

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-013093**Date Inspected:** 10-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

This QA Inspector randomly observed the following work in progress:

Bike Path**Repair Welding.**

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BK001-025-009; The Welding Repair Report (WRR) was B-WR11836. ZPMC QC is identified as Mr. Zhang Hai Tao. 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# 7CE~7DE

This QA inspector observed, ZPMC qualified welding personnel identified as 220069 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE7A-007, ZPMC CWI identified as Mr. LI Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T

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Segment # 7DE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 048047 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck panel to Edge plate E2 Location, weld joint identified as CA042-004; The Critical Welding Repair Report (CWRR) was B-CWR1378. ZPMC QC is identified as Mr. 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 Photo.

Segment # 7DW

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW) for weld connecting Deck panel to Edge plate W2 Location, weld joint identified as CA043-004; The Critical Welding Repair Report (CWRR) was B-CWR1377. ZPMC QC is identified as Mr. Wang Xiang Pin. 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 Photo.

Segment# 7CE ~ 7DE

This QA inspector observed, ZPMC qualified welding personnel identified as 053748 perform Submerged Arc Welding (SAW), weld joint identified as OBE7A-009, ZPMC CWI 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-223(2) T-2. See the attached 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.

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Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
