

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-014288**Date Inspected:** 17-May-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 8CE (Upper and Lower Chevron)**

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper and Lower Chevron (North and South side) at Panel Point (PP) 68 to PP 71 for Segment 8CE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00344 Dated May 8, 2010

Bolt sizes used were M22 x 70 RC Set# DHGM220004 and final torque required was 453 N-m.

Bolt sizes used were M22 x 75 RC Set# DHGM220034 and final torque required was 453 N-m.

Bolt sizes used were M22 x 80 RC Set# DHGM220050 and final torque required was 486 N-m.

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Manual Torque wrench was been used with Sr. No. XQ2-666.

Segment # 7DW-PP57

This QA inspector observed ZPMC qualified welding personnel identified as 045143 perform Flux Core Arc Welding (FCAW), weld joint identified as TR1A-PP057-002 and was observed welding in the 1G (Flat) position; ZPMC QC is identified as Mr.Wang Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4b-FCM.

Segment # 7CW ~ 7DW

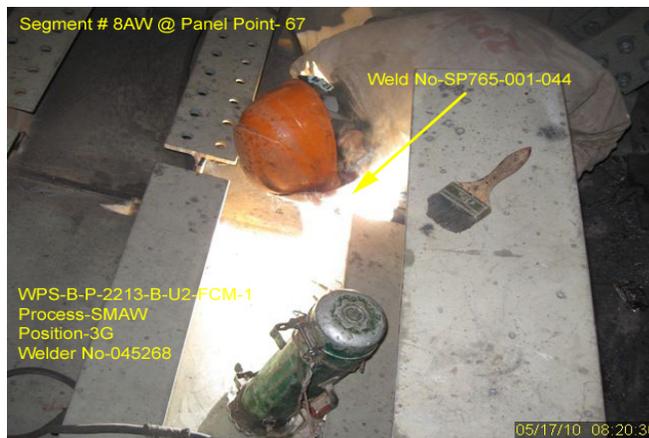
Repair Welding

This QA inspector observed ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW7C-004 and was observed welding in the 4G (Horizontal) position; The Welding Repair Report (WRR) was B-WR12774. ZPMC QC is identified as Mr.Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. See the attaché below Photo.

Segment # 8AW-PP67

This QA inspector observed ZPMC qualified welding personnel identified as 045268 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP765-001-044 and was observed welding in the 3G (Vertical) position; ZPMC QC is identified as Mr.Zhang Xing Ming. 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.

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

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for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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