

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011704**Date Inspected:** 27-Jan-2010**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:** Wuzhi Chang, Li Yang**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:** Shanghai, China**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD (6CE)

This QA inspector witnessed final tension verification for floor beam to side panel clips (North & South) of Segment 6CE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP44, 45, 46 & 47: M16 X 45 – DHGM 160001 – 210 NM

PP44, 45, 46 & 47: M16 X 65 – DHGM 160006 – 180 NM

PP44, 45, 46: M16 X 50 – DHGM 160004 – 180 NM

OBG # TRIAL ASSEMBLY YARD (6CE)

This QA inspector witnessed final tension verification for floor beam to bottom panel clips (North & South) of Segment 6CE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

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PP44, 45, 46 & 47: M16 X 45 – DHGM 160001 – 210 NM

PP44, 45, 46 & 47: M16 X 65 – DHGM 160006 – 180 NM

OBG # TRIAL ASSEMBLY YARD (6AE)

This QA inspector witnessed final tension verification for lower chevron and upper chevron of Segment 6AE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP 37 (S), PP 38 (N): M22 X 70 – DHGM 220004 – 453 NM

M22 X 80 – DHGM 220050 – 486 NM

PP 37 (S) East, PP 38 (N) East: M22 X 75 – DHGM 220005 – 473 NM

OBG # TRIAL ASSEMBLY YARD (6AW)

This QA inspector witnessed final tension verification for T-Stiffener splice (Side panel at cross beam side) of Segment 6AW. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP38-PP40: M22 X 65 – DHGM 220021 – 543 NM

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed Root Gap for OBG Segment along with Caltrans QA inspector (Mr.Manjunath Math) for below segment. Reports forwarded to team leader for further action

6AW-6AE

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (7AE)

This QA inspector observed, ZPMC qualified welding personnel identified as 068596 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE7C-007 , ZPMC QC identified as Mr. Wang LI Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T

Segment# 6CE

Repair Welding

This QA inspector observed ZPMC qualified welding personnel identified as 049339 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG032J-095; The Welding Repair Report (WRR) was B-WR10057. ZPMC QC identified as Mr.Zhangalung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-345-SMAW-3G (3F)-FCM-Repair-1

Repair Welding

This QA inspector observed ZPMC qualified welding personnel identified as 048047 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG032J-050; The Welding Repair Report (WRR) was B-WR10057. ZPMC QC identified as Mr.Zhangalung. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
