

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-015877**Date Inspected:** 21-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:** Liu Huajie**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

This QA received ZPMC inspection notification sheet 00432 to perform final tension verification for Retrofit Plate from location Panel point 64 ~ PP65 and PP67 ~ PP68 for Segment 8AE+8BE and 8BE+8CE Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M24 x 70 DHGM240075 and final torque required was 680 N-m.

Bolt sizes used were M24 x 90 DHGM240076 and final torque required was 474 N-m.

Bolt sizes used were M24 x 85 DHGM160036 and final torque required was 550 N-m.

Bolt sizes used were M24 x 75 DHGM160036 and final torque required was 600 N-m.

Bolt sizes used were M24 x 60 DHGM160036 and final torque required was 572 N-m.

Manual Torque wrench was been used with Sr. No. XO2-666. See the attached Photo.

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Segment # 8AE ~ 7EE

This QA received ZPMC inspection notification sheet 0433 to perform Cable Tray Wire Visual inspection From panel point PP61 ~PP62, mentioned all panel point cable tray wire installed remaining not installed due to sea fastener.

Segment # 7AW ~ 7EW

This QA received ZPMC inspection notification sheet 0429 to perform Cable Tray Wire Visual inspection From panel point PP47~PP58.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 069683 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP684-001-018; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1. See the attached Photo.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 045143 perform Flux Core Arc Welding (FCAW), weld joint identified as SP730-001-048; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 068097 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA059-005; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

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

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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.

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