

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-013129**Date Inspected:** 05-Apr-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 and Wu Zhi 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:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 7W

This QA Inspector observed ZPMC welding personnel performing welding for weld joint CA031-004 located on PMCK W2 Location, Deck Panel connected to Edge Panel. Welder is identified as 045196 and 045196. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Segment 7CW

This QA Inspector observed ZPMC welding personnel performing welding for weld joint CA038-004. Welder is identified as 045221 located on PMCK Deck Panel to Edge Panel Cross Beam side. The ZPMC QC was identified as Mr. Zhang Ziang. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-B-P-2214-Tc-U4b-FCM-1. Welding was performed against B-CWR – 1228.

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Segment 7BW

This QA Inspector observed ZPMC welding personnel performing welding for weld joint Seg 036-047/048. Welder is identified as 048659 located on PMCK Deck Panel to Edge Panel at E5 location. The ZPMC QC was identified as Mr. Wang Li Yang. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair-1. Welding was performed against B-CWR – 1325.

Segment 7CE

This QA Inspector observed ZPMC welding personnel performing welding for weld joint CA040-002. Welder is identified as 054467 located on PMCK Deck Panel to Edge Panel at E2 location. The ZPMC QC was identified as Mr. Wang Li Yang. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair-1. Welding was performed against B-CWR – 1227.

Segment 7EE

This QA Inspector observed ZPMC welding personnel performing welding for weld joint CA045-004 Welder is identified as 066258 located on PMCK Deck Panel to Edge Panel at Cross Beam Side at working point 5. The ZPMC QC was identified as Mr. Wang Li Yang. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-B-P-2214-Tc-U4b-FCM-1.

Segment 7BW to 7CW

This QA Inspector observed ZPMC Heat Straightening personnel's performing Heat Straightening at Side Panel T-Ribs Cross Beam side for Segment 7BW to 7CW between Panel Point (PP) 52 and PP 53. Heat Straightening been performed against the Report no. HSR1(B)-8235 Rev. 0 Dated March 21, 2010. Please refer the pictures attached below for more comprehensive details.

Segment 7AW and 7BW

This QA Inspector verified and measured the flatness for the Lower Chevron for Segment 7AW and 7BW from Panel Point (PP) 48 to 52 except at PP 49 Cross Beam Side as ZPMC is not ready for inspection. Please refer the pictures attached below for more comprehensive details.

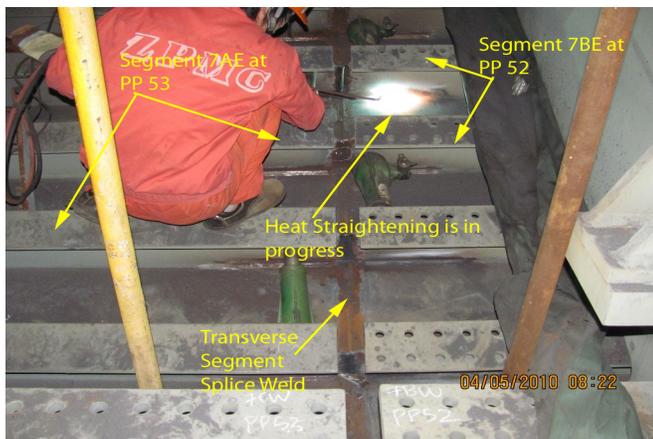
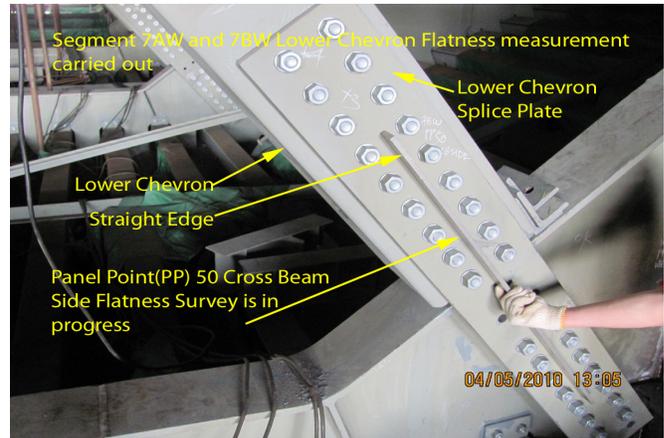
Segment 7AW and 7BW

This QA Inspector observed ZPMC personnel's installing ASTM A-325 Bolts at upper chevron at PP 49, PP 50 and PP 51 north and south side.

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

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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 T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer