

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-017862**Date Inspected:** 15-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:** An Qing Xiang**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 # 10AW ~ 10BW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00509 to perform final tension verification U-Rib at Cross Beam and Counter Weight side between Panel Points (PP) 88 to PP 89 for Segment 10AW to 10BW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 70 DHGM220022 and final torque required was 487 N-m.

Manual Torque wrench was been used with Sr. No. XO2-776.

Segment # 10AW ~ 10BW

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This Quality Assurance (QA) received ZPMC inspection notification sheet 00509 to perform final tension verification T-Rib Side Plate to Side plate at Cross Beam and Counter Weight side and Bottom Plate between Panel Points (PP) 88 to PP 89 for Segment 10AW to 10BW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 70 DHGM220038 and final torque required was 480 N-m.

Manual Torque wrench was been used with Sr. No. XO2-776. See the attached Photo.

Note:- Bottom Plate T-Rib Cross Beam Side 3rd T-Rib balance for final tension verification.

WELDING

Segment # 11AE

This QA inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11B-003; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld. The Welding Repair Report (WRR) was B-WR15966. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM Repair-1 See the attached Photo.

Segment # 11AE

This QA inspector observed ZPMC qualified welding personnel identified as 040265 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG064A-043; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld. The Critical Welding Repair Report (CWRR) was B-CWR2045. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM Repair-1

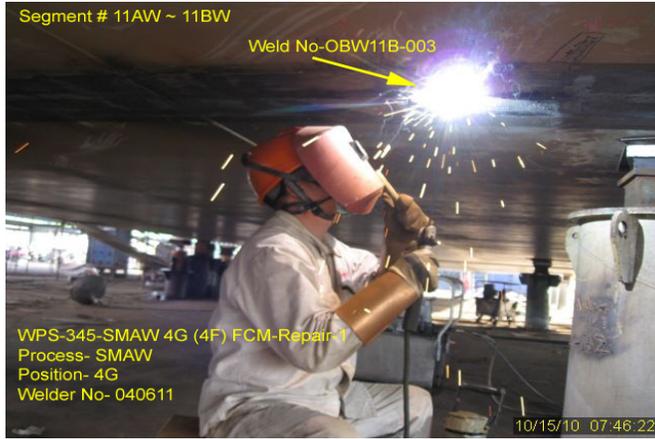
Segment # 11AE

This QA inspector observed ZPMC qualified welding personnel identified as 040265 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG064A-044; located On Orthotropic Box Girder (OBG) Bottom Plate to Bottom Plate Transverse CJP Weld. The Critical Welding Repair Report (CWRR) was B-C CWR2046. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM Repair-1.

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

WELDING INSPECTION REPORT

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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
