

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-014495**Date Inspected:** 30-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:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar 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

This QA Inspector randomly observed the following work in progress.

Segment # 8AW ~ 8BW

This QA inspector observed ZPMC qualified welding personnel identified as 037723 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE8B-003 and was observed welding in the 1G (Flat) position; The Welding Repair Report (WRR) was B-WR12928. ZPMC QC is identified as Mr. Zhang Hai Tao. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG SEGMENT 8CW

This QA inspector observed ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG049A-014 and was observed welding in the 4G (Overhead) position; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

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This QA inspector observed ZPMC qualified welding personnel identified as 048696 perform Flux Core Arc Welding (FCAW), weld joint identified as SP488-001-022 and was observed welding in the 4G (Overhead) position; ZPMC CWI is identified as Mr. Liu Hu ajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

This QA inspector observed ZPMC qualified welding personnel identified as 048696 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP645-001-013 and was observed welding in the 4G (Overhead) position; ZPMC CWI is identified as Mr. Liu Hu ajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-4114-1.

OBG SEGMENT 7AW

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform Flux Core Arc Welding (FCAW), weld joint identified as TR1A-PP49-002 and was observed welding in the 2G (Horizontal) position; ZPMC QC is identified as Mr. Wang Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair.

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform Flux Core Arc Welding (FCAW), weld joint identified as TR1A-PP49-002 and was observed welding in the 2G (Horizontal) position; ZPMC QC is identified as Mr. Wang Jie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-2G (2F)-Repair.

OBG SEGMENT 7DW-7EW

This QA Inspector observed ZPMC QA Inspector performing magnetic particle inspection for the deck panel splice weld between OBG segment 7DW and 7EW (OBW7A-008). See attached photo.

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



Summary of Conversations:

No relevant conversations.

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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, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Dawson,Paul	QA Reviewer
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