

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011455**Date Inspected:** 31-Dec-2009**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:** Mr. 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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu 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:

TRIAL ASSEMBLY AREA

This QA Inspector observed the following work in progress:

FCAW (Flux Cored Arc Welding) welding of weld joint 301 located on 6AW-SEG-027F. Welder is identified as 220069. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW (Flux Cored Arc Welding) welding of weld joint 302 located on 6AW-SEG-027F. Welder is identified as 220069. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (Lift 5 East)

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 5 East along with QA inspector (Manikandan) for smoothness. Below locations not complies with the ABF inspection report no: CWAHIR-5E-03 dated 30th Dec 2009. Those locations flush grinding and sharp edges

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

removal required. All these details noted and forwarded to team leader for further action.

Location E4 - Panel point 31(Facing East) - Floor beam to bottom panel cope hole

Location E4 - Panel point 31(Facing East) - Floor beam to side panel cope hole

Location E3 - Panel point 32(Facing East) - Floor beam to bottom panel cope hole

Location E3 - Panel point 32(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 32(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E4 - Panel point 33(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E3 - Panel point 35(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E4 - Panel point 35(Facing East) - Floor beam to bottom panel cope hole

Location E4 - Panel point 35(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 35(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

Location E3 - Panel point 36(Facing East) - Floor beam to bottom panel cope hole

Location E3 - Panel point 36(Facing East) - Floor beam to side panel cope hole

Location E4 - Panel point 36(Facing West) - Longitudinal diaphragm to bottom panel/floor beam cope hole

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

Summary of Conversations:

Only general conversation was held between QA and Quality Control (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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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