

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023207**Date Inspected:** 28-Apr-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:** Liu Hua Jie**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 13AW**

This QA Inspector observed ZPMC qualified welding personnel identified as 066109 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3103-075; located On Orthotropic Box Girder (OBG) RS3449A to X4192B CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20811. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-3G (3F) FCM-Repair-1. See attached photo for further details.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform Shielded Metal Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SMAW), weld joint identified as SEG3013D-129; located On Orthotropic Box Girder (OBG) Side Plate to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20577. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 3G (3F) FCM-Repair-1. See attached photo for further details.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013K-117; located On Orthotropic Box Girder (OBG) RS3434H to SP3102A CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 052493 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA3005-005; located On Orthotropic Box Girder (OBG) Side Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20834. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G(4F)FCM-Repair-1.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 066326 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013S-193; located On Orthotropic Box Girder (OBG) FB3175A to RS3426F CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20577. ZPMC Quality Control (QC) Mr. Shen Jian Bo was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 3G (3F) FCM-Repair-1.

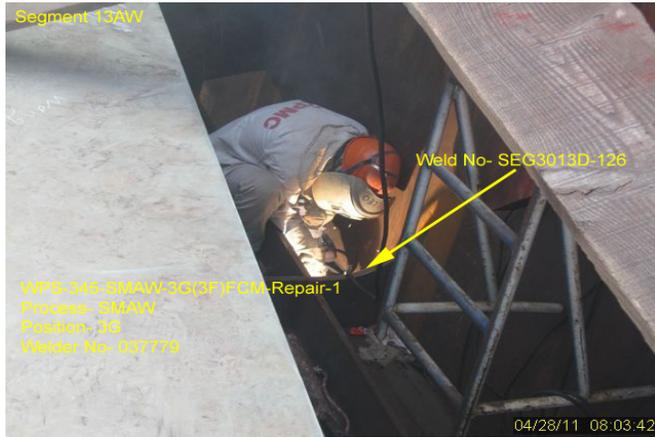
Segment 13AE

This QA Inspector observed ZPMC qualified welding personnel identified as 044772 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3007K-097; located On Orthotropic Box Girder (OBG) Side Plate I-Rib to Floor Beam CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Liu Hua Jie. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Liu Hua Jie was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2213-TC-U4b-FCM-1.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

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

Reviewed By: Peterson,Art

QA Reviewer