

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-015443**Date Inspected:** 03-Jun-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 # 8AE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manunath Math Joint Survey Inspection for the following.

Flatness measurement for Side Panel to Corner Assembly from PP 61 towards PP 62 Measurement area

1040mm ~ 3200mm and observed flatness 5.3mm, 6.8mm, 7.5mm, 6.5mm.

4220mm ~ 4580mm and observed flatness 5.5mm, 5.6mm, 5.8mm.

Panel Point 63 towards 64

2000mm ~ 3560mm and observed flatness 5.5mm, 6.0mm.

Segment # 8CE

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Flatness measurement for Side Panel to Corner Assembly from Panel Point 68 towards PP 69
820mm ~ 2990mm and observed flatness 5.5mm ~ 6.8mm.

Segment # 7EE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manunath Math Joint Survey Inspection for the following.

Flatness measurement for Side Panel to Corner Assembly from Panel Point 59 towards PP 60
1760mm ~ 3920mm and observed flatness 5.5mm, 6.2mm, 8.5mm, 11.6mm.

Segment # 7BE

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manunath Math Joint Survey Inspection for the following.

Flatness measurement for Side Panel to Corner Assembly from Panel Point 54 towards PP 55
440mm ~ 810mm and observed flatness 5.5mm ~ 5.7mm
1750mm ~ 2860mm and observed flatness 5.5mm ~ 6.4mm
3740mm ~ 4400mm and observed flatness 5.5mm ~ 5.8mm

Segment 9AE ~ 9BE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 9AE ~ 9BE (Shop Segment Splice) between Panel Point (PP) 73 and PP 74 North(Cross Beam side) and South (Bike Path side) for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 9AW ~ 9BW

This QA inspector observed ZPMC qualified welding personnel identified as 067183 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9B-004 and was observed welding in the 4G (Overhead) position; 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-P-2214-B-U2-FCM-1

Segment # 8CW

This QA inspector observed ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG047B-046 and was observed welding in the 4G (Overhead) position; ZPMC QC is identified as Mr.Wang Zhu. The welding parameters measured using QC's calibrated

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instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1

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
