification No. 00016 Dated 2009-06-09 for U-Rib to U-Rib 4AW to 4BW. Inspection not carried out as ZPMC were not ready.

4AW and 4BW

This Quality Assurance (QA) Inspector randomly inspected snug tightening which was in progress at various locations as depicted below.

1. At PP 28 North side lower chevron snug tightening in progress.
2. At PP 28 South Side Panel Snug tightening in progress.
3. At PP 27 South Side Panel Snug tightening in progress.
4. At PP 27 South side Lower Chevron Snug tightening in progress.

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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