

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-016170**Date Inspected:** 13-Aug-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

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|------------------------------------|---------------------------------|----------------------------------|------------------------------|----------------------|
| 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 |
| Bridge No: | 34-0006 | Delayed / Cancelled: | Yes | No N/A |
| | | 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 Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment 9BW~9CW

This QA Inspector performed dimensional Joint Inspection with Caltrans (CT) QA Mr. Manjunath Math, for the Longitudinal Diaphragm to Longitudinal Diaphragm W3 location (Cross Beam side) and W4 location (Counter Weight side) for Segment 9BW to 9CW between Panel Point (PP) 76 and PP 77. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: LD Offset and Sweep". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Punch List item # 340

The QA inspector performed inspection for the punch list item 340 for out of Flatness of Transverse Splice Weld

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at Edge Plate CJP was been cut and re-welded at location W5 (Cross Beam Side) between Panel Point PP 73 and PP 74 and dimension verification performed, found the dimension Satisfaction.

Punch List item # 342

The QA inspector performed inspection for the punch list item 342 for out of Flatness of Transverse Splice Weld at Edge Plate CJP was been cut and re-welded at location W2 (Counter Weight Side) between Panel Point PP 73 and PP 74 and dimension verification performed, found the dimension Satisfaction.

Segment # 9EE, 9BE, 9AE (After Heat Straightening)

This QA performed a joint survey dimensional inspection of Plumbness & Flatness on segment 9EE, 9BE, 9AE. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the Deck Panel diaphragm plate plumbness & Flatness were taken from PP72, PP73, PP76 and PP85. dimension verification performed, found the dimension Satisfaction. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Deck Panel Diaphragm Plate Plumbness & Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9AE and 9DW

This QA performed a joint survey dimensional inspection of Flatness on segment 9AE and 9DW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the Floor Beam Flatness were taken from PP72 and PP80. Dimension verification performed, found the dimension Satisfaction. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Floor Beam Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

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.

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| Inspected By: | Prabhune,Manoj | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
