

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-019227**Date Inspected:** 09-Jan-2011**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 (Lift 11E)

This QA Inspector witnessed the final bolt tension verification on the catwalk handrails of lift 11East. 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 segment, panel point and bolt size designations were as follows:

11BE: (PP 98 to PP 99) - M16 X 95 – DHGM 160046

11DE: (PP 104 to PP 105) - M16 X 95 – DHGM 160046

OBG # TRIAL ASSEMBLY YARD (Lift 11W)

This QA Inspector witnessed the final bolt tension verification on the catwalk handrails of lift 11West. 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 bolt size designations were as follows:

11 AW to 11EW: (PP 95 to PP 108)

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M16 X 95 – DHGM 160046

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (11DE)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 11DE prior to the shipment of (Voyage 7) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 11DE (Panel Point 104 thru Panel point 106.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 11DE – PP 104.5, 105.5 and PP 106.5.
2. Corner Assembly – Crossbeam side of segment 11DE – PP 104, 105 and PP 106.
3. Longitudinal Diaphragm - Crossbeam side of segment 11DE – PP 104, 105 and PP 106.
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 11DE – PP 104, 105 and PP 106.
5. Sea fasteners- 11DE – PP 104, 105 and PP 106.
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 11DE – PP 104, 105 and PP 106.
7. Longitudinal Diaphragm – Bike path side of segment 11DE – PP 104, 105 and PP 106.
8. Corner Assembly – Bike path side of segment 11DE – PP 104, 105 and PP 106.
9. Truss post – Bike path side of segment 11DE – PP 104.5, 105.5 and PP 106.5.

OBG # TRIAL ASSEMBLY YARD (11EE)

This QA Inspector along with Mr. Manoj Prabhune photographed and documented at various locations on OBG 11EE prior to the shipment of (Voyage 7) en-route to Yerba Buena Island, California, USA. The following locations are where the photographs were taken and the photographs are available for review upon request.

OBG 11EE (Panel Point 107 thru Panel point 108.5) the following sequential members were photographed and documented:

1. Truss post – Crossbeam side of segment 11EE – PP 107.5 and PP 108.5.
2. Corner Assembly – Crossbeam side of segment 11EE – PP 107 and 108
3. Longitudinal Diaphragm - Crossbeam side of segment 11EE – PP 107 and 108
4. Chevron Diagonal members (upper and lower) - Crossbeam side of segment 11EE – PP 107 and 108
5. Sea fasteners- 11EE – PP 107 and 108
6. Chevron Diagonal members (upper and lower) – Bike path side of segment 11EE – PP 107 and 108
7. Longitudinal Diaphragm – Bike path side of segment 11EE – PP 107 and 108
8. Corner Assembly – Bike path side of segment 11EE – PP 107 and 108
9. Truss post – Bike path side of segment 11EE – PP 107.5 and PP 108.5.

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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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| Inspected By: | Manikandan,Murugan | Quality Assurance Inspector |
| Reviewed By: | Peterson,Art | QA Reviewer |
