

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-015887**Date Inspected:** 28-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:** Zhu Zhong Hai**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 & 9AE

This QA performed a joint survey dimensional inspection of corner assembly cope holes on segment 9AE & 9AW. The inspection was performed along with Caltrans (CT) QA Mr. Manjunath Math, Measurements of the cope holes were taken from PP71.25 to PP 73 at the following locations: E1~E2, S1~S5 and T1~T3 on both the crossbeam, bike path sides and Counter Weight Side. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly Cope Holes". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9AW & 9AE

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This QA performed a joint Survey dimensional inspection of Corner assembly on Segment 9AW & 9AE for Deck Panel to Corner Assembly Flatness measurement from PP 71.25 ~ PP 73 Cross Beam, Counter Weight side and Bike path Side. Details of these locations can be found on CT / QA document titled “OBG DCP Hand Measurement Survey: Corner Assembly SP-SP & DP-DP Flatness”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9DW ~ 9EW

This QA inspector measured and recorded root gap and offset on segment 9DW ~ 9EW along with Caltrans QA inspector (Mr.Manjunath Math) from Panel Point 82 to Panel Point 83. Details of these locations can be found on CT / QA document titled “OBG DCP Hand Measurement Survey: Transverse Segment Splice Root Gap and Offset”. This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 9BW ~ 9CW

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9B-007; ZPMC CWI is identified as Mr. Zhu Zhang Hai. The welding parameters measured using QC’s calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM. See the attached Photo.

Segment # 9DE ~ 9EE

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 048659 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE9A-008; The Critical Welding Repair Report (CWRR) was B-CWR1736. 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 4G (4F) FCM-Repair-1.

Segment # 9DE ~ 9EE

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 220066 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE9A-008; The Welding Repair Report (WRR) was B-WR14139. 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-FCAW 2G (2F) Repair-1. See the attached Photo.

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

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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
