

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-013159**Date Inspected:** 18-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** 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:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (6BE-6CE)**

This QA inspector witnessed final tension verification between U-Rib of Segment 6BE-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:

PP43-PP44

M22 X 65 – DHGM 220033 – 470 NM

(Except the following U-Rib locations tension verified: 6, 8, 9, 10, 11, 12, 23, 24, 25 and 27)

**OBG # TRIAL ASSEMBLY YARD (6AW-6BW)**

This QA inspector witnessed final tension verification between U-Rib of Segment 6AW-6BW. 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:

PP40-PP41

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M22 X 65 – DHGM 220035 – 433 NM

(Except the following U-Rib locations tension verified: 1 to 7, 14, 16, 17, 23, 24, 25, 26, 37 to 39)

OBG # TRIAL ASSEMBLY YARD (Lift 6E)

This QA inspector witnessed final tension verification Catwalk and Cable tray support of Lift 6E. 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:

PP37 – PP47:

M19 X 55(¾ X 2 ¼ inch) - DHG60580 – 340 NM

M16 X 40 – DHGM 160019 – 200 NM

M16 X 50 – DHGM 160011 – 200 NM

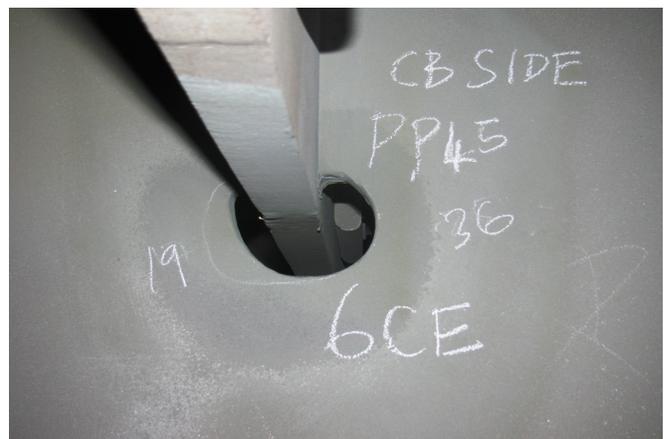
OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check to close out punch list items 223, 235 and 241 along with QA inspector (Mr. Manoj) on radius cut out in the floor beam web at corner assembly of Lift 6E. Reports forwarded to team leader for further action.

Lift 6E – PP37 to PP47

Please see the attached pictures below

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No Relevant Conversation.

## Comments

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

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