

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016141**Date Inspected:** 08-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:** Li Yang**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 Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

This QA received ZPMC inspection notification sheet 06357 to perform Magnetic Particle Testing (MT) of Punch List Item as below all the details.

- 1) Punch List No. 341: Temporary attachments removed at the Piece Mark as FB14A & BP 181A. from the 9DE panel point.82
- 2) Punch List No. 335: Damage due to handling distortion area Piece Mark as U-rib RS21D & Deck Panel (DP) 338. Transverse Splice weld OBE9-003.
- 3) Punch List 337: Distortion area Piece mark of affected member is as LD17C (X40C)
- 4) Punch List 343: Temporary attachments removed at the Piece Mark as BP 125A.

Segment # 9EW ~ 10AW

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This QA performed a joint survey dimensional inspection of Root Gap & Offset on segment 9EW~10AW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math. Measurements of the Root Gap & Offset were taken from PP85 to PP86. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Transverse Segment Splice Root Gap & Offset". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9AE

This QA performed a joint survey dimensional inspection of corner assembly Side Plate to Side plate Longitudinal Weld Flatness on segment 9AE. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math; Measurements of the Flatness were taken from PP71.25 to PP73. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly SP-SP & DP-DP Flatness". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9DW ~ 9EW

This QA inspector observed, ZPMC qualified welding personnel identified as 067609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9C-007; ZPMC CWI is identified as Mr.Zhu Zhong Hai. 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.

Segment # 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG053A-011; ZPMC CWI is identified as Mr.Zhu Zhong Hai. 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.

Segment # 9DW

This QA inspector observed, ZPMC qualified welding personnel identified as 037932 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG055A-045; ZPMC CWI is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Segment # 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 040609 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG053C-009; ZPMC CWI is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2233-TC-U4b-FCM-1.

Segment # 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 046706 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG053B-024; ZPMC CWI is identified as Mr.Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2233-TC-U4b-FCM-1.

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

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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.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
