

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019968**Date Inspected:** 13-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. Xu Xian Ping.**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 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 CB3002A-018-030, And Welder is identified as 066733,066471, 062494, ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2232-TC-U5-F.

Submerged Arc Welding (SAW) welding of welds joint CB3003E-019-002(CB19, BAY 6), and Welder is identified as 215960. ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) welding of welds joint FB3169-002-039, and Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS-B-P-2213-B-U3b.

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BAY 7

Submerged Arc Welding (SAW) welding of welds joint CB3003B-019-003(CB19, BAY 6), and Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) welding of welds joint X4253A-003-001, and Critical Welding Repair Report(CWR)B-CWR2030, Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

SMAW welding of welds joint X4253A-004-001, and Critical Welding Repair Report(CWR)B-CWR2031, Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

SMAW welding of welds joint X4253B-001-001, and Critical Welding Repair Report(CWR)B-CWR2032, Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

SMAW welding of welds joint X4253B-002-001, and Critical Welding Repair Report(CWR)B-CWR2033, Welder is identified as 057795. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-1G(1F)-FCM-Repair.

BAY 8

Flux Cored Arc (FCAW) welding of welds joint BK004A3-064-025, And Welder is identified as 054459, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Win. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of welds joint BK004A5-064-022/023, And Welder is identified as 500405, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Win . The welding variables appeared to comply with the Applicable WPS-B-T-2132.

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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