

**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-023379**Date Inspected:** 02-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>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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 (for Lift #4)

This Quality Assurance (QA) Inspector continues to monitor the final torque applying for U-Ribs 4AW and 4BW in between panel point PP No. 25 to 26. Noticed ZPMC bolt tightening personnel are turning nut marking 180 degree apart. R.C Lot No. is identified as DHGM 220021 Size M22 X 65. Few areas where they had left the mark not turned down to 180 degree shown ZPMC QC for rectification.

4AE and 4BE (for Lift #4)

This Quality Assurance (QA) Inspector continues to monitor the final torque applying for U-Ribs 4AW and 4BW in between panel point PP No. 25 to 26. Noticed ZPMC bolt tightening personnel are turning nut marking 180 degree apart. R.C Lot No. is identified as DHGM 220021 Size M22 X 65. Few areas where they had left the mark not turned down to 180 degree shown ZPMC QC for rectification.

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# WELDING INSPECTION REPORT

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Punch List for the 4AW and 4BW (for Lift #4) been prepared from PP 25 to 24 and PP24 and submitted to Mr. Aaron Prchlik.

As per the Bolting Inspection Notification Sheet Document No. 00006 Dated 06.01.2009. for Final Tension Verification from PP 24 to PP 28 Bottom Plate to Floor Beam Clips. For 4AE to 4 BE Lift # 4.

The Bolting Inspection was scheduled in the morning but rescheduled at 1500 Hrs due to the non-availability of Torque Wrench.

Final tension verification carried out from PP 24 to PP 28 bolts were inspected on 10% random basis found satisfactory and signed off the green tag 17 to 21.

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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