

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-013154**Date Inspected:** 24-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 performed photo documentation along with QA inspector (Mr. Manoj) on segment lift 5 (West) located on ZPMC ship # 17 prior to being shipped to San Francisco California for erection. The following locations and members documented are as follows:

Lift 5 West (Panel Point 29~34) following sequence pictures documented

1. Corner Assembly - Counterweight side of segment.
2. Longitudinal Diaphragm - Counterweight side of segment.
3. Chevron Diagonal members (upper and lower) - Counterweight side of segment.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment.
5. Longitudinal Diaphragm - Crossbeam side of segment.
6. Corner Assembly - Crossbeam side of segment.

ZPMC SHIP # 17 (Lift 5E)

The Caltrans Quality Assurance (QA) Inspector observed that the tightening of the bolts were not performed per the approved procedure.

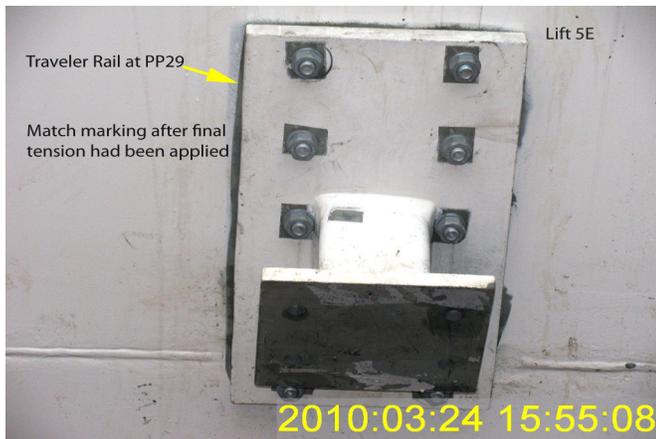
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- Marking bolts after final tension had been applied at Traveler Rail located at PP 29.
- ZPMC workers were performing final bolt tightening of ASTM A325 bolts by turn-of-nut specification of 180° to 210°.
- This issue is located at Lift 5E Traveler Rail at PP 29 to PP 36 (Bike path side)

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:

The incident report is issued for the above mentioned discrepancy observed in Lift 5E. And prior to issue it was informed to ZPMC QC and ABF QA.

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.

Inspected By: Manikandan,Murugan

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer