

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014964**Date Inspected:** 23-May-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:	N/A	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	
Bridge No:	34-0006	Delayed / Cancelled:	Yes No N/A	
		Component:	Orthotropic Box Girder (OBG)	

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:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment 7DE ~ 7EE (Corner Assembly)

This Quality Assurance (QA) Inspector witnessed final tension verification for Corner Assembly at Panel Point (PP) 55 and PP 60.5 Counter Weight Side and Cross Beam side for Segment 7DE ~ 7EE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00360 Dated May 23, 2010.

Bolt sizes used were M22 x 85 RC Set# DHGM220096 and final torque required was 583 N-m.

Bolt sizes used were M22 x 55 RC Set# DHGM220001 and final torque required was 443 N-m.

Bolt sizes used were M22 x 60 RC Set# DHGM220014 and final torque required was 567 N-m.

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Bolt sizes used were M22 x 65 RC Set# DHGM220013 and final torque required was 540 N-m.

Bolt sizes used were M22 x 80 RC Set# DHGM220011 and final torque required was 533 N-m.

Bolt sizes used were M22 x 120 RC Set# DHGM220052 and final torque required was 463 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-666.

Segment 7BW ~ 7CW (Side Panel T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs Cross Beam side and Bike Path Side between Panel Point (PP) 52 and PP 53 for Segment 7BW ~ 7CW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00360 Dated May 23, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220035 and final torque required was 433 N-m.

Bolt sizes used were M22 x 70 RC Set# DHGM220017 and final torque required was 520 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-667.

Note: Segment Splice to T Stiffeners (Cross Beam Location) Except 2, 3, 4, 5, 13, 16. Numbering Bottom to Top.

Segment 8CW to 9AW (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8CW to 9AW (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 from North towards South side. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

Segment 8CE to 9AE (U-Ribs) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8CE to 9AE (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 from North towards South side. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

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

Summary of Conversations:

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

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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:	Patterson,Rodney	QA Reviewer
