

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-025628**Date Inspected:** 17-Jul-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:	N/A	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

DCP:

Paint Shop 1

This Quality Assurance (QA) Inspector witnessed final tension verification for Traveler Rails. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00694 Dated May 17, 2011

3007TR1-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3001TR1-001

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Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3007TR2-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3001TR2-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3009TR1-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3009TR2-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3003TR1-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

3003TR2-001

Bolt sizes used were M16 x 80 DHGM 160056 and final torque required was 180 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-022.

BAY 19

This QA Inspector performed a Flatness inspection on the Bike Path - BK23 the inspection was performed using a 1500 mm Straight Edge for Checking global deformation and a 600 mm Straight Edge for checking local deformation. The results of the inspection were recorded in a separate document and submitted to the CT QA Lead Inspector for review and disposition.

Trial Assembly Yard

NDT:

Segment 13AW

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

OBW13AA-005, 006, 007, 008, 009, 010

SEG3013AH- 172, 173, 174, 175

Segment 13AW

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This QA Inspector performed a Visual inspection and witnessed Magnetic Particle Testing inspection performed by the ABF QA MT Technicians.

SEG3013T- 113
SEG3013V- 095
DP3122-001-244, 243
DP3120-001-244, 243
SEG3013AH-184
SEG3013S-091
KP3015-001-003, 005, 007
KP3017-001-001, 003, 005

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

Summary of Conversations:

No significant 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 James Devey - 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
