

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010647**Date Inspected:** 07-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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:** OBG/ TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar 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:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067947 performing Flux Cored Arc Welding process for the weld OBE6C-006 located on PCMK side panel splice weld (bike path side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for the weld OBE6C-005 located on PCMK side panel splice weld (bike path side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG SEGMENT 6 WEST

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220063 performing Flux Cored Arc Welding process for the weld OBW6B-003 located on PCMK bottom panel splice weld between OBG segment 6AW and 6BW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2A-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for the weld OBE6B-004 located on PCMK side panel splice weld (cross beam side) between OBG segment 6AW and 6BW. ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

OBG SEGMENT 5 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for the weld EP038-001-014 located on PCMK OBG segment 5East. ZPMC QC Mr. Zhang Xiao Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) FCM-Repair. The weld repair report identified as B-WR8426

BAY # 11

This QA Inspector randomly observed the following work in progress.

WEST TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040736 performing Flux Cored Arc Welding process for the weld WSTL4-2F/L-98 located on PCMK West tower lift 4. ZPMC QC Mr. Shao Hai Lang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049541 performing Flux Cored Arc Welding process for the weld WSTL4-2J/L-99 located on PCMK West tower lift 4. ZPMC QC Mr. Shao Hai Lang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

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

Summary of Conversations:

No relevant conversations.

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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer