

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-013332**Date Inspected:** 04-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:	Xu Xian Ping	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:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

BAY 1:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report (WRR) #B-WR11464 (for UT Reject) of 20TR1-001; weld number 003. Welder is identified as 216575. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

BAY 2:

Submerged Arc Welding (SAW) of FB3185-001; weld number 004. Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Zhu Lin. Weld Procedure Specification (WPS) is identified as WPS-B-T-2221-L2c-S-2. Welding appears to conform to the requirements of the WPS used.

Submerged Arc Welding (SAW) of FB3185-001; weld number 006. Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Zhu Lin. Weld Procedure Specification (WPS) is identified as

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WPS-B-T-2221-L2c-S-2. Welding appears to conform to the requirements of the WPS used.

BAY 5:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1283 (for Buttering) of 11TR3-001, 11TR3-004 and 11TR2-003. Welders are identified as 215689 and 053486. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1283 (for Buttering) of 10TR1-029. Welder is identified as 053486. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1283 (for Buttering) of 11TR1-008. Welder is identified as 215689. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) of TR1E-PP104; Weld 009. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2232-TC-U4c-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of TR1A-PP101; Weld 001. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Shen Jian Guo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2232-TC-U4c-F. Welding appears to conform to the requirements of the WPS used.

BAY 6:

Shielded Metal Arc Welding (SMAW) of WJF-0; Weld number(s) 309, 330, and 323. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Shu Yang Hua. Weld Procedure Specification (WPS) is identified as WPS-B-T-3112-1. Welding appears to conform to the requirements of the WPS used.

Shielded Metal Arc Welding (SMAW) of WJF-0; Weld number(s) 394, 381, and 380. Welder is identified as 048800. ZPMC Quality Control (QC) is identified as Shu Yang Hua. Weld Procedure Specification (WPS) is identified as WPS-B-T-3112-1. Welding appears to conform to the requirements of the WPS used.

BAY 7:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1100 (for Buttering) of 11TR3-017. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

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Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1100 (for Buttering) of 11TR3-021. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) #BCWR-1100 (for Buttering) of 10TR3-026. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report (WRR) #BWRR-11192 (for UT Reject) of 10TR2-007; weld number 014. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
