

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-017854**Date Inspected:** 07-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:** 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 # 10CE & 10CW

This Quality Assurance (QA) received ZPMC Verbal inspection notification to perform Suspender Bracket identified as SB94W, SB92W, SB94E and SB92E on segment 10CE & 10CW at Panel Point 92 and 94. Faying Surface Gap Verified and Measured within Tolerance.

WELDING

Segment # 11AW

This QA inspector observed ZPMC qualified welding personnel identified as 044779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG064-039; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate. The Welding Repair Report (WRR) was B-WR15568. ZPMC Quality Control (QC) is identified as

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Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See the attached Photo

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 040367 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP699-001-034; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F. See the attached Photo.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 052763 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SP714-001-031; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Joint. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

Segment # 11AW ~ 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP692-001-019; located On Orthotropic Box Girder (OBG) Corner Assembly I-Rib to I-Rib CJP Joint. 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-3213-B-U3b.

Segment # 11AW ~ 11BW

This QA inspector observed ZPMC qualified welding personnel identified as 069841 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP692-001-007; located On Orthotropic Box Girder (OBG) Deck Plate to I-Rib. 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-4114-1.

Segment # 11AE ~ 11BE

This QA inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as BP078-001-022; located On Orthotropic Box Girder (OBG) Bottom Plate T-Rib Web to Web 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-2213-B-U2-FCM-1.

HEAT STRAIGHTENING

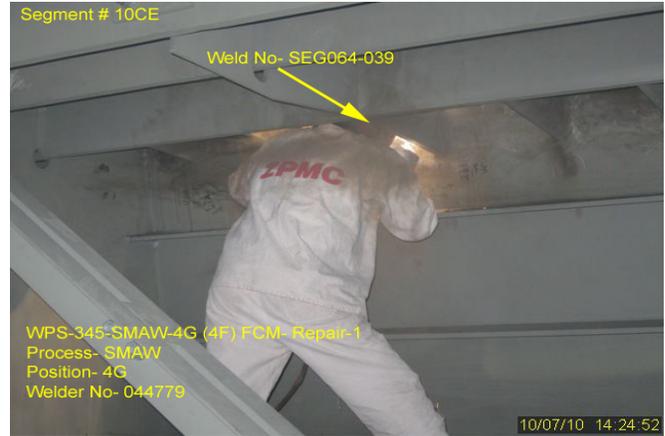
This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Bottom Plate on segment 10CE at Panel Point 94. Distortion appeared to be caused by Welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Li Yang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B) 9559.

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
