

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-014286**Date Inspected:** 15-May-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:** Wu Zhi 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 Inspector (QA) Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (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

Notification No: 005740 (Segment # 7BE)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

1. OBE7B-011, 012, 013, 022, 023, 024, 025, 026, 027, 032, 033, 034

Segment # 8BW ~ 8CW

This QA inspector observed ZPMC qualified welding personnel identified as 037840 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW8C-003 and was observed welding in the 4G (Overhead) position; 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-B-P-2214-B-U2-FCM-1. See the attached Photo.

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Segment # 8AW-PP63

This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD25-PP063-056 and was observed welding in the 1G (Flat) position; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 8AW-PP63

This QA inspector observed ZPMC qualified welding personnel identified as 066401 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SSD25-PP063-033 and was observed welding in the 3G (Vertical) position; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2113.

Segment # 8CE –PP68

This QA inspector observed ZPMC personnel Performing Snug Tightening for Lower Chevron Angle (Bike Path side) at Panel Point (PP) 68. This QA Inspector observed ZPMC used Manual Torque Wrench. See the attached Photo.

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



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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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