

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-012266**Date Inspected:** 18-Feb-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. 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:** Orthotropic Box Girder (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:

OBG TRIAL ASSEMBLY

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 6CW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG031F-008. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Welding Repair Report (WRR) No: B-WR10630.

SEGMENT: 7AW-7BW

Shielded Metal Arc Welding (SMAW) welding of weld joint SP518-001-37. Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2.

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Shielded Metal Arc Welding (SMAW) welding of weld joint SP097-001-41. Welder is identified as 068917. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2.

Shielded Metal Arc Welding (SMAW) welding of weld joint SP097-001-42. Welder is identified as 068917. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2.

SEGMENT: 6BW

During random in process visual inspection this Caltrans Quality Assurance Inspector (QA) observed a following Issue:

- The width of a single weld pass was measured to be approximately 25 mm.
- This welding was performed in the flat (1G) position.
- The welding process performed was Flux Cored Arc Welding (FCAW).
- The maximum FCAW single weld pass width allowed in this position is 16mm.
- The weld is identified as OBW6F-007.

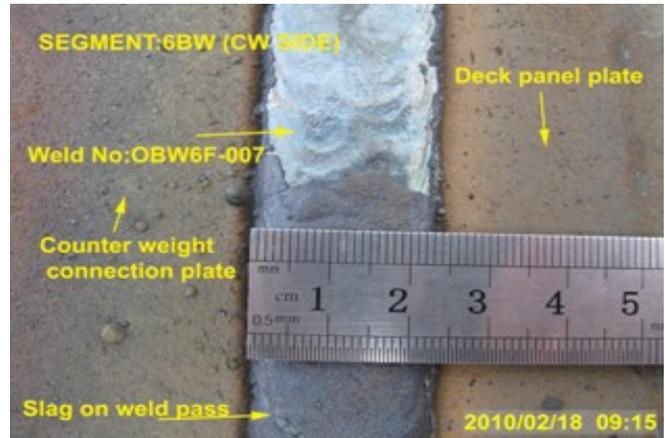
This QA generated an incident report on this date for the above issue, for further details see attached photographs and an incident report.

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



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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 Tsand 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer
