

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-023359**Date Inspected:** 22-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

4BE

This Quality Assurance (QA) Inspector witnessed final torque verification for segment 4BE at Counter Weight side for T-Ribs for Side panel splice plate 6th T-Rib from the corner assembly was balance due to misalignment and rest of the T-ribs were inspected on 06.08.2009. As on date inspected 10% of the 6th R-rib from the Counter weight side and found the tension satisfactory .Bolt sizes used are M22x 2.5 x 65 RC Lot No. DHGM220016 and final Torque required is 495 N-m. Tension verification carried out by Manual Torque wrench with Sr. No. X02-584.

4AE and 4BE

This Quality Assurance (QA) Inspector prepared an incident report no.

040120F4_TL-15_B278_06-22-09_T-Rib_CB Side_2AE_PP_15. Incident report was been reported for misaligned T-Ribs, and for more comprehensive information refer the incident report.

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2BE

This Quality Assurance (QA) Inspector randomly witnessed in-progress snug tightening for Floor Beam to Bottom Panel at PP # 17.

2AE

This Quality Assurance (QA) Inspector randomly witnessed in progress rotation of nut for side panel splice plates cross beam side at PP # 16. Noticed traveler rail angles installation in progress.

2AE

This Quality Assurance (QA) Inspector randomly witnessed in progress snug tightening of nut for Lower Chevron for H-Beam to Floor beam bolts at PP # 15. Noticed bolts installation also in progress.

2AE

This Quality Assurance (QA) Inspector randomly witnessed in progress snug tightening of nut for side panel splice plates cross beam side at PP # 14.

2AE

This Quality Assurance (QA) Inspector randomly witnessed in progress installation of correct size and grade of bolts and nuts for lower chevron M22 X 80mm at PP # 13 at Bike path side.

2AW

This Quality Assurance (QA) Inspector randomly witnessed in progress snug tightening of upper chevron at PP # 15.

2AW

This Quality Assurance (QA) Inspector randomly witnessed in progress snug tightening of upper chevron at PP # 16.

2BW

This Quality Assurance (QA) Inspector randomly witnessed in progress snug tightening of upper chevron at PP # 18.

2AW and 2BW

This Quality Assurance (QA) Inspector witnessed randomly in progress rotation of nut for Bottom Plate to Floor Beam Clips at PP 13 to PP18.

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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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