

**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-012421**Date Inspected:** 04-Mar-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, Wu Chi Cheng**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:

**OBG # TRIAL ASSEMBLY YARD**

Segment: LIFT 6 West

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Individual Inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at W3 Location from Panel Point (PP) 37 to PP 45, East and West side of Floor Beam.

Segment: LIFT 6 East

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Individual Inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 37 to PP 40, East and West side of Floor Beam.

Segment 5AW (Side Panel T-Ribs at FL3 Location)

This Quality Assurance (QA) Inspector witnessed final tension verification for Side Panel T-Ribs Cross Beam side

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between Panel Point (PP) 33 to PP 33.5 and PP 33.5 to PP 34 for Segment 5AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00269 Dated March 4, 2010

The following location are been inspected after installing the Extra Reinforcing Splice plate of 12mm thickness due to the vertical offset exceeding the requirement of RFI No. 2004 Rev. 0 Dated Dec 17, 2010.

At PP 33 to 33.5

9th T-rib, 10th T-rib, 12th T-rib, 13th T-rib, 14th T-rib, 15th T-rib, 17th T-rib, 18th T-rib, 19th T-rib.

At PP 33.5 to PP 34

10th T-rib, 11th T-rib, 12th T-rib, 14th T-rib, 15th T-rib, 16th T-rib, 18th T-rib, 19th T-rib

Bolt sizes used were M22 x 80 RC Set# DHGM220012 and final torque required was 470 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-084

Segment: 6AW

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Support at Panel Point (PP) 37 to PP-47. Tension verified on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No-00270 Dated March 4, 2010.

Bolt sizes used were M19 x 57.14 RC Set# DHGM60580 and final torque required was 340 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-118.

Segment# 6AW-6BW

This QA inspector observed, Heat Straightening Perform ZPM QC is identified as Mr. Zhong Yong Gang. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8155.

### **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.

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**Inspected By:** Prabhune,Manoj

Quality Assurance Inspector

**Reviewed By:** Miller,Mark

QA Reviewer