

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018298**Date Inspected:** 25-Nov-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:** Zhu Zhong Hai**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

DCP:

Segment # 11DW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00558 to perform final tension verification for T-Rib Small Connection Plate at Cross Beam and Bike Path side between Panel Points (PP) 104 to PP 106 for Segment 11DW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 X 65 DHGM220116 and final torque required was 333.3 N-m.

Bolt sizes used were M22 x 80 DHGM220094 and final torque required was 470 N-m.

Manual Torque wrench was been used with Sr. No. XO2-776

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Segment 11DW

This QA Inspector performed Dimension Control Inspection to check and measure, for the T-rib to T-rib Vertical offset (Cross Beam side) for Segment 11DW between Panel Point (PP) 104 and PP 106. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: WT Stiffener Offset / Transverse Segment Splice". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

WELDING:

Segment 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 perform Flux Core Arc Welding (FCAW), weld joint identified as CSD9-PP108-152; located On Orthotropic Box Girder (OBG) Floor Beam to Skin Plate Stiffener CJP Weld; The Welding Repair Report (WRR) was B-WR17693. ZPMC Quality Control (QC) is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appeared to comply with applicable WPS-345-FCAW -3G (3F) FCM-Repair-1. See attached photo for further details.

Cross Beam 16

This QA Inspector observed ZPMC qualified welding personnel identified as 044515 perform Flux Core Arc Welding (FCAW), weld joint identified as SP203-016-044; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate Transverse Splice Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132-ESAB .See attached photo for further details.

Cross Beam 16

This QA Inspector observed ZPMC qualified welding personnel identified as 057333 perform Shielded Metal Arc Welding (SMAW), weld joint identified as FB203-016-009; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate Transverse Splice Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1

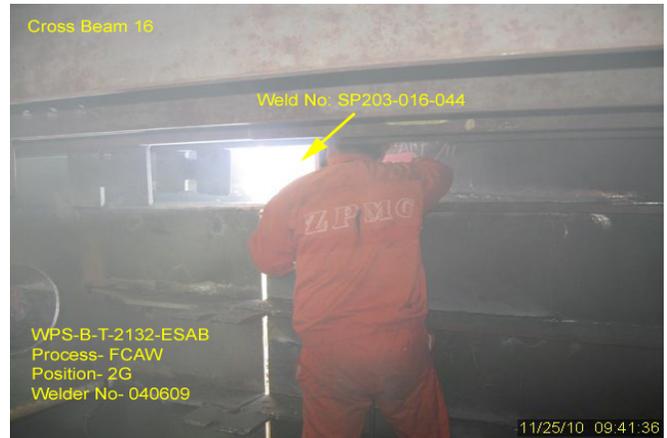
Cross Beam 16

This QA Inspector observed ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as FB203-016-010; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate Transverse Splice Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2114-FCM-1

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

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Summary of Conversations:

No significant 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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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