

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-016169**Date Inspected:** 11-Aug-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:** 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 Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

This QA received ZPMC inspection notification sheet 06375 to perform dimensional inspection of traveler rails identified as 20TR2-024. The inspection was performed along with Caltrans (CT) QA Mr. Amit Juvekar, Dimensional inspections performed on each of these traveler rails include, but is not limited to, overall length, Thickness at Typical Section, Flange Width, Depth Typical Section, flange Curl at Typical Section, Web to Flange Offset The results of the inspection were recorded on Caltrans (CT) QA form "OBG DCP Hand Measurements Survey: Traveler Rails and submitted to CT QA lead for review.

Segment # 9BW ~ 9CW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP685-001-021; The Welding Repair Report (WRR) was B-WR14513. ZPMC QC is identified as Mr. Shi Lei. The welding parameters measured using QC's calibrated instrument

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appeared to be in general compliance with WPS-485- SMAW 3G (3F) FCM-Repair -1. See the attached below Photo.

Segment # 9DW

This QA inspector observed, ZPMC qualified welding personnel identified as 067572 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP686-001-013; 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-B-T-4114-1.

Segment # 9DW ~ 9EW

Base Metal Repair

This QA inspector observed, ZPMC qualified welding personnel identified as 067610 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW9C-007; The Critical Welding Repair Report (CWRR) was B-CWR1679. ZPMC QC is identified as Mr. Zhong Peng. 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 # 9BW ~ 9CW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 067829 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG053A-013; The Critical Welding Repair Report (CWRR) was B-CWR1775. ZPMC QC is identified as Mr. Zhong Peng. 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 # 9AE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on Floor Beam in OBG segment 9AE at panel point 72. ZPMC QC is identified as Mr. Zhang Qiang the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9006.

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
