

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-013716**Date Inspected:** 29-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 Jia**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:

Bay -5

This QA Inspector performed survey along with Mr. Manjunath Math for the Traveler Rails identified 10TR6-001. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

1. Rail Length
2. Rail Longitudinal Elevation
3. Thickness at Typical Section
4. Thickness at Sliding Connection
5. Flange Width at Typical Section
6. Flange Width at Sliding Connection
7. Web to Flange Offset
8. Depth Typical Section

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- 9. Depth Sliding Connection
- 10. Flange Tilt
- 11. Cut angle at sliding connection.

This QA Inspector randomly observed the following work in progress:

Bay -5

This QA inspector observed, ZPMC qualified welding personnel identified as 204342 perform Flux Core Arc Welding (FCAW), weld joint identified as TR1B-PP103-003, ZPMC QC identified as Mr. Wang Liang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-TC-U4C-F

Bay # 1

This QA inspector observed, ZPMC qualified welding personnel identified as 216872 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR1-046-007 (Traveler Rail) , ZPMC QC identified as Mr.Xiang Feng Feng .The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

Bay # 1

This QA inspector observed, ZPMC qualified welding personnel identified as 059450 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR2-048-013 (Traveler Rail) , ZPMC QC identified as Mr.Xiang Feng Feng .The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

Bay # 1

This QA inspector observed, ZPMC qualified welding personnel identified as 215397 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR1-029-003 (Traveler Rail) , ZPMC QC identified as Mr.Xiang Feng Feng .The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

Bay # 2

This QA inspector observed, ZPMC qualified welding personnel identified as 062708 perform Flux Core Arc Welding (FCAW), weld joint identified as FB3216-001-002 , ZPMC QC identified as Mr. Zhan Haifeng .The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2a-F-1

Summary of Conversations:

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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:	Patterson,Rodney	QA Reviewer
