

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-015617**Date Inspected:** 04-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 # 10BW

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 10 East along with QA inspector Mr. Manjunath Math for smoothness. Below locations not complies with the ABF inspection report no: CWAHIR-10BW-01 dated 3rd June 2010. Those locations flush grinding and sharp edges removal required. All these details noted and forwarded to team leader for further action.

Location W4 - Panel point 89(Facing West) - Floor beam to side panel cope hole

Location W4 - Panel point 89(Facing West) - Floor beam to bottom panel cope hole

Location W4 - Panel point 90(Facing West) - Floor beam to side panel cope hole

Segment# 7DE ~ 7EE (T-Ribs)

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This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Rib to T- Rib Cross Beam side and Bike Path Side between Panel Point (PP) 58 and PP 59 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. 00368 Dated June 4, 2010

Bolt sizes used were M22 x 80 RC Set# DHGM220091 and final torque required was 460 N-m,

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 380 N-m

Bolt sizes used were M22 x 70 RC Set# DHGM220004 and final torque required was 453 N-m.

Bolt sizes used were M22 x 70 RC Set# DHGM220009 and final torque required was 447 N-m.

Bolt sizes used were M22 x 70 RC Set# DHGM240003 and final torque required was 543 N-m.

Bolt sizes used were M22 x 95 RC Set# DHGM240021 and final torque required was 540 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-590.

Note: T-Ribs numbering reference taken from Side Panel (Cross Beam Side) as 12th T-Rib. 12mm reinforcing plate installed on the Splice Plate.

Segment # 8AW ~ 8BW & 8BW ~ 8CW

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) 64 to 65 and PP 67 to PP 68

(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.

Segment 8CW to 9AW (T-Ribs) Caltrans QA Survey Inspection

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Individual Inspection for the T-Ribs to T-Ribs between Segment 8CW to 9AW (Shop Segment Splice) between Panel Point (PP) 71 and PP 72 North(Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at

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Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review, for more comprehensive details please refer the pictures attached below.

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

Summary of Conversations:

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

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
