

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-015874**Date Inspected:** 17-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 # 9BE ~ 9CE

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 062092 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG052A-045; The Critical Welding Repair Report (CWRR) was B-CWR1703. 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-345-SMAW-4G (4F) FCM-Repair-1. See the below attached Photo.

Segment # 9DE ~ 9EE

This QA inspector observed, ZPMC qualified welding personnel identified as 067765 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP699-001-018; ZPMC CWI is identified as Mr. Liu Huajia. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-B-T-4114-1. See the attached below photo.

Segment # 9BW

This QA inspector observed, ZPMC qualified welding personnel identified as 207465 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD25-PP075-051; ZPMC QC is identified as Mr. Xu Jin Long. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 9DE ~ 9EE

This QA inspector observed, ZPMC qualified welding personnel identified as 067947 perform Submerge Arc Welding (SAW), weld joint identified as OBE9A-008; ZPMC CWI is identified as Mr. Wuzhi Cheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-223(2) 1T-1.

Segment # 9DE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on locations Bottom Plate in OBG segment 9DE at panel point 82. ZPMC CWI is identified as Mr. Liu Huajie. the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR (B) 384.

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

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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
