

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-014978**Date Inspected:** 12-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:** Wu Zhi Chang**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:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment 8BE to 8CE (T-Ribs after Bolting) Caltrans QA Survey Inspection

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Individual Inspection for the T-Ribs to T-Ribs between Segment 8BE to 8CE (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 North (Counter Weight Side total 19 Nos. T-Ribs) and South (Cross Beam side Total 19 Nos. T-Ribs) and at Bottom Panel (Total 18 Nos. T-Ribs) for Horizontal and Vertical Offset. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment # Cross Beam 9

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 069841 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB202A-018 and was observed welding in the 2G (Horizontal)

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position;The Welding Repair Report (WRR) was B-WR13530. ZPMC CWI is identified as Mr. Li Jia. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1

Segment# 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 220066 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD029-PP71.5-251 and was observed welding in the 3G (Vertical) position; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-B-U2-F. See the attached below Photo.

Segment# 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 069841 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SS159-001-032 and was observed welding in the 2G (Horizontal) position; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1. See the attached below Photo.

Segment# 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 045240 perform Flux Core Arc Welding (FCAW), weld joint identified as SS133-001-010 and was observed welding in the 2G (Horizontal) position; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

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



Summary of Conversations:

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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:	Patterson,Rodney	QA Reviewer
