

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-015623**Date Inspected:** 10-Jul-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 # 9AW~9BW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9B-002; The Critical Welding Repair Report (CWRR) was B-CWR1698. ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair- 1. See the below attached Photo.

Segment # 9CE~9DE

This QA inspector observed, ZPMC qualified welding personnel identified as 068501 perform Flux Core Arc Welding (FCAW), weld joint identified as BP126-001-022; ZPMC CWI is identified as Mr. Liu Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-B-T-2233T-1. See the attached below photo.

Segment# 9AW~9BW

During in process visual inspection of 9AW~9BW , This QA Inspector observed ZPMC Quality Control (QC) personnel performing Magnetic Particle testing (MT) ZPMC Technician identified as Mr.Xie Gen Lin , of the Deck Plate to Deck plate (Transverse Splice Weld)

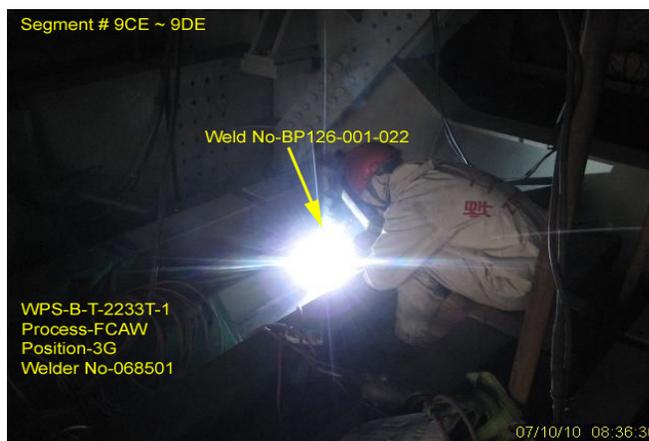
Segment # 9CE~9DE

This QA inspector observed, ZPMC qualified welding personnel identified as 067947 perform Flux Core Arc Welding (FCAW), weld joint identified as SP545-001-053; ZPMC CWI is identified as Mr.Liu Huajie. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T-1.

Segment # 9AW

This QA inspector observed, ZPMC qualified welding personnel identified as 067904 perform Shielded Metal Arc Welding (SMAW), The Repair Welding of the Bottom Plate Hold back Area Magnetic Particle testing (MT); ZPMC QC is identified as Mr.Shi Lei The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) FCM-Repair-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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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer
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