

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-013575**Date Inspected:** 26-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:** Xu Xian Ping**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:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

This inspector performed In- Process inspections of welder training deck panels in Bay 9. Welding was being performed on panel MU2-001, welds 001~020. The weld procedure was found to be WPS-B-T-2342-U1-(U-rib)-4. The welding operators were identified as follows:

Weld 1 and 11- Xiang Huanfeng 059416

Weld 2 and 12- Jaing Ting Guang 062265

Weld 3 and 13- Zhang Liping- 201840

Weld 4 and 14- Song Yinshu- 059421

Weld 5 and 15- Jaing Shuang Chen- 201788

Weld 6 and 16- Yang Yong Zeng- 059418

Weld 7 and 17- Xu Guo Yin- 059443

Weld 8 and 18- Xiang Jie- 059378

Weld 9 and 19- Hang Changhou- 059464

Weld 10 and 20- Feng Chuanhong- 059371

ZPMC and ABF QC were present during the welding process and identified as Zhang Qiao and Huang Wen Guang respectively. The ZPMC CWI was present during the welding process and identified as Sun Bo.

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During the welding process, the welding parameters were verified by this inspector and were as follows:

Head 1, Weld 1- 351 Amps, 30.5 Volts, and 530mm/ minute travel speed
Head 2, Weld 2- 355 Amps, 30.5 Volts, and 530mm/ minute travel speed
Head 3, Weld 5- 356 Amps, 30.8 Volts, and 530mm/ minute travel speed
Head 4, Weld 6- 362 Amps, 30.3 Volts, and 530mm/ minute travel speed
Head 5, Weld 9- 360 Amps, 30.0 Volts, and 530mm/ minute travel speed
Head 6, Weld 10- 353 Amps, 30.0 Volts, and 530mm/ minute travel speed
Head 1, Weld 3- 370 Amps, 31.0 Volts, and 530mm/ minute travel speed
Head 2, Weld 4- 359 Amps, 30.8 Volts, and 530mm/ minute travel speed
Head 1, Weld 1- 380 Amps, 31.0 Volts, and 530mm/ minute travel speed
Head 1, Weld 1- 371 Amps, 30.8 Volts, and 530mm/ minute travel speed

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
