

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-016062**Date Inspected:** 05-Aug-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:** Zhu Zhong Hai**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar 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. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG LIFT 9 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing Shielded Metal Arc Welding process for weld 004 located on PCMK OBW9K. ZPMC QC Mr. Zhou peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-fcm.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044551 performing Shielded Metal Arc Welding process for weld 019 located on PCMK DP686-001. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-u3b.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066239 performing Flux Cored Arc Welding process for weld 003 located on PCMK OBW9C. ZPMC QC Mr. Shi Lei was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045268 performing Shielded Metal Arc Welding process for weld 045 located on PCMK SEG051A. ZPMC QC Mr. Zhu Zhong Hai was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair. Critical weld repair report identified as B-CWR1722.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067904 performing Shielded Metal Arc Welding process for weld 012 located on PCMK SEG049A. ZPMC QC Mr. Zhu Zhong Hai was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair. Critical weld repair report identified as B-CWR1722.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067764 performing Shielded Metal Arc Welding process for weld 001 located on PCMK CA062. ZPMC QC Mr. Zhu Zhong Hai was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-FCM.

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



Summary of Conversations:

No significant conversations were reported on this date.

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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer