

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-013076**Date Inspected:** 30-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:	N/A	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:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

LAY DOWN YARD

SEGMENT: 9BW-Panel Point (PP) #74,75&76. (Individual Survey by Caltrans)

This QA Inspector along with Caltrans QA Mr. Manjunath Math randomly performed Joint Inspection for the Deck panel to Deck panel diaphragm offset(plumbness) measured for SEGMENT: 9BW- from PP# 74~76. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

The maximum offset readings noted in each Panel Points as follows:

1. Segment: 9BW-PP#74, Survey point: 11 (West side), Maximum offset reading is: 11 mm.
2. Segment: 9BW-PP#75, Survey point: 26 (West side), Maximum offset reading is: 15 mm.
3. Segment: 9BW-PP#76, Survey point: 1 and 39(East side), Maximum offset reading is: 11 mm.

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This QA Inspector along with Caltrans QA Mr. Manjunath Math Randomly performed Joint Inspection for the Deck panel diaphragm flatness for the SEGMENT: 9BW -PP #74, 75&76. The flatness has been measured by using 710 mm length straight edge. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

The maximum flatness readings noted in each Panel Points as follows:

1. Segment: 9BW-PP#74, Survey point: 13 (East side), Maximum Flatness reading is: 2.2 mm.
2. Segment: 9BW-PP#75, Survey point: 27 (East side), Maximum Flatness reading is: 4.5 mm.
3. Segment: 9BW-PP#76, Survey point: 1 (West side), Maximum Flatness reading is: 2.5 mm.

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed joint Inspection for the 'T' Rib cope holes buckling areas at FL3 Location at Segment: 9BW- PP #74, 75&76.

The maximum Buckled area readings noted in each Panel Points as follows:

1. Segment: 9BW-PP#74, Survey Location: 1 and 3, Maximum reading is: 4 mm.
2. Segment: 9BW-PP#75, Survey Location: 5, Maximum reading is: 4 mm.
3. Segment: 9BW-PP#76, Survey Location: 1, Maximum reading is: 3.5 mm.

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed joint Inspection for the 'T' Rib Horizontal and vertical offset at FL3 Location at Segment: 9BW- PP #74.

The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

This QA Inspector Randomly performed joint Inspection along with Caltrans QA Mr. Manjunath Math for the Panels flatness at Segment: 9BW- PP #74. The maximum deformation measured as follows.

- The Deformation was measured to be approximately 15 mm in 1500 mm Maximum template size.
- The Segment and Panel Point no is 9BW- PP #74 Facing West at Crossbeam (CB) Side.

BAY: 5-TRAVELER RAIL(TR).

This QA Inspector along with Caltrans QA Mr. Manjunath Math measured the length of Traveler Rails at location 1 and 2. Total number of TR's: 09 No's. The measured readings were data recorded, generated the report and submitted to the Task Leader. The TR designations are review as follows:

1. 10TR-020. 2. 10TR3-017. 3. 10TR1-024. 4. 10TR3-035. 5. 11TR5-008.
6. 11TR1-030. 7. 10TR6-002. 8. 11TR1-024. 9. 11TR6-002.

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 Quality Control (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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
