

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-019956**Date Inspected:** 27-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. Huang Min		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG BAY 5 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 6

Flux Cored Arc (FCAW) welding of welds joint FB3168-004-035, And Welder is identified as 048659, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b.

Shielded Metal Arc (SMAW) welding of Weld Joint DP3166-001-026(OBG Lift 14), And Welder is identified as 057795, ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2113.

BAY 7

FCAW welding of welds joint W2-SB9-044-128/129, And Welder is identified as 215689, ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guao. The welding variables appeared to comply with the Applicable

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WPS-B-T-2132-3.

FCAW welding of welds joint W2-SB9-043-130,/131, And Welder is identified as 053609, 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 8

Shielded Metal Arc (SMAW) welding of Weld joint BK004A2-053-018,And Critical Welding Repair Report(CWR)B-CWR2114, Welder is identified as 045148, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-Repair.

FCAW welding of welds joint BK004A5-055-004, And Welder is identified as 066421, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4C-F.

During the QA In process observations of Fabrication of OBG Bike Path BK4A-053, this QA discovered the following issue: ZPMC has welded 4 CJP joints with backing bar. The backing bars were not full length of the joints as specified in AWS D1.5 2002. This QA informed ZPMC QC identified as Liu Fa Wen and ABF QA identified as Luo Lai Quan of this issue and that an incident report will be generated. For further details, see the incident report issued by this QA on this date and the attached photos.

For further information, please see the attached pictures below.

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.

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

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