

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-014273**Date Inspected:** 28-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 # 7BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron Angle (Bike Path & Cross Beam side) at Panel Point (PP) 50~ 60, Segment 7AE Inspected 100% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00333 Dated April 26, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220018 and final torque required was Rotation of Nut 180 degree.

At Segment 7BE at Panel Point (PP) 50 ~ PP 60 for Lower Chevron Brace (Bike Path & Cross Beam side) Bolt

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Size used was M22 x 75 RC Set# DHGM220005 and final torque required was 473 N-m respectively and Notification No. 00333 Dated April 26, 2010.

Manual Torque wrench was been used with Sr. No. XQ2-776.

Segment # 7CW-PP55

This QA inspector observed, ZPMC qualified welding personnel identified as 037996 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP641-001-018; ZPMC QC is identified as Mr.Cai Xiao Yeng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1. See the attached below Photo.

Segment # 8BE-PP67

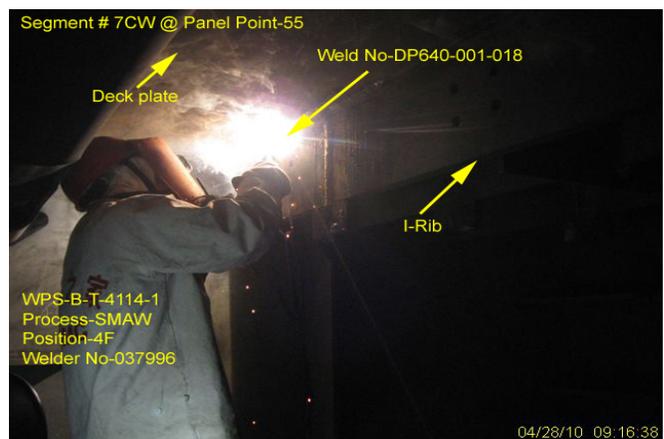
This QA inspector observed, ZPMC qualified welding personnel identified as 066746 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG046A-012; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T.

See the attached below Photo.

Segment # 8CE

This QA inspector observed, ZPMC qualified welding personnel identified as 068764 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP661-001-008; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1.

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



Summary of Conversations:

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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: | Patterson,Rodney | QA Reviewer |
