

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-012011**Date Inspected:** 11-Feb-2010**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:** 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:

Segment# 7BW-PP52

This QA inspector observed, ZPMC qualified welding personnel identified as 068917 perform Shielded Metal Arc Welding (SMAW); weld joint identified as CA035-006, ZPMC CWI is identified as Mr. Li Yang

The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1. See the attached photo.

Segment# 5CE-PP36**Repair Welding.**

This QA inspector observed, ZPMC qualified welding personnel identified as 0220066 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG026A-008; The Critical Welding Repair Report (CWRR) was B-CWR1201. ZPMC CWI identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-345-FCAW-1G (1F)-FCM-Repair-1

WELDING INSPECTION REPORT

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This QA inspector observed, ZPMC perform Corner assembly cross brace snug tightening on following location in-progress. See the attached photo.

6BE-PP42

This QA Inspector observed ZPMC personnel performing Heat Straightening on weld joint no: SEG026A. The weld is connecting to Side plate (SP306A) and Side plate (SP425A) plate thickness is 18 mm. Against Caltrans Engineer approved document No: HSR (B)-353.Rev 0



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 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:	Miller,Mark	QA Reviewer
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