

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-014193**Date Inspected:** 14-May-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:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes 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.

This QA Inspector observed the following work in progress:

BAY 9:

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 001. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 002. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 003. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 004. Welder(s) are identified as 059421. ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 005. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 006. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 007. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 008. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 009. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3119-001; Weld(s) 010. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 001. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 002. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 003. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 004. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 005. Welder(s) are identified as 059416. ZPMC

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 006. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 007. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 008. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 009. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3120-001; Weld(s) 010. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Sun Bo. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 231~240. Welder(s) are identified as 040881. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 241~250. Welder(s) are identified as 059443. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 251~260. Welder(s) are identified as 059443. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 261~270. Welder(s) are identified as 059443. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 271~280. Welder(s) are identified as 062259. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 286, 287, 296, 297, 306, 307, 316, 317, 326, 327.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Welder(s) are identified as 040875. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 340, 341, 348, 349, 358, 359, 368, 369, 378, 379. Welder(s) are identified as 062265. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3079-001; Weld(s) 392, 393, 400, 401, 410, 411, 420, 421, 430, 431. Welder(s) are identified as 062265. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3149-001; Weld(s) 167~172. Welder(s) are identified as 040875. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3143-001; Weld(s) 167~172. Welder(s) are identified as 062265. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of DP3150-001; Weld(s) 167~172. Welder(s) are identified as 040875. ZPMC Quality Control (QC) is identified as Zhang Qiao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2233-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

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:	Holmes,Stefan	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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