

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-013683**Date Inspected:** 30-Apr-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:** 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

Segment # Lift 7

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray at Panel Point (PP) 48 ~ PP 61 for Segment 7AE ~ 7EE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00337 Dated April 30, 2010.

Bolt sizes used were M19 x 55 RC Set# DHG60580 and final torque required was 340 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Note: Cable Tray Support (Angle Frame Location) –Except PP 50~50.5 and PP56 ~ 56.5 due to sea fastener Impact.

Segment # Lift 8

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

This Quality Assurance (QA) Inspector witnessed final tension verification for Cable Tray Support at Panel Point (PP) 61~ PP 71 for Segment 8AW ~8CW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00336 Dated April 30, 2010.

Bolt sizes used were M19 x 55 RC Set# DHG60580 and final torque required was 340 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-114.

Note: Cable Tray Support (I beam Location) –Except PP64~PP65 and PP67 ~ PP68

Segment # 8CE~8BE

This QA inspector observed, ZPMC qualified welding personnel identified as 067904 perform Shielded Metal Arc Welding (SMAW) for weld connecting Edge Plate to Edge Plate Cross Beam side, weld joint identified as OBE8A-005; ZPMC QC is identified as Mr.Zhang Qiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. See the attached below Photo.

Segment # Cross Beam 7

This QA inspector observed, ZPMC qualified welding personnel identified as 220066 perform Flux Core Arc Welding (FCAW) for weld connecting Side Plate to Bottom Plate Cross Beam side, weld joint identified as FB039-007; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F. See the attached below Photo.

Segment # 7DW~7EW

This QA inspector observed, ZPMC qualified welding personnel identified as 066413 perform Shielded Metal Arc Welding (SMAW) for weld connecting Transverse Splice Weld Side plate to Side plate Counter Weight Side, weld joint identified as OBE7C-007; ZPMC QC is identified as Mr.Liu Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached below Photo.

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

## 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.

---

---

## WELDING INSPECTION REPORT

*( Continued Page 3 of 3 )*

---

---

---

<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

---