

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014005**Date Inspected:** 31-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 Jia			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:

Bay -5

This QA Inspector performed survey along with Mr. Manjunath Math for the Traveler Rails below mentioned all the details. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

10 TR1-020, 10TR3-017, 10TR1-024, 10TR3-035, 11 TR5-008, 11TR1-030, 10TR6-002, 11TR1-024, 11TR6-002,

This QA Inspector randomly observed the following work in progress:

Bay -5

This QA inspector observed, ZPMC qualified welding personnel identified as 204342 perform

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Flux Core Arc Welding (FCAW), weld joint identified as TR6C-PP106-005, ZPMC QC identified as Mr. Shen Jian Guo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4C-F

Bay # 5

Repair Welding.

This QA inspector observed ZPMC qualified welding personnel identified as 203710 perform Flux Core Arc Welding (FCAW), weld joint identified as 10TR3-028; The Critical Welding Repair Report (CWRR) was B-CWR1283. ZPMC QC is identified as Mr. Shen Jian Guo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair-1.

Bay # 5

Repair Welding.

This QA inspector observed ZPMC qualified welding personnel identified as 203710 perform Flux Core Arc Welding (FCAW), weld joint identified as 11TR3-026; The Critical Welding Repair Report (CWRR) was B-CWR1283. ZPMC QC is identified as Mr. Shen Jian Guo. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW- 1G (1F) Repair-1.

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

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
Reviewed By:	Patterson,Rodney	QA Reviewer
