

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020778**Date Inspected:** 09-Jul-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:** Mr. Huang Min .**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 Subassembly(Bays 5-8)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 observed the following work in progress:

Bay 8

Shielded Metal Arc Welding (SMAW) welding of weld joint CB3001A-017-020. Welding Repair Report(WR)B-WR-13939, Welder is identified as 045148. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-Repair.

Flux Cored Arc Welding(FCAW) of the weld joint CB3001G-053-184/185, Welder is identified as 054460/054459. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

FCAW Welding of the weld joint CB3001G-054-184/185. Welder is identified as 054460/054459. ZPMC Quality Control (QC) is identified as Mr. Li Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

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FCAW Welding of the weld joint CB3001G-055-184/185. Welder is identified as 054460/054459. ZPMC Quality Control (QC) is identified as Mr. Li Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

Bay 7

FCAW Welding of the weld joint DP3041A-001,012. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW Welding of the weld joint EP3013-001-67/68,71/72,75/76,79/80,83/84. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW Welding of the weld joint DP3097-001-065,050,035,091. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

FCAW Welding of the weld joint DP3097-001-020,005,080. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F

Bay 6

FCAW Welding of the weld joint WJF-0-24,105 Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Shu Yang hua. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3311-TC- P4.

During Surveillance inspection found Fit up for the Weld no.DP3108-001-080/082,Was having 7.5mm Gap and As per drawing that weld is having fillet weld and ZPMC shall change that groove and make CJP. And carry out NDT as CJP Weld, And detail as shown below picture.

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

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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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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