

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-014283**Date Inspected:** 13-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:** 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:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**Segment # 7EW**

This QA inspector observed ZPMC qualified welding personnel identified as 037840 perform Shielded Metal Welding (SMAW), weld joint identified as CA044-002 and was observed welding in the 2G (horizontal) position; ZPMC QC is identified as Mr. Wang Zu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2212-TC-U4b-FCM-1.

Segment # 7EW

This QA inspector observed ZPMC qualified welding personnel identified as 205098 perform Shielded Metal Welding (SMAW), weld joint identified as BP039-001-042 and was observed welding in the 1G (Flat) positions; ZPMC QC is identified as Mr. Cai Xiao Yeng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1. See the attached Photo.

Segment # 7EW

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This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG043A-044 and was observed welding in the 1G (Flat) position;. ZPMC QC is identified as Mr.Cai Xiao Yeng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T-2. See the attached Photo.

Segment # 8BE~8CE

Repair Welding

This QA inspector observed ZPMC qualified welding personnel identified as 220069 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE8C-005 and was observed welding in the 3G (Vertical) position;. The Critical Welding Repair Report (CWRR) was B-CWR1525. 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-3G (3F) -FCM-Repair-1

Segment # 8AW

This QA inspector observed ZPMC qualified welding personnel identified as 066038 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA047-006 and was observed welding in the 4G (Overhead) position;. ZPMC QC is identified as Mr.Cai Xiao Yeng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-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.

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Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
