

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-012696**Date Inspected:** 15-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#9AW (Lay Down Yard)**

This QA Inspector performed Inspection along with Mr. Surendra Prabhu for the Deck Panel Diaphragm offset at every alternative U - Ribs for Segment 9AW at Panel Point (PP) 72 and Panel Point (PP) 73 from North towards South side. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

Segment: 9AW (Lay Down Yard)

This QA Inspector along with Caltrans QA Mr. Surendra Prabhu performed Individual Inspection for the Flatness of Panels Segment 9AW between Panel Point (PP) 72 and PP73. The flatness deformation was measured only at locations which were suspected. The following location are not comply with the contract document. See the attached below Photo.

The segment 9AW at Panel Point (PP) 72 Looking West at Counter Weight Side

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The Deformation was measured to be approximately 18 mm in 2250 mm String line length.

The segment 9AW at Panel Point (PP) 72 Looking West at Cross Beam Side

The Deformation was measured to be approximately 19 mm in 2250 mm String line length.

The segment 9AW at Panel Point (PP) 73 Looking West at Cross Beam Side

The Deformation was measured to be approximately 16 mm in 2250 mm String line length.

The segment 9AW at Panel Point (PP) 73 Looking West at Counter Weight Side

The Deformation was measured to be approximately 24mm in 2250 mm String line length.

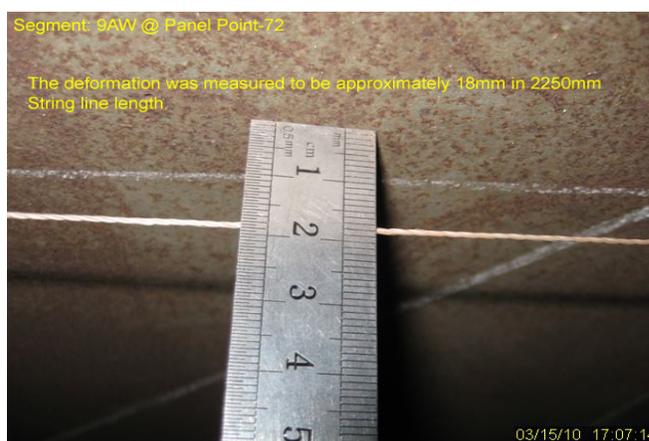
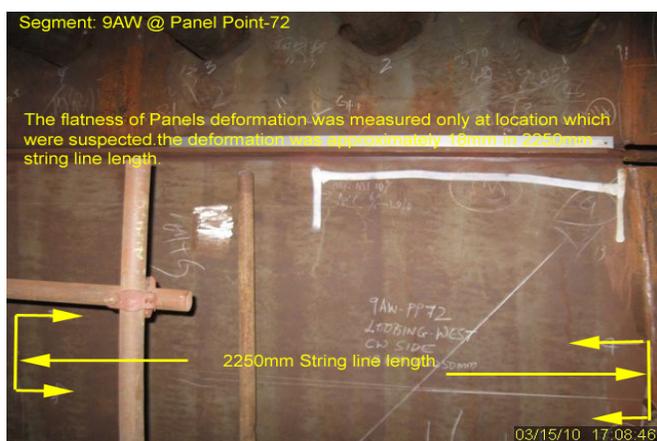
This QA Inspector randomly observed the following work in progress:

Segment# 7AE

This QA inspector observed, ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA034-006; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1. See the attached below Photo.

Segment# 7BE

This QA inspector observed, ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG036-049; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

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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
