

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-024106**Date Inspected:** 27-May-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:** 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**WELDING:****Segment 14 West**

This QA Inspector observed ZPMC qualified welding personnel identified as 068596 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3020AG-001 ; located On Orthotropic Box Girder (OBG) Edge Plate to Deck Plate CJP Weld; 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. 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-B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

Cross Beam 18

This QA Inspector observed ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc

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Welding (SMAW), weld joint identified as CB3002A-018-021 ; located On Orthotropic Box Girder (OBG) Side Plate to Top Plate Hold Back CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Li Yang. 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-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

Cross Beam 18

This QA Inspector observed ZPMC qualified welding personnel identified as 066258 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CB3002A-018-001 ; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Li Yang. 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. Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2212-TC-U4b-FCM-1.

Segment 14 East

This QA Inspector observed ZPMC qualified welding personnel identified as 037723 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3019AH-002 ; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. 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-WR21107. ZPMC Quality Control (QC) Mr. Zhu Yuan Yuan was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G(4F) FCM-Repair-1.

Segment 14 East

This QA Inspector observed ZPMC qualified welding personnel identified as 066418 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3019J-138 ; located On Orthotropic Box Girder (OBG) RS3258AY to FB3279A CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. 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-WR21029. ZPMC Quality Control (QC) Mr. Zhu Yuan Yuan 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.

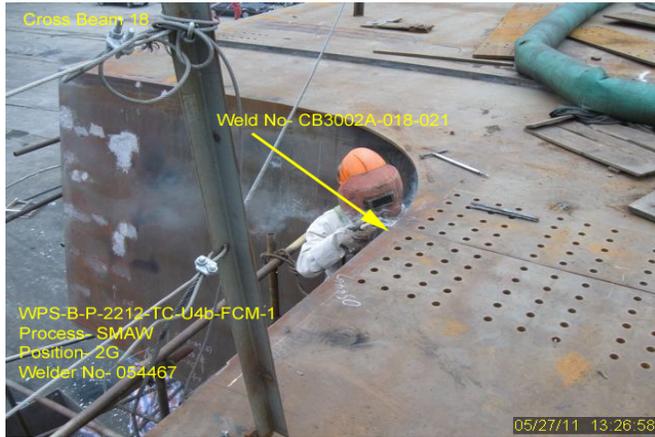
Segment 14 East

This QA Inspector observed ZPMC qualified welding personnel identified as 067656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG30AH-003 ; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Yuan Yuan. 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-WR21107. ZPMC Quality Control (QC) Mr. Zhu Yuan Yuan was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G(4F) FCM-Repair-1.

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 James Devey - 15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer