

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-023351**Date Inspected:** 11-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 witnessed final tension verification for Floor Beam to Bottom Panel Clips 2 Nos. for Segment 4AW to 4BW from PP 28. Inspected 100% found satisfactory and green tag not signed off as any ABF QC was not available. Bolt sizes used are M16x 2.0 x 60 RC Set# DHGM160006 and final Torque required is 180 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009. 06.26. The Inspection was scheduled from 1030 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron for Segment 4AW to 4BW from PP 24 to PP 28. Inspected 10% found satisfactory and green tag not signed off as any ABF QC was not available. Bolt sizes used are M22x 2.5 x 70 RC Set# DHGM220020 and final Torque required is 520 N-m and Bolt sizes used are M22x 2.5 x 75 RC Set# DHGM220005 and final Torque required is 473 N-m. Manual

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Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled from 1030 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper Chevron for Segment 4AW to 4BW from PP 24 to PP 28. Inspected 10% found satisfactory and green tag not signed off as any ABF QC was not available. Bolt sizes used are M22x 2.5 x 70 RC Set# DHGM220020 and final Torque required is 520 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled from 1030 Hrs. The Upper chevron 2 bolts north and south not completed as no accessibility for manual torque wrench.

4AE and 4BE

This Quality Assurance (QA) Inspector randomly inspected the longitudinal stiffeners heat straightening and prepared an Incident report no. 040120F4_TL-15_B278_06-11-09_Longitudinal Diaphragm.doc Dated 06.11.2009 for attempting to rectify the distortion and deflection by heat straightening without engineer approval.

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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