

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-019530**Date Inspected:** 26-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**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 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:

Bay 10 (OBG Traveler Rail)

WELDING:

This QA Inspector observed ZPMC qualified welding personnel identified as 044473 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR2-030-009; located On Orthotropic Box Girder (OBG) Traveler rail CJP Weld; The Critical Welding Repair Report (WRR) was B-WR14292. ZPMC Quality Control (QC) is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with applicable WPS-345-FCAW-1G (1F) ESAB-Repair. See attached photo for further details.

This QA Inspector observed ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR2-030-015; located On Orthotropic Box Girder (OBG) Traveler

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rail CJP Weld; The Critical Welding Repair Report (WRR) was B-WR14294. ZPMC Quality Control (QC) is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with applicable WPS-345-FCAW-1G (1F) ESAB-Repair. See attached photo for further details.

This QA Inspector observed ZPMC qualified welding personnel identified as 040434 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR2-030-013; located On Orthotropic Box Girder (OBG) Traveler rail CJP Weld; The Critical Welding Repair Report (WRR) was B-WR14293. ZPMC Quality Control (QC) is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with applicable WPS-345-FCAW-1G (1F) ESAB-Repair

This QA Inspector observed ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as 20TR2-030-017; located On Orthotropic Box Girder (OBG) Traveler rail CJP Weld; The Critical Welding Repair Report (WRR) was B-WR14295. ZPMC Quality Control (QC) is identified as Mr. Li Jun. The welding variables recorded by QC appeared to comply with applicable WPS-345-FCAW-1G (1F) ESAB-Repair.

OBG TRIAL ASSEMBLY YARD

HEAT STRAIGHTENING:

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as upper floor beam flange and floor beam in OBG segment 12AE at Panel Point 111. Distortion appeared to be caused by Welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Zhu was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B) 9784.

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



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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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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