

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-022130**Date Inspected:** 21-Mar-2011**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:** Zho 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

WELDING:**Segment 12BW**

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), Temporary attachments remove (Base Metal Repair) ; located On Orthotropic Box Girder (OBG) Longitudinal Diaphragm ; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding The Critical Welding Repair Report (CWRR) was B-CWR2130. ZPMC Quality Control (QC) Mr. Zhou Peng was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-3G (3F) FCM-Repair-1. See attached photo for further details.

Segment 13AE

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This QA Inspector observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3076-001-015; located On Orthotropic Box Girder (OBG) X3341A to X3325A CJP Weld ; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding .The Welding Repair Report (WRR) was B-WR20471 Rev-0. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-3G (3F) FCM-Repair-1. See attached photo for further details.

This QA Inspector observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3007R-001; located On Orthotropic Box Girder (OBG) DP3072A to DP3072 CJP Weld ; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20472 Rev-0. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-3G (3F) FCM-Repair-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3007K-001; located On Orthotropic Box Girder (OBG) DP3073A to DP3074A CJP Weld ; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20472 Rev-0. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-3G (3F) FCM-Repair-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066418 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3007K-001; located On Orthotropic Box Girder (OBG) SA3019B to FB3127A CJP Weld ; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2213-TC-U4b-FCM-1.

Segment 12AE

This QA Inspector observed ZPMC personnel performing final rotation of nut using pneumatic wrench between Panel Point 112 to Panel Point 112.5 for Corner Assembly.

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
Reviewed By:	Peterson,Art	QA Reviewer
