

**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-023360**Date Inspected:** 23-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b> <b>No</b> <b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
		<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Trial Assembly	

**Summary of Items Observed:**

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

2AE to 2BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel Splice Plate for Segment 2AE to 2BE between PP 15 to 16. Inspected 10% of bolt final tensioning found satisfactory for Cross Beam side except 3rd and 4th T-rib from the Corner Assembly for PP15. Noticed that splice plate are not covering the T-rib flange area and splice plate is fitted in inclined manner. Informed the same to the David Wu (ABF), Lay Tao (ZPMC QA) they responded saying they will remove and fit the new splice plate and tensioned bolts will be discarded and Bolt sizes used are M22-2.5 x 65 RC Lot No. DHGM220033 final Torque required was 470 N-m. Manual calibrated torque wrench is been used bearing Sr. No. X02-584. The inspection was been carried out against the Bolting Inspection Sheet No. 00039.

2AW to 2BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Bottom Panel to Floor Beam Clips

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## WELDING INSPECTION REPORT

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for Segment 2AW to 2BW between PP 14 to 15(Except PP 14.5). Inspected 10% of bolt final tensioning found satisfactory. Bolt sizes used are M16 x 65 RC Lot No. DHGM160001 final Torque required was 210 N-m and Bolt sizes used are M16 x 45 RC Lot No. DHGM160006 final Torque required was 180 N-m. Manual calibrated torque wrench is been used bearing Sr. No. X02-118. The inspection was been carried out against the Bolting Inspection Sheet No. 00041.

2AW

This Quality Assurance (QA) Inspector randomly witnessed in-progress snug tightening for lower chevron connecting to Floor Beam to H-beam at PP # 15 and upper chevron from PP 13 to 15 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.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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