

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017852**Date Inspected:** 06-Oct-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 Hua Jie**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

WELDING**Segment # 11AW**

This QA inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG065A-11; located On Orthotropic Box Girder (OBG) Bottom Plate to Side Plate. The Critical Welding Repair Report (CWRR) was B-CWR1842. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM-1. See the attached Photo

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc

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Welding (SMAW), weld joint identified as SP380-001-028; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Web to Web Joint. ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1. See the attached Photo.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 056200 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP353-001-027; located On Orthotropic Box Girder (OBG) Side Plate T-Rib Web to Web Joint. ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-B-U2-FCM-1.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11-005; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044473 perform Flux Core Arc Welding (FCAW), weld joint identified as BP132-001-045/046, BP133A-001-043/044; located On Orthotropic Box Girder (OBG) Bottom Plate T-Rib Hold Back Weld. ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132.

Segment # 11AW ~ 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 040604 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG067B-004; located On Orthotropic Box Girder (OBG) LD to Floor Beam Stiffener CJP Weld. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-TC-U4b-FCM.

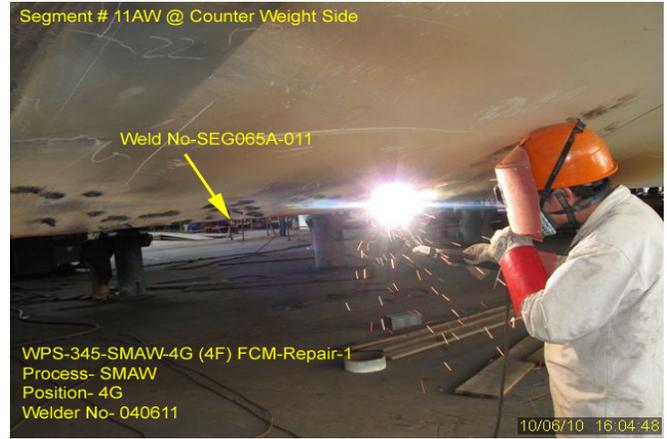
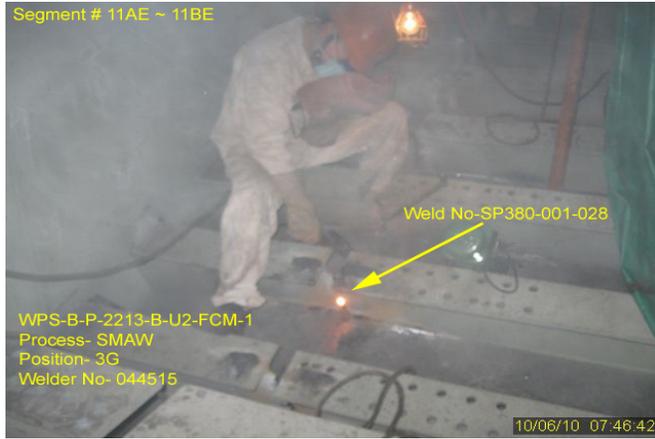
Segment # 10CE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Ultrasonic Testing (UT) on Bottom Plate to Side Plate Hold Back Weld in OBG segment 10CE.

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
