

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-012697**Date Inspected:** 14-Mar-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, Wu Chi Cheng**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:

OBG # TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress:

This QA Inspector performed Inspection along with Mr. Manunath Math for the Deck Panel Diaphragm to Deck Panel offset at every alternative U - Ribs for Segment 7CW at Panel Point (PP) 53 and Segment 7BW at Panel Point (PP) 52 from North towards South side. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

Segment# 7AE-7BE

This QA inspector observed, ZPMC qualified welding personnel identified as 062092 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP461-001-031; ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1. See the attached below Photo.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment# 7BE-7CE

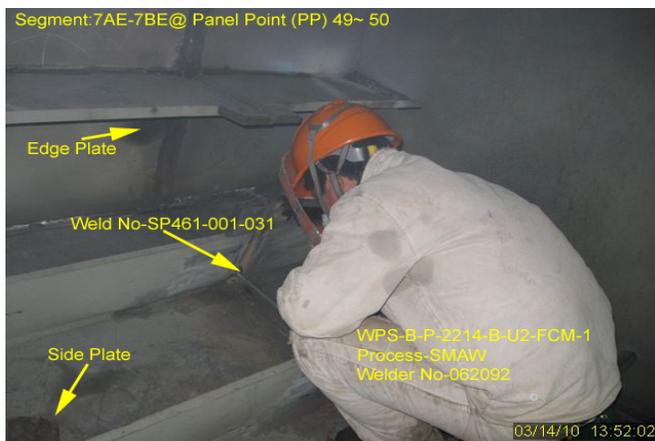
This QA Inspector observed ZPMC personnel's performing at Segment 7BE and 7CE Panel point (PP) 52~53 Transverse Splice weld Flush Grinding is in progress. See the attached below photo.

Segment# 7AE

During in process visual inspection of 7AE , This QA Inspector observed ABF personnel, identified as Mr. Lee, performing Ultrasonic Testing (UT) of the Weld connecting side panel to Bottom panel at E4 location for more comprehensive information refer the attached Photo.

Segment# 7BE

During in process visual inspection of 7BE , This QA Inspector observed ZPMC Quality Control (QC) personnel performing Magnetic Particle testing (MT) ZPMC Technician identified as Mr. Zhang Xu, of the Weld connecting Deck Plate to Edge Plate at E1 location for UT rejected area for more comprehensive information refer the attached Photo.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
Reviewed By:	Miller,Mark	QA Reviewer
