

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-025632**Date Inspected:** 22-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:

Segment 13BW ~ 13CW

This Quality Assurance (QA) Inspector witnessed final tension verification for Deck Panel U-rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00703 Dated May 17, 2011

Bolt sizes used were M22 x 65 DHGM 220131 and final torque required was 360 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-676.

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Segment 13CW PP123, PP124

This Quality Assurance (QA) Inspector witnessed final tension verification for Deck Panel U-rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00703 Dated May 17, 2011

Bolt sizes used were M22 x 65 DHGM 220131 and final torque required was 360 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-676.

Segment 13BW ~13CW CB Side

This Quality Assurance (QA) Inspector witnessed final tension verification for Deck Panel U-rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00703 Dated May 17, 2011

Bolt sizes used were M22 x 65 DHGM 220131 and final torque required was 360 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-676.

Segment 13BW ~13CW PP 121, PP123, PP124 CB Side

This Quality Assurance (QA) Inspector witnessed final tension verification for Deck Panel U-rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00703 Dated May 17, 2011

Bolt sizes used were M22 x 65 DHGM 220131 and final torque required was 360 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-676.

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.

SA3183- 003, 004

SA3183- 002

SA3021- 001, 002

SA3021- 003

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SA3021- 004

Segment 13AW

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

SA3342-001, 003

SA3342-002, 004

SA3413-002, 004

SA3413-001, 003

SEG3013P- 033

SEG3013P- 025

OBW13- 007, 008, 009, 010, 011, 016, 017, 018, 019, 020, 021, 022,

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
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Reviewed By:	Peterson,Art	QA Reviewer
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