

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-015981**Date Inspected:** 29-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:** 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 # 9BW

This QA received ZPMC inspection notification sheet 00444 to perform final tension verification for T-Rib to T-Rib at Side Panel Cross Beam side from FL3 location between Panel point 74 to 75.5, 75.5 to 76 for Segment 9BW. Inspected 10% on a random basis and found the tension to be in general compliance.

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

Manual Torque wrench was used with Sr. No. XO2-779

Note: Panel Point (PP) 74 SP to SP T-Rib Numbering from Bottom to Top 7th, 8th, 13th ~19th, Panel Point 75 T-rib no. 18th, 19th, Panel Point (PP) 76 2nd, 3rd, 5th ~8th, 10th ~12th, 16th ~ 19th not installed splice plate.

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Segment # 9BE

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG052A-039; The Critical Welding Repair Report (CWRR) was B-CWR1738. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 4G (4F) FCM-Repair-1. See the attached photo.

Bike Path-PP83

This QA inspector observed, ZPMC qualified welding personnel identified as 220066 perform Flux Core Arc Welding (FCAW), weld joint identified as BK001-PP083-005; ZPMC CWI is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. See the attached photo.

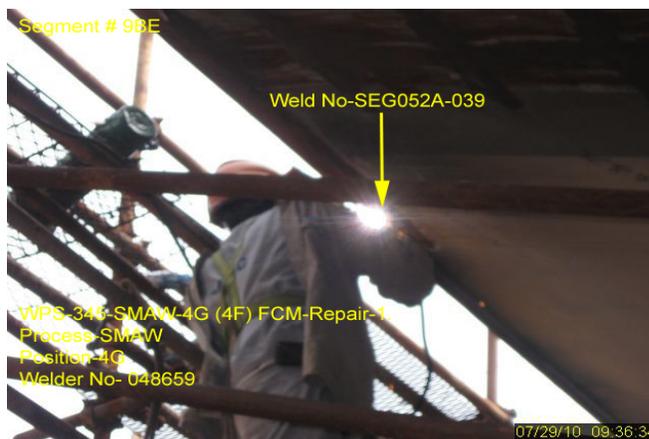
Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP770-001-012; 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-B-U2-FCM-1.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP492-001-055; 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-B-U2-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
