

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-022427**Date Inspected:** 31-Mar-2011**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:** Li Yang**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 COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 1G position for OBG cross beam CB17, welding of base metal VT repair temporary attachmet area at deck plate. The Welder is identified as 067752. ZPMC Quality Control is identified as Mr. Li Yang. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1.

The weld repair report is identified as CWR2134 R1. The welding variables were recorded at, Amperage 168, volts 24.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

FCAW in the 3G position for OBG segment 13AW, welding of weld No. SEG3013S-205. The Welder is identified as 048433. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-B-T-2233-ESAB. The In-process FCAW appears to be progressing in compliance with approved contract documents.

FCAW in the 3G position for OBG segment 13AW, welding of weld No. SEG3013M-046. The Welder is

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identified as 048696. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-B-T-2233-ESAB. The In-process FCAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AW, welding of weld No. SEG3013AD-061. The Welder is identified as 047864. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1. The In-process SMAW appears to be progressing in compliance with approved contract documents.

SMAW in the 4G position for OBG segment 13AW, welding of UT repair weld No. SEG3013AA-118. The Welder is identified as 069683. ZPMC Quality Control is identified as Mr. Shen Jian Bao. The welding variables recorded by QC personnel appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The weld repair report is identified as WR20525. The welding variables were recorded at, Amperage 148, volts 23.5. The In-process SMAW appears to be progressing in compliance with approved contract documents.

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



Summary of Conversations:

No relevant conversations

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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
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Reviewed By:	Dsouza, Christopher	QA Reviewer
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