

**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-014972**Date Inspected:** 05-Jun-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

<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>	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 # 11AW (Green Tag)

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manjunath Math Joint Survey Inspection for the following Segment 11AW from Panel Point 95 to PP 97

Corner Assembly Cope Holes dimension measurements at PP 95~ 95.5, PP 96 ~ 96.5, PP 97 ~ 97.5 Counter Weight side and Cross Beam Side.

Flatness measurement for Floor Beam at PP 95, PP 96 and PP 97 Cross Beam and Counter Weight Side.

Flatness measurement for Deck Panel to Corner Assembly from PP 95.25 to PP 97.25 Cross Beam and Counter Weight side.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Flatness measurement for Side Panel to Corner Assembly from PP 94.75 to PP 97.75 Cross Beam and Counter Weight side and

Plumbness and Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 95, PP 96 and PP 97 East and West side of the Diaphragm.

The recorded measurements submitted to lead as well to the engineer for further action.

Segment # 8CW

This Quality Assurance (QA) Inspector witnessed final tension verification for Catwalk at Bottom Panel from Panel Point (PP) 67 ~ PP 71 for Segment 8CW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00371 Dated June 5, 2010

Bolt sizes used were M16 x 40 RC Set# DHGM160020 and final torque required was 200 N-m.

Bolt sizes used were M16 x 50 RC Set# DHGM160011 and final torque required was 200 N-m.

Bolt sizes used were M16 x 45 RC Set# DHGM160010 and final torque required was 200 N-m.

Manual Torque wrench was been used with Sr. No. 0900001. Please refer the pictures for more comprehensive detail.

Segment # 8CW ~ 9AW

This QA Inspector performed Joint Inspection with ABF Survey Team for the Skin Flatness between Segment 8AW to 8BW (Shop Segment Splice) between Panel Point (PP) 71 to PP 72

(Counter Weight side at B1 and B2 locations) and South (Cross Beam side at B3 and B4 Locations) at weld connecting Bottom Panel to Side Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation and

(Counter Weight side at T1 location) and South (Cross Beam side T2 Location) at weld connecting Deck Panel to Edge Panel with 5000mm String line for overall deformation and 600mm and 630 mm Straight Edge for localized deformation.

The measured readings were recorded on spread sheet, 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.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**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.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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