

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-014898**Date Inspected:** 07-Jun-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 6:

Submerged Arc Welding (SAW) of WJF-0; Weld number(s) 199. Welder is identified as 054458. ZPMC Quality Control (QC) is identified as Shu Yang Hua. Weld Procedure Specification (WPS) is identified as WPS-B-T-3221-TC-U4b-S-1. Welding appears to conform to the requirements of the WPS used.

Submerged Arc Welding (SAW) of WJF-0; Weld number(s) 197. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Shu Yang Hua. Weld Procedure Specification (WPS) is identified as WPS-B-T-3221-TC-U4b-S-1. Welding appears to conform to the requirements of the WPS used.

BAY 7:

Flux Cored Arc Welding (FCAW) of DP3072-001; weld(s) 025, 026, 077, 078. Welder(s) are identified as 062447. ZPMC Quality Control (QC) is identified as Xia Yong Zheng. Weld Procedure Specification (WPS) is identified as WPS-B-T-4132. Welding appears to conform to the requirements of the WPS used.

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Shielded Metal Arc Welding (SMAW) tack welding of DP3070-001; weld(s) 003, 004, 011, 012, 019, 020, 027, 028. Welder(s) are identified as 250833. ZPMC Quality Control (QC) is identified as Cui Jun Jei. Weld Procedure Specification (WPS) is identified as WPS-B-P-2112-FCM. Welding appears to conform to the requirements of the WPS used.

Shielded Metal Arc Welding (SMAW) tack welding of DP3048-001; weld(s) 013~024. Welder(s) are identified as 215259. ZPMC Quality Control (QC) is identified as Cui Jun Jei. Weld Procedure Specification (WPS) is identified as WPS-B-P-2112-FCM. Welding appears to conform to the requirements of the WPS used.

Shielded Metal Arc Welding (SMAW) tack welding of DP3035-001; weld(s) 037~048. Welder(s) are identified as 203204. ZPMC Quality Control (QC) is identified as Cui Jun Jei. Weld Procedure Specification (WPS) is identified as WPS-B-P-2112-FCM. Welding appears to conform to the requirements of the WPS 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
