

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-012340**Date Inspected:** 27-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: 7AE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG034A-007. Welder is identified as 048654. 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-1G (1F) FCM-Repair-1. The repair welding was performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1211 and American Bridge/Fluor (AB/F) UT report # UT-7E-029 dated: 02/18/2010.

SEGMENT: 6BE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SP527-001-029. Welder is identified as 068091. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC

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appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) FCM-Repair and Welding Repair Report (WRR) No: B-WR-10707. This weld has been repaired due to the flatness exceed the requirement which was caused by weld distortion and fabrication error at Segment 6BE (Crossbeam side).

SEGMENT: 6CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SP528-001-046. Welder is identified as 066413. 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-1G (1F) FCM-Repair and Welding Repair Report (WRR) No: B-WR-10707. This weld has been repaired due to the flatness exceed the requirement which was caused by weld distortion and fabrication error at Segment 6CE (Crossbeam side).

SEGMENT: 6CW

Shielded Metal Arc Welding (SMAW) welding of Base Metal Repair (BMR) at Segment 6CW Panel Point #45-46 (FL3 location). Welder is identified as 062092. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) FCM-Repair-1. The repair was been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR1098.

(see attached photos)

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

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