

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-013150**Date Inspected:** 28-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**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:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

ZPMC SHIP # 17

This QA inspector witnessed final tension verification on Traveler rail of Lift 6W. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP37-PP47

M20 X 95 – DHGM 200018 – 347 NM

M20 X 160 – DHGM 200006 – 340 NM

M22 X 90 – DHGM 220048 – 500 NM

M22 X 120 – DHGM 220051 – 433 NM

For further information, please see the attached pictures below.

ZPMC SHIP # 17

This QA inspector witnessed final tension verification on Suspender bracket of Lift 6W. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size

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designations are as follows:

PP38, PP 40, PP 42, PP 44 and PP46
M24 X 75 – DHGM 240020 – 600 NM
M24 X 95 – DHGM 240021 – 540 NM
M27 X 85 – DHGM 270001 – 853 NM

For further information, please see the attached pictures below.

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



Summary of Conversations:

No Relevant Conversation.

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 , who represents the Office of Structural Materials for your project.

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Inspected By:	Manikandan, Murugan	Quality Assurance Inspector
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Reviewed By:	Miller, Mark	QA Reviewer
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