

**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-017593**Date Inspected:** 20-Oct-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 (10E)**

This QA inspector witnessed the final bolt tension verification on the Cable tray support of Lift 10E. The torque wrench S/N was X02-114. 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 with the contract specifications. The panel point and bolt size designations were as follows:

PP 86 to PP 94:

M19 X 50 – DHG 60631 – 346 NM

**OBG # TRIAL ASSEMBLY YARD (10AW)**

This QA inspector witnessed the final bolt tension verification on the Bottom panel T-Rib clips of 10AW. The torque wrench S/N was X02-666. 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 with the contract specifications. The panel point and bolt size designations were as follows:

PP 87 and PP 88:

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M22 X 80 – DHGM 220029 – 447 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (10CW)

This QA inspector witnessed the final bolt tension verification on the Bottom panel T-Rib clips of 10AW. The torque wrench S/N was X02-666. 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 with the contract specifications. The panel point and bolt size designations were as follows:

PP 92 and PP 93:

M22 X 80 – DHGM 220012 – 427 NM

OBG # OUTSIDE YARD (12BE)

This QA Inspector performed the dimensional survey inspection for green tag along with QA inspector Mr. Manjunath S Math for the Segment 12BE from Panel Point 113 to 114.5. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition.

Inspection details are as follows:

- 1)Skin flatness measurement on the longitudinal weld joining deck panel and corner assembly deck panel using 600mm straight edge.
- 2)Skin flatness measurement on the longitudinal weld joining Side panel and corner assembly Side panel using 600mm straight edge.
- 3)Plumbness and flatness measurements between the Deck panel and the deck panel diaphragm using right angle square and 710mm straight edge.
- 4)Flatness measurement on the floor beam using 1500mm straight edge.
- 5)Radius measurement on the corner assembly cope holes using 150mm rule.

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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