

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-018213**Date Inspected:** 19-Nov-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:** An Qing Xiang**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 11EE**

This QA Inspector observed ZPMC qualified welding personnel identified as 040367 perform Flux Core Arc Welding (FCAW), weld joint identified as LB4-003-045; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate Transverse PJP Weld. ZPMC QC is identified as Mr. An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-T-2233-ESAB. See attached photo for further details.

Segment 11EE

This QA Inspector observed ZPMC qualified welding personnel identified as 052910 perform Flux Core Arc Welding (FCAW), weld joint identified as LB4-003-047; located On Orthotropic Box Girder (OBG) Deck Plate

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to Edge Plate Transverse PJP Weld. ZPMC QC is identified as Mr. An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-B-T-2233-ESAB.

Segment 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11A-024; located On Orthotropic Box Girder (OBG) Deck Plate to Connection Plate CJP Weld; The Welding Repair Report (WRR) was B-WR17275. ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 1G (1F) FCM-Repair-1. See attached photo for further details.

Segment 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11A-021; located On Orthotropic Box Girder (OBG) Deck Plate to Connection Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1.

Segment 11DW

This QA Inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW11A-021; located On Orthotropic Box Girder (OBG) Deck Plate to Connection Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM-1.

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



Summary of Conversations:

No significant conversations were reported on this date.

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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
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Reviewed By:	Peterson,Art	QA Reviewer
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