

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-012423**Date Inspected:** 06-Mar-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, Wu Chi Cheng**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

Segment: LIFT 7 East

This QA Inspector along with Caltrans QA Mr. Manjunath S. Math performed Individual Inspection for the Floor Beam Flange welded at Longitudinal Diaphragm for the Radius and Distance from the Flange to the Weld termination at E3 Location from Panel Point (PP) 48 to PP 55, East and West side of Floor Beam. Panel Point-52 & 55 Location East side Longitudinal Diaphragm Fit up balance.

This QA Inspector randomly observed the following work in progress:

Segment # Cross Beam-6

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD27-PP045-103; The Welding Repair Report (WRR) was B-WR10783. ZPMC QC is identified as Mr. Zhong Yong Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-4G (4F)-FCM-Repair-1. See the attached below Photo.

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Segment # 6BW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA013-002; The Welding Repair Report (WRR) was B-WR10749. ZPMC QC is identified as Mr.Zhong Yong Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. See the attached below Photo.

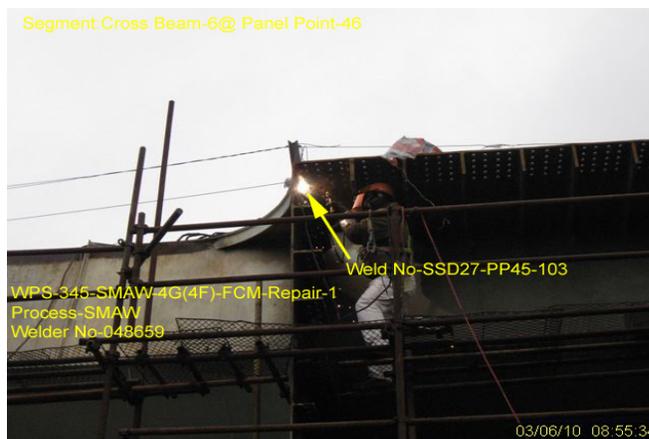
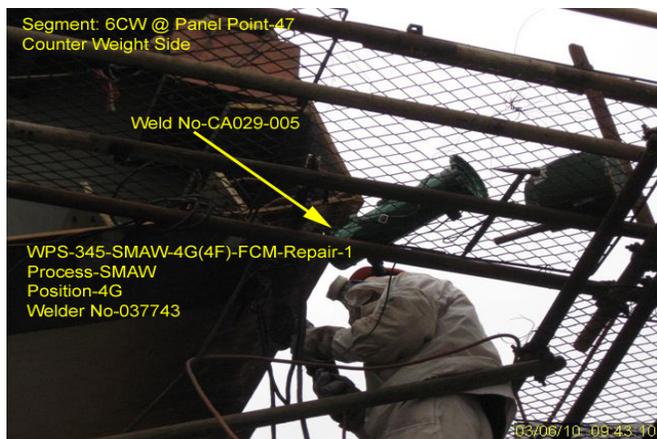
Segment # 6BW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA029-005; The Welding Repair Report (WRR) was B-WR10753. ZPMC QC is identified as Mr.Zhong Yong Gang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

Segment# 6AW-6BW

This QA inspector observed, Heat Straightening Perform ZPM QC is identified as Mr.Zhong Yong Gang. The variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) -8155.



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