

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017207**Date Inspected:** 26-Sep-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:	Xu Xian Ping	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 date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 066179 perform Shielded Metal Arc Welding (SMAW) Process on weld joint WJF-0-057. ZPMC Quality Control Personnel (QC) identified as Mr. Huang Min was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3311-TC-P4.

This QA observed ZPMC qualified welding personnel identified as 066481 perform Shielded Metal Arc Welding (SMAW) Process on weld joint WJF-0-062. ZPMC Quality Control Personnel (QC) identified as Mr. Huang Min was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3311-TC-P4.

This QA observed ZPMC qualified welding personnel identified as 053748 perform Submerged Arc Welding (SAW) Process on weld joint CB3003C-019-004. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng zhi wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

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OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 217185 perform Flux Cored Arc Welding (FCAW) Process on weld joint SA3077-009-001. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2331-C-P2-F-2.

This QA observed ZPMC qualified welding personnel identified as 062447 perform Flux Cored Arc Welding (FCAW) Process on weld joint SP3150-001-009,010,021,022. ZPMC Quality Control Personnel (QC) identified as Mr. Wang Liang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

OBG # BAY 8

This QA observed ZPMC qualified welding personnel identified as 067947 / 067184 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A1-058-043. ZPMC Quality Control Personnel (QC) identified as Mr. Feng Ya Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4C-F.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer