

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011584**Date Inspected:** 09-Jan-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. Fa Wen**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**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

BAY-3

MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The weld designations reviewed are as follows:

LD3007-001-032,033,039,040,045,046,050,051,057,058,063,064,069.

BAY-5

MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The weld designations reviewed are as follows:

TR6A-PP038-001, 002, TR6A-PP040-001, 002, TR6A-PP042-001, 002, TR6A-PP044-001,002,
TR6A-PP046-001, 002, TR5B-PP037-003,004, TR5B-PP039-003, 004, TR5B-PP041-003,004,
TR5B-PP043-003, 004, TR5B-PP045-003,004.

UT of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an UT report for this date. The weld designations reviewed are as follows:

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TR6A-PP046-001, 002, TR5B-PP039-003, 004, TR5B-PP041-003,004.

BAY-6 - Traveler Rail (TR)

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted notification No: 005026.

Visual Inspection(VT)

This QA Inspector performed VT of the area previously Tested and accepted by ZPMC QC Personnel. The member is identified Exterior platform Component. The identified component reviewed as follows:
M202A, B, C, D, &E.

BAY-5

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 005 located on 11TR4-001. Welder is identified as 217185. ZPMC Certified Welding Inspector (CWI) is identified as Mr.Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5F.

Flux Cored Arc Welding(FCAW)welding of weld joint 007 located on 11TR4-001. Welder is identified as 217185. ZPMC Certified Welding Inspector (CWI) is identified as Mr.Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5F.

Flux Cored Arc Welding (FCAW)welding of weld joint 014 located on 11TR3-008. Welder is identified as 067275. ZPMC Certified Welding Inspector (CWI) is identified as Mr.Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-2232-TC-U5F.

Flux Cored Arc Welding (FCAW) welding of weld joint 013 located on 11TR4-001. Welder is identified as 217185. ZPMC Certified Welding Inspector (CWI) is identified as Mr.Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS:B-T-2232-TC-U5F.

BAY-3 - Cross Beam (CB)

Shielded Metal Arc Welding (SMAW) welding of weld joint 148 located on CB202G-044. Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr.Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2114-FCM-1.

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

Summary of Conversations:

Only general conversation was held between QA and Quality Control (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 Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer