

**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-015505**Date Inspected:** 09-Jul-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:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

**OBG # TRIAL ASSEMBLY YARD (8AW)**

This QA inspector witnessed the final bolt tension verification on the FL3 – Web plate to bottom plate of segment 8AW. The torque wrench S/N was X02-871 and X02-767. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance. The panel point and bolt size designations were as follows:

PP 62 to PP 64:

M24 X 60 – DHGM 240014 – 567 NM

M24 X 65 – DHGM 240002 – 573 NM

M24 X 70 – DHGM 240010 – 1200 NM

For additional information please reference the pictures below:

**OBG # TRIAL ASSEMBLY YARD (8CW)**

This QA inspector witnessed the final bolt tension verification on the FL3 – Web plate to bottom plate of segment 8CW. The torque wrench S/N was X02-871 and X02-767. The QA inspector witnessed 10% of the bolts on a

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random basis and found the tensioning of the bolts appeared to be in general compliance. The panel point and bolt size designations were as follows:

PP 68 to PP 70:

M24 X 60 – DHGM 240014 – 567 NM

M24 X 65 – DHGM 240002 – 573 NM

M24 X 70 – DHGM 240010 – 1200 NM

OBG # TRIAL ASSEMBLY YARD

This QA inspector along with QA inspector Mr. Manoj Prabhune performed the dimensional survey inspection to verify the root gap and offset on the transverse splice weld of segment 9CE and segment 9DE. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 9CE to Segment 9DE – PP 79 to PP 80

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (9CE-9DE)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 028 in the (3G) vertical position on bottom panel WT stiffener piece mark number BP172-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 9CE and 9DE. The welder ID was 067947. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG # TRIAL ASSEMBLY YARD (9CE-9DE)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 028 in the (3G) vertical position on bottom panel WT stiffener piece mark number BP126-001. The location was the complete joint penetration groove weld joining the WT stiffeners of segment 9CE and 9DE. The welder ID was 068501. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

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

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## Summary of Conversations:

No relevant conversations were reported on this date.

## 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 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Manikandan,Murugan	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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