

**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-014967**Date Inspected:** 28-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

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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, 7CE, 7DE, 7EE

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 7BE, 7CE, 7DE, 7EE East along with QA inspector (Manikandan) for smoothness. ABF inspection report no: CWAHIR-7BE-03 dated 1st May 2010, CWAHIR-7CE-02 dated 1st May 2010, CWAHIR-7DE-02 dated 1st May 2010 and CWAHIR-7EE-01 dated 1st May 2010. All these details noted and forwarded to team leader for further action.

Segment # 10CE (Green Tag)

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manjunath Math for the Horizontal Offset and Buckling at T-Ribs below the Floor Beam for the Transverse Segment T-Ribs to T-Ribs

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at Side Panel dimension was recorded from following work point for Segment 10CE between Panel Point (PP) 92 to PP 94 at the following locations.

Side Panel from work point E4 to E6.

The measured and recorded readings were submitted to the Lead and Engineer for review.

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manikandan Joint Survey Inspection for the following Segment 10CE from Panel Point 92 to PP 94

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 92 to 94 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 92 to 94 Cross Beam and Counter Weight side.

Segment # 8AW

Flatness measurement for Side Panel to Corner Assembly from PP 61 to PP 62 Cross Beam and Counter Weight side and

Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 61 to PP 62 East and West side of the Diaphragm.

Segment # 8BW

Flatness measurement for Side Panel to Corner Assembly from PP 65 to PP 66 and PP 67 Cross Beam and Counter Weight side and

Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 65 to PP 66 and PP 67 East and West side of the Diaphragm.

Segment # 8CW

Flatness measurement for Side Panel to Corner Assembly from PP 70 to PP 71 Cross Beam and Counter Weight side and

Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 70 to PP 71 East and West side of the Diaphragm.

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

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## Summary of Conversations:

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

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