

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012326
Date Inspected: 26-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. Wuzhi Chang	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: 7AW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG033B-011. Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) FCM-Repair-1 and Welding Repair Report (WRR) No: B-WR-10698.

SEGMENT: 6CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG030B-032. Welder is identified as 054467. ZPMC Quality Control (QC) is identified as Mr. Wang 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

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Report (WRR) No: B-WR-9693.

SEGMENT: 6AW

Shielded Metal Arc Welding (SMAW) welding of weld joint EP030-001-060. Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Tang Ya jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2113-TC-U4b-FCM-1.

SEGMENT: 6BW-6CW

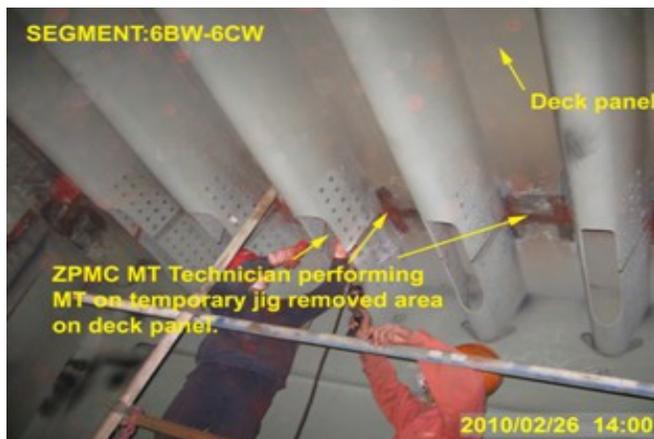
This QA Inspector observed ZPMC QC MT Technician Mr. Ding Achang was performing Magnetic Particle Testing (MT) for OBG Segment 6BW-6CW (Panel Point #43-44) on temporary jig removed area on base metal. (See attached photographs)

SEGMENT: 6AW-6BW

This QA Inspector observed American Bridge/Fluor (AB/F) QC MT Technician Mr. Wang Long Nian was performing Magnetic Particle Testing (MT) for OBG Segment 6AW-6BW (Panel Point #41) on T Rib Hold back welds.

(See attached photographs)

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.

WELDING INSPECTION REPORT

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