

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-015555**Date Inspected:** 12-Jul-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:** 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 Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (CB9)

This QA Inspector witnessed the final bolt tension verification on the Catwalk of Cross beam 9. The torque wrench S/N was X02-776. The QA Inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance. The bolt size designations were as follows:

M16 X 50 – DHGM 160011 – 200 NM

M16 X 45 – DHGM 160010 – 200 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (CB10)

This QA Inspector witnessed the final bolt tension verification on the Catwalk of Cross beam 10. The torque wrench S/N was X02-776. The QA Inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance. The bolt size designations were as follows:

M16 X 50 – DHGM 160011 – 200 NM

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

M16 X 45 – DHGM 160010 – 200 NM

OBG # TRIAL ASSEMBLY YARD (7CW-7DW)

This QA Inspector witnessed the final bolt tension verification on the WT stiffener – Bottom panel of segment 7CW to 7DW. The torque wrench S/N was X02-779. The QA Inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance. The panel point and bolt size designations were as follows:

PP 55 to PP 56:

M22 X 70 – DHGM 220017 – 487 NM

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9CE-9DE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 001 in the (4G) overhead position on side panel piece mark no. OBE9C. The location was the transverse splice weld joining segment 9CE and 9DE. The welder ID was 037932. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (9CE-9DE)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 002 in the (4G) overhead position on side panel piece mark no. OBE9C. The location was the transverse splice weld joining segment 9CE and 9DE. The welder ID was 066179. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG # TRIAL ASSEMBLY YARD (9CE)

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 021 in the (2F) horizontal position on WT stiffener piece mark no. SP691-001. The location was the hold back of WT stiffener fillet weld of segment 9CE. The welder ID was 067947. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations were reported on this date.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan, Murugan	Quality Assurance Inspector
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Reviewed By:	Peterson, Art	QA Reviewer
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