

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019668**Date Inspected:** 04-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:** Mr. Chen xi.**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:** OBG BAY 1 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 observed the following work in progress:

BAY #3

Flux Cored Arc Welding (FCAW) of welds joint FB3271-001-102, And Welder is identified as 217805, ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

BAY # 2

FCAW welding of welds joint VP3014-001-052, And Welding Repair Report (WR) B-WR15430, and Welder is identified as 045276; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables appeared to comply with the Applicable WPS-345-FCAW-2G (2F)-FCM-Repair-1.

FCAW welding of welds joint VP3014-001-041, And Critical Welding Repair Report (CWR) B-CWR1981, and Welder is identified as 045240; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables

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appeared to comply with the Applicable WPS-345-FCAW-2G (2F)-FCM-Repair-1.

FCAW welding of welds joint FB3317-001-012,011, And Welder is identified as 045209, ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2231-B-U4b-F.

BAY # 7

FCAW welding of welds joint FB3246-001-005,006, And Welder is identified as 0204342, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4b-F.

FCAW welding of welds joint W2-SB1G-014-126~131, And Welder is identified as 215689, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang . The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB1A-003-126~131, And Welder is identified as 205386, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang . The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

BAY #6

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Cross Beam (CB) 19 members identified as SP3146A. Distortion appeared to be caused by mishandling of the material. ZPMC Quality Control (QC) inspector identified as Mr. Shu Yang Hua was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) / HSR1 (B)-9536.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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