

**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-023392**Date Inspected:** 12-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 (from Counter Weight to Cross Beam side)

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Ribs to U-Ribs for Segment 4AE to 4BE between PP 25 to PP 26. Inspected 10% of bolt final tensioning found satisfactory. U-Ribs from 11 to 39 (Reference from Counter Weight to Cross Beam Side) completed the final verification and from 11 to 39 is balance. Bolt sizes used are M22 x 2.5 x 80 RC Set# DHGM220021 and final Torque required is 543 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date 2009.06.26. The Inspection was scheduled from 0930 Hrs.

4AW and 4BW

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron for I-Beam to Floor Beam for Segment 4AW to 4BW from PP 24 to PP 28. Inspected 10% found satisfactory. Bolt sizes used are M22x 2.5 x 80 RC Set# DHGM220012 and final Torque required is 23Mpa. Hydraulic Torque wrench is been

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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 1300 Hrs.

4AE and 4BE

This QA Inspector performed Magnetic Particle Testing (MT) for Longitudinal Stiffener for segment 4AE at OBG Trail Assembly Weld no. SEG018C-005 was accepted and Weld No. SEG018B-026 visually was not accepted thus MT not performed. This QA Inspector generated a TL-6028 MT report on this date.

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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