

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-015437**Date Inspected:** 26-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:** Wu Zhi Cheng**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 # 8AW ~ 8CW (West Side)

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manikandan Joint Survey Inspection for the following Segment 8AW ~ 8CW from Panel Point 62 to PP 71

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly Survey Location is E1~ E2, S1 ~ S4, T1 ~ T3 Cope Hole Diameter from PP 62 to 71 Cross Beam and Counter Weight side.

Corner Assembly Cope Holes dimension measurements at Typical Corner Assembly at Intermediate Panel Point Survey Location is E1~ E2, S1 ~ S4, T1 ~ T2 Cope Hole Diameter from PP 62 to 71 Cross Beam and Counter Weight side.

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Segment # Cross Beam 8

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr.Manikandan Joint Survey Inspection for the Segment Cross beam 8 to FL3 Gap, Offset and Bolt Hole Spacing.

Segment 8CW ~ 8BW

This QA inspector observed ZPMC qualified welding personnel identified as 045213 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP653-001-019 and was observed welding in the 3G (Vertical) position; 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-B-T-3213-B-U3b.

Segment # 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 045227 perform Flux Core Arc Welding (FCAW), weld joint identified as SP489-001-051 and was observed welding in the 3G (Vertical) 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-T-2132.

Segment # 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 0 perform Flux Core Arc Welding (FCAW), weld joint identified as SP489-001-051 and was observed welding in the 3G (Vertical) 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-T-2132.

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
