

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-014011**Date Inspected:** 21-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**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

Segment: LIFT 7 West

This QA inspector performed Magnetic Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

7BW~7CW "T" Rib & "I" Rib Holdbacks Area

Nondestructive testing (NDT) notification No. 005570

Weld No# BP090-001-045~052, BP090-001-033-040, SP152-001-025 ~032, SP153-001-001~008, SP098-001-031~036, SP099-001-003~008, DP639-001-013~018, DP640-001-007~012

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Segment 7DE to 7EE (“T” Rib) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the WT Stiffener Offset between Segment 7DE to 7EE between Panel Point (PP) 57 and PP 58 North(Bike Path side) and South (Cross Beam side) for WT Stiffener Offset. Offset was measured at 1000 mm Straight Edge. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 7BW to 6CW (Flatness) Joint Survey

This QA Inspector performed Joint Inspection with ABF Survey Team for the Flatness Panel’s between Segment 7CW to 7EW between Panel Point (PP) 53 and PP 60 North(Cross Beam side) and South (Counter Weight side) for Deformation. Deformation was measured at 1500 mm Straight Edge. The measured readings were recorded on spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment # 7DE~7EE

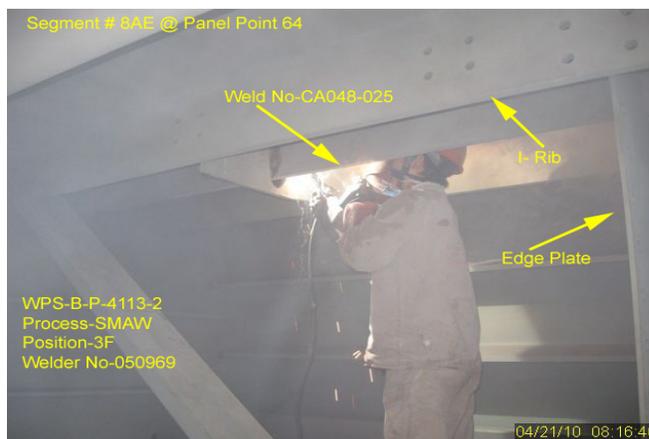
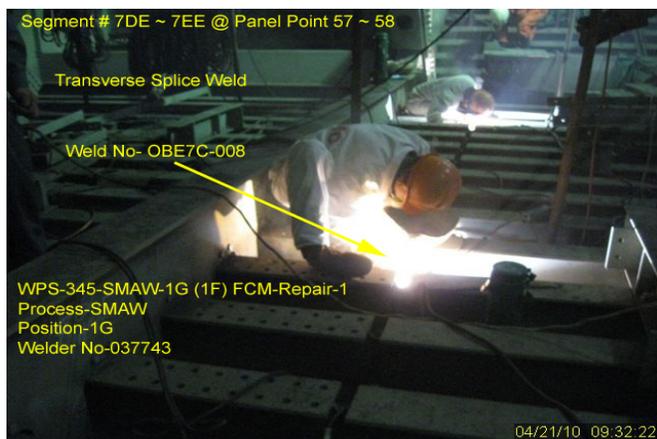
Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 037743 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE7C-008; The Critical Welding Repair Report (CWRR) was B-CWR12237. 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-345-SMAW-1G (1F) Repair. See the attached below Photo.

Segment # 8AE

This QA inspector observed, ZPMC qualified welding personnel identified as 050969 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA048-025; ZPMC QC is identified as Mr.Zhang Qiang. The welding parameters measured using QC’s calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F) Repair. See the attached below Photo.

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



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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
