

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-016717**Date Inspected:** 23-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:** 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 # 9AW ~ 9BW

This Quality Assurance (QA) received ZPMC inspection notification sheet 00458 to perform final tension verification for U-Rib to U-Rib at Panel Point (PP) 73 and PP 74 for Segment 9AW~9BW. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used were M22 x 70 DHGM220027 and final torque required was 450 N-m.

Bolt sizes used were M22 x 85 DHGM220111 and final torque required was 340 N-m.

Manual Torque wrench was been used with Sr. No. XO2-676

Segment # 10AW ~ 10BW

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This QA inspector observed, ZPMC qualified welding personnel identified as 067589 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10B-003; ZPMC QC is identified as Mr. Zhong Guo 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 # 10BW

This QA inspector observed, ZPMC qualified welding personnel identified as 067829 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG061A-014; ZPMC QC is identified as Mr. Zhong Guo 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 # 9BW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG051A-045; The Welding Repair Report (WRR) was B-WR14700. ZPMC QC is identified as Mr. Zhu Guo Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 4G (4F) FCM-Repair-1. See the attached below photo.

Segment # 9BW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 202384 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG053B-024; The Welding Repair Report (WRR) was B-WR14568. ZPMC QC is identified as Mr. Zhu Guo Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW- 3G (3F) Repair.

Segment # 9DW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as EP129-001-027; The Welding Repair Report (WRR) was B-WR14680. ZPMC QC is identified as Mr. Zhu Yuan Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW 4G (4F) Repair. See the attached below photo.

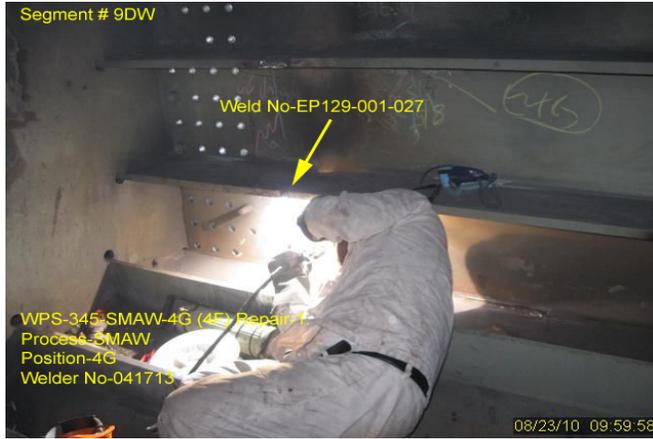
Segment # 9BW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on Bottom plate in OBG segment 9BW at panel point 74. ZPMC QC is identified as Mr. Zhong Guo Hai the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9173.

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