

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-013091**Date Inspected:** 14-Apr-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:

OBG # TRIAL ASSEMBLY YARD

Segment 7BW to 6CW (Flatness) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the Flatness Panel's between Segment 7CW to 7EW between Panel Point (PP) 53 and PP 60 North (Counter Weight side) and South (Cross Beam side) for Deformation. Deformation was measured at 1500 mm Straight Edge. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment# 7AW-PP49

This QA inspector observed, ZPMC qualified welding personnel identified as 045280 perform

Flux Core Arc Welding (FCAW), weld joint identified as SEG033C-011, ZPMC QC identified as Mr. Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-B-T-2233-TC-U4b-F

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Segment # 7AW-PP49

This QA inspector observed, ZPMC qualified welding personnel identified as 222396 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD27-PP057-118, ZPMC QC identified as Mr.Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T

Segment # 7AW-PP49

This QA inspector observed, ZPMC qualified welding personnel identified as 220068 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD27-PP057-138, ZPMC QC identified as Mr.Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T

Segment # 7AW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG033A-004; The Critical Welding Repair Report (CWRR) was B-WR1404. ZPMC QC is identified as Mr.Cai Xiao Feng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. See the attached Below Photo.

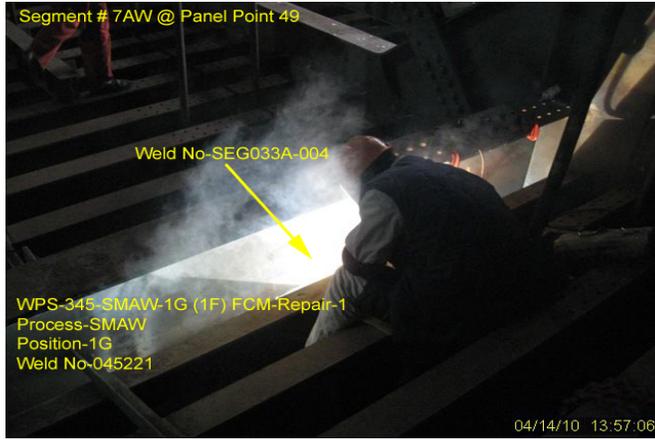
Segment # 7AW

This QA inspector observed, ZPMC qualified welding personnel identified as 045246 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP647-001-019; The Welding Repair Report (WRR) was B-WR10512. 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-3213-B-U3b. See the attached below Photo.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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