

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-015438**Date Inspected:** 02-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

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	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	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 # 8CE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manjunath Math Joint Survey Inspection for the following Segment 8CE from Panel Point 67.5 to PP 71

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 67.5 to 71 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 67.5 to 71 Cross Beam and Counter Weight side. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

WELDING INSPECTION REPORT

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Segment 8CE - 9AE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 8CE - 9AE (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 North(Cross Beam side) and South (Bike Path side) for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment # 9CW

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 9 East along with QA inspector Mr.Manjunath Math for smoothness. Below locations not complies with the ABF inspection report no: CWAHIR-9CW-03 dated 05th April 2010. Those locations after rectification ZPMC offer re-inspection flush grinding and sharp edges. All these details noted and forwarded to team leader for further action.

Location W4 - Panel point 77(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location W3 - Panel point 78(Facing West) - Floor beam to side panel cope hole

Location W3 - Panel point 78(Facing West) - Floor beam to bottom panel cope hole

Location W4 - Panel point 78(Facing West) - Floor beam to side panel cope hole

Location W4 - Panel point 78(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

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.

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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