

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-016716**Date Inspected:** 22-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:** Liu Huajie**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 # 10AE ~ 10BE**

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manunath Math for the Transverse Segment Splice Root Gap & Offset at Bottom Plate to Bottom Plate and Side Plate to Side Plate (Cross Beam & Bike Path Side) & Deck Plate to Deck Plate. Dimension was recorded from following work point for Segment 10AE ~ 10BE between Panel Point (PP) 88 to 89. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Transverse Segment Splice Root Gap & Offset". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

Segment # 10AW ~ 10BW

This QA inspector observed, ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10B-004; ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

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WPS-B-P-2214-B-U2-FCM-1. See the attached below Photo.

Segment # 10AW ~ 10BW

This QA inspector observed, ZPMC qualified welding personnel identified as 067829 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW10B-005; ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-B-P-2214-B-U2-FCM-1

Segment # 10AW

This QA inspector observed, ZPMC qualified welding personnel identified as 040704 perform Flux Core Arc Welding (FCAW), weld joint identified as SP777-001-010; ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-B-T-2132.

Segment # 10AW

This QA inspector observed, ZPMC qualified welding personnel identified as 202384 perform Flux Core Arc Welding (FCAW), weld joint identified as BP103-001-032; ZPMC QC is identified as Mr. Zhou Peng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with

WPS-B-T-2132.

Segment # 10AW

This QA inspector observed, ZPMC qualified welding personnel identified as 044473 perform Flux Core Arc Welding (FCAW), weld joint identified as OBE10-003; 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-P-2231T. See the attached below Photo.

Segment # 9CW ~ 9DW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP673-001-019; The Welding Repair Report (WRR) was B-WR14646.

ZPMC QC is identified as Mr. Zhou Yuan Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW 3G (3F) FCM-Repair-1.

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
