

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-011460**Date Inspected:** 02-Jan-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:** Mr. Li Yang / Mr. Wuzhicheng**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 002 located on 6BW-6CW. Welder is identified as 220067. ZPMC CWI is identified as Wuzhicheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-BT-2231T-1.

This QA Inspector observed the following work in progress:

FCAW (Flux Cored Arc Welding) welding of weld joint OBW6C-003 located on 6BW-6CW. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Zang Hai tao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-BT-2231T-1.

This QA Inspector observed the following work in progress:

SMAW (Shielded Metal Arc Welding) welding of weld joint OBW6F-003 located on 6AW. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Wang zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector observed the Heat straightening work has been performed for LD, Location between 6AW & 6BW PP#40.5 & PP#41. Against Record No: HSR1 (B) 7992 Rev: 0.

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
Reviewed By:	Miller, Mark	QA Reviewer
