

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-011823**Date Inspected:** 05-Feb-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:** Wuzhi Chang, 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:** 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:

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed T-Rib dimensional survey and recorded horizontal and vertical offset along with Caltrans QA inspector (Mr. Surendra Prabhu) for below segment. Reports forwarded to team leader for further action

7BE-7CE

This QA Inspector randomly observed the following work in progress:

Segment# 7BW-PP49

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 066261 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG035A-005; The Welding Repair Report (WRR) was B-WR10620.

ZPMC CWI identified as Mr. Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-345-FCAW-1G (1F)-FCM-Repair

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This QA inspector observed, ZPMC qualified welding personnel identified as 067275 perform Flux Core Arc Welding (FCAW), weld joint identified as SP429-001-023; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed, ZPMC qualified welding personnel identified as 066746 perform Flux Core Arc Welding (FCAW), weld joint identified as SP518-001-029; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed, ZPMC qualified welding personnel identified as 050316 perform Flux Core Arc Welding (FCAW), weld joint identified as BP089-001-031; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132

Segment#7AE-6CE

This QA inspector observed, Heat Straightening of weld joint identified as DP518-001
ZPM QC is identified as Wang Lai Yang. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8066.



Summary of Conversations:

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

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

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Reviewed By: Miller, Mark

QA Reviewer