

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-012167**Date Inspected:** 13-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:** 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:

This QA Inspector randomly observed the following work in progress:

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 066673 perform Flux Core Arc Welding (FCAW), weld joint identified as EP030-001-023; The Welding Repair Report (WRR) was B-WR9846. ZPMC QC is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-3G (3F)-FCM- Repair. See the below Photo.

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 066673 perform Flux Core Arc Welding (FCAW), weld joint identified as EP030-001-024; The Welding Repair Report (WRR) was B-WR9846. ZPMC QC is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-3G (3F)-FCM- Repair

Segment# 6CW-PP47

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector observed, Heat Straightening of weld joint identified as SEG031D ZPM QC is identified as Mr. Xia Chun Hui. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8121. See the below Photo.



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
Reviewed By:	Miller,Mark	QA Reviewer
