

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-015567**Date Inspected:** 13-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

This QA Inspector along with Mr. Manjunath S Math photographed and documented at various locations on lift 7E prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

Lift 7 East (Panel Point 47.5 through Panel point 55) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 7AE, 7BE and 7CE – PP 47.5, PP 48.5, PP 49.5, PP 50.5, PP 51.5, PP 52.5, PP 53.5 and PP 54.5.
2. Corner Assembly – Crossbeam side of segment 7AE, 7BE and 7CE – PP 48 to PP 55.
3. Longitudinal Diaphragm - Crossbeam side of segment 7AE, 7BE and 7CE – PP 48 to PP 55.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 7AE, 7BE and 7CE – PP 48 to PP 55.
5. Sea fasteners- 7AE, 7BE and 7CE – PP 48 to PP 55 except PP 54.
5. Longitudinal Diaphragm – Bike path side of segment 7AE, 7BE and 7CE – PP 48 to PP 55.
6. Corner Assembly – Bike path side of segment 7AE, 7BE and 7CE – PP 48 to PP 55.
7. Truss post – Bike path side of segment 7AE, 7BE and 7CE – PP 47.5, PP 48.5, PP 49.5, PP 50.5, PP 51.5, PP 52.

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5, PP 53.5 and PP 54.5.

OBG # TRIAL ASSEMBLY YARD

This QA Inspector performed dimensional survey inspection to close out the punch list items on the I Rib stiffeners – crossbeam and counterweight side to verify the out of flatness tolerance. The flatness inspection results appeared to be in general compliance with contract specifications. The segment and panel point designations were as follows:

Segment 8BW to Segment 8CW – PP 67 to PP 68

OBG # TRIAL ASSEMBLY YARD (8AE-8BE)

This QA Inspector witnessed the final bolt tension verification on the WT stiffener – Bottom panel of segment 8AE to 8BE. The torque wrench S/N was X02-666. 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 64 to PP 65:

M22 X 70 – DHGM 220009 – 447 NM

OBG # TRIAL ASSEMBLY YARD (8BE-8CE)

This QA Inspector witnessed the final bolt tension verification on the WT stiffener – Bottom panel of segment 8AE to 8BE. The torque wrench S/N was X02-666. 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 67 to PP 68:

M22 X 70 – DHGM 220009 – 447 NM

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

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