

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-015436**Date Inspected:** 24-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:	N/A	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, 7DE, 8AE, 8CE (T-Ribs)

This Quality Assurance (QA) Inspector witnessed final tension verification for T-Rib to T-Rib at Side Panel Cross Beam side between Panel Point (PP) 70, PP 62, PP58, PP56, PP 50, PP51, PP 52 for Segment 7BE, 7DE, 8AE, 8CE. Inspected the T-Ribs along with 12mm Reinforcing Splice Plate above the Splice Plates. Tension verified on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00362 Dated May 24, 2010.

The following location are been inspected after installing the Extra Reinforcing Splice plate of 12mm thickness due to the vertical offset exceeding the requirement of RFI No. 2004 Rev. 0 Dated Dec 17, 2010.

At PP 70

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

15th location, 16th location, 17th location, 18th location, 19th location.

At PP 62

15th location.

At PP 58

1st location, 3rd location, 4th location, 5th location, 6th location, 8th location, 9th location, 10th location, 11th location, 12th location, 13th location, 14th location, 15th location, 18th location, 19th location.

At PP 52

10th location, 11th location, 12th location, 13th location, 17th location, 18th location, 19th location.

At 51

19th location.

At 50

16th location, 18th location.

Bolt sizes used were M22 x 80 RC Set# DHGM220091 and final torque required was 460 N-m.

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

Note: T-Ribs numbering reference taken from Bottom Panel as 1st T-Rib and towards Side Panel as 19th T-Rib.

OBG Trial Assembly Yard (Lift 7 East)

The QA inspector performed inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 48 to PP 61.5, East and West side of Floor Beam.

Report forwarded to team leader for further action, kindly refer to the pictures attached below when measured with 25mm Radius template and 50mm Radius template.

Segment 8AE ~ 8CE

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron from Panel Point (PP) 61 ~ PP 71 for Segment 8AE ~ 8CE. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00361 Dated May 24, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220105 and final torque required was 380 N-m.

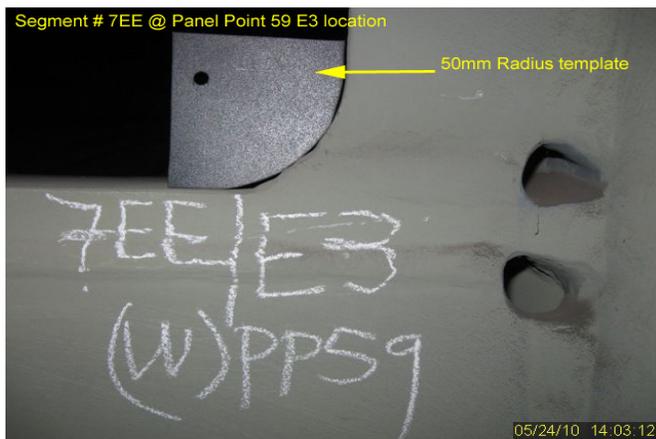
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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

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

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.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer