

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016894**Date Inspected:** 08-Sep-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:** Zhu Zhong Hai**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 # 9CW ~ 9DW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00472 to perform final tension verification for T-Rib to T-Rib at Cross Beam and Counter Weight Side between Panel Points (PP) 79 to PP 80 for Segment 9CW to 9DW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 65 DHGM220003 and final torque required was 503 N-m.

Bolt sizes used were M24 x 70 DHGM220038 and final torque required was 480 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676. See the attached Photo.

Segment # 9AW ~ 9BW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00472 to perform final tension

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verification for T-Rib to T- Rib at Counter Weight Side between Panel Points (PP) 73 to PP 74 for Segment 9CW to 9DW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 70 DHGM220017 and final torque required was 487 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676

Segment # 9DW FL 3

This Quality Assurance (QA) received ZPMC inspection notification sheet 00472 to perform final tension verification for T-Rib to T- Rib at Cross Beam Side between Panel Points (PP) 80 for Segment 9DW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 65 DHGM220002 and final torque required was 513 N-m.

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

Manual Torque wrench was been used with Sr. No. XO2-676

Segment # 10AW ~ 10BW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10B-003; The Critical Welding Repair Report (CWRR) was B-CWR1889.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-345-SMAW-4G (4F) FCM-Repair.

Segment # 10BW ~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 067656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP117-001-012; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1.

Segment # 10BW~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10C-004; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached Photo.

Segment # 10AE ~ 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 040367 perform Flux Core Arc Welding (FCAW), weld joint identified as SP550-001-051; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

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Segment # 10BW ~ 10CW

This QA inspector observed, ZPMC qualified welding personnel identified as 068917 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA074-002; ZPMC QC is identified as Mr. Zhong Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-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
