

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-023353**Date Inspected:** 14-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**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 and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Plate to Floor Beam connecting Clips for Segment 3AW to 3BW between PP 19 to PP 23. Inspected 10% of bolt final tensioning found satisfactory. Bolt sizes used are M16 -2.0 x 80 RC Lot No. DHGM160002 and final Torque required is 250 N-m. Manual Torque wrench is been used with Sr. No. X02-118. The Inspection was scheduled from 0830 Hrs.

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Plate to Floor Beam connecting Clips for Segment 3AW to 3BW between PP 19 to PP 23. Inspected 10% of bolt final tensioning found satisfactory. Bolt sizes used are M16 -2.0 x 80 RC Lot No. DHGM160002 and final Torque required is 250 N-m. Manual Torque wrench is been used with Sr. No. X02-118. The Inspection was scheduled from 0830 Hrs.

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3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper Chevron 2Bolts counter weight side 3AW to 3BW from PP 19 to PP 24. Inspected 100% found satisfactory. Bolt sizes used are M22x 2.5 x 70 RC Lot No. DHGM220020 and final Torque required is 23Mpa. Hydraulic Torque wrench is been used with Pump Model No. MP 582-2; Pump Sr. No. PW090331001 and Wrench Model No. ZXLCT; Sr. No. Y090520002 with no calibration. The Inspection was scheduled from 1400 Hrs. Rest of the bolts tension verification carried out for north side (Counter weight side) by Manual Torque wrench with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled from 1430 Hrs.

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper Chevron 2Bolts cross beam side 3AW to 3BW from PP 19 to PP 24. Inspected 100% found satisfactory. Bolt sizes used are M22x 2.5 x 70 RC Lot No. DHGM220020 and final Torque required is 23Mpa. Hydraulic Torque wrench is been used with Pump Model No. MP 582-2; Pump Sr. No. PW090331001 and Wrench Model No. ZXLCT; Sr. No. Y090520002 with no calibration. The Inspection was scheduled from 1600 Hrs.

3AW and 3BW

This Quality Assurance (QA) Inspector randomly verified snug tightening for Bottom Plate Splice plate between Panel Point No. 22 and 23. Snug tightening was been carried out by Ring Spanner.

3AW and 3BW

This Quality Assurance (QA) Inspector randomly verified snug tightening for Side Plate splice plate, South side at Panel Point 20, 21 and Panel Point 22.

3AW and 3BW

This Quality Assurance (QA) Inspector witnessed arrival of M22-2.5 x 80 with Lot No. DHGM220012 – 2 Container – 200 Nos. each and Grade A 325 M-1-MG.

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.

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Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer