

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018207**Date Inspected:** 14-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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 Subassemblies**Summary of Items Observed:**

On this day CALTRANS Office of Structural Materials (OSM) Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG BAY 6

This QA observed ZPMC qualified welding personnel identified as 066471 perform Flux Cored Arc Welding (FCAW) on crossbeam CB18. The weld joint is identified as CB3002A-018-030. ZPMC QC Mr. Zhang 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-2232-TC-U5-F.

This QA observed ZPMC qualified welding personnel identified as 215960 perform Submerged Arc Welding (SAW) on crossbeam CB19. The weld joint is identified as CB3003E-019-002. ZPMC QC Mr. Shu Yang Hua 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.

This QA observed ZPMC qualified welding personnel identified as 215083 perform Shielded Metal Arc Welding (SMAW) on floor beam. The weld joint is identified as FB3169-002-039. ZPMC QC Mr. Shu Yang Hua 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-P-2213-B-U3b.

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OBG BAY 7

This QA observed ZPMC qualified welding personnel identified as 053748 perform Submerged Arc Welding (SAW) on Crossbeam CB19. The weld joints are identified as CB3003B-019-003. ZPMC QC Mr. Xu Hai Yang 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.

OBG BAY 8

This QA observed ZPMC qualified welding personnel identified as 054459 perform FCAW on bike path. The weld joint is identified as BK004A3-064-025. ZPMC QC Mr. Liu Fa Wen 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.

This QA observed ZPMC qualified welding personnel identified as 500405 perform FCAW on bike path. The weld joint is identified as BK004A5-064-022. ZPMC QC Mr. Liu Fa Wen 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.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract 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 (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
