

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-015907**Date Inspected:** 21-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.

ZPMC SHIP # 19 (Lift 8E)

This QA Inspector witnessed the final bolt tension verification on the catwalk handrail of segment 8AE –FL3 and segment 8CE-FL3. 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 63 & PP 68 to PP 69: M16 X 95 – DHGM 160036.

ZPMC SHIP # 19 (Lift 8W)

This QA Inspector witnessed the final bolt tension verification on the catwalk handrail of segment 8AW –FL3 and segment 8CW-FL3. 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 63 & PP 68 to PP 69: M16 X 95 – DHGM 160036.

ZPMC SHIP # 19 (Lift 7E)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector witnessed the final bolt tension verification on the catwalk handrail of segment 7BE –FL3 and segment 7DE-FL3. 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 50 to PP 51 & PP 56 to PP 57: M16 X 95 – DHGM 160017.

ZPMC SHIP # 19 (8AE)

This QA Inspector along with Mr. Shailesh Wadkar photographed and documented at various locations on OBG 8AE prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 8AE (Panel Point 60 thru Panel point 64) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 8AE – PP 60.5, PP 61.5, PP 62.5 and PP 63.5.
2. Corner Assembly – Crossbeam side of segment 8AE – PP 60 to PP 64.
3. Longitudinal Diaphragm - Crossbeam side of segment 8AE – PP 60 to PP 64.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 8AE – PP 60 to PP 64.
5. Sea fasteners- 8AE – PP 60 to PP 64.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 8AE – PP 60 to PP 64.
7. Longitudinal Diaphragm – Bike path side of segment 8AE – PP 60 to PP 64.
8. Corner Assembly – Bike path side of segment 8AE – PP 60 to PP 64.
9. Truss post – Bike path side of segment 8AE – PP 60.5, PP 61.5, PP 62.5 and PP 63.5.

ZPMC SHIP # 19 (8BE)

This QA Inspector along with Mr. Shailesh Wadkar photographed and documented at various locations on OBG 8BE prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 8BE (Panel Point 64.5 thru Panel point 67) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 8BE – PP 64.5, PP 65.5 and PP 66.5.
2. Corner Assembly – Crossbeam side of segment 8BE – PP 65 to PP 67.
3. Longitudinal Diaphragm - Crossbeam side of segment 8BE – PP 65 to PP 67.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 8BE – PP 65 to PP 67.
5. Sea fasteners- 8BE – PP 65 to PP 67.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 8AE – PP 65 to PP 67.
7. Longitudinal Diaphragm – Bike path side of segment 8BE – PP 65 to PP 67.
8. Corner Assembly – Bike path side of segment 8BE – PP 65 to PP 67.
9. Truss post – Bike path side of segment 8BE – PP 64.5, PP 65.5 and PP 66.5.

ZPMC SHIP # 19 (8CE)

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector along with Mr. Shailesh Wadkar photographed and documented at various locations on OBG 8CE prior to the shipment of (Voyage 4) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 8CE (Panel Point 68 thru Panel point 71) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 8CE – PP 68.5, PP 69.5 and PP 70.5.
2. Corner Assembly – Crossbeam side of segment 8CE – PP 68 to PP 71.
3. Longitudinal Diaphragm - Crossbeam side of segment 8CE – PP 68 to PP 71.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 8CE – PP 68 to PP 71.
5. Sea fasteners- 8CE – PP 68 to PP 71.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 8CE – PP 68 to PP 71.
7. Longitudinal Diaphragm – Bike path side of segment 8CE – PP 68 to PP 71.
8. Corner Assembly – Bike path side of segment 8CE – PP 68 to PP 71.
9. Truss post – Bike path side of segment 8CE – PP 68.5, PP 69.5 and PP 70.5.

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

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.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
