

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-016901**Date Inspected:** 16-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:** Liu Hua Jie**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 # 9AW ~ 9EW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00493 to perform final tension verification for Traveler Rail Bracket at Counter Weight side between Panel Points (PP) 72 to PP 85 for Segment 9AW to 9EW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 90 DHGM220048 and final torque required was 500 N-m.

Bolt sizes used were M22 x 120 DHGM220053 and final torque required was 440 N-m.

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

Segment # 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc

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Welding (SMAW), weld joint identified as CA076-002; ZPMC CWI is identified as Mr.Liu Hua Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1. See the attached Photo.

Segment # 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA075-006; ZPMC CWI is identified as Mr. Liu Hua Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1.

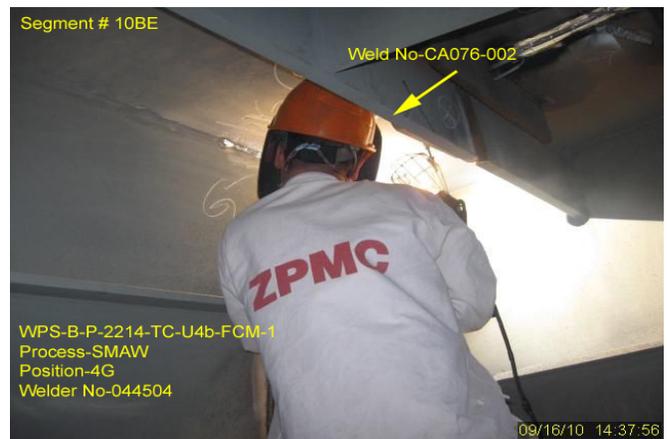
Segment # 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 052763 perform Flux Core Arc Welding (FCAW), weld joint identified as BP076-001-043; ZPMC CWI is identified as Mr.Liu Hua Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 10BE ~ 10CE

This QA inspector observed, ZPMC qualified welding personnel identified as 040367 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE10C-002; ZPMC CWI is identified as Mr.Liu Hua Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T.

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 |
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| Reviewed By: | Patterson,Rodney | QA Reviewer |
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