

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014245**Date Inspected:** 05-Apr-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. Zhu Tian Shu / Mr. Li Jia	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:

This QA Inspector observed the following work in progress:

BAY-1 -TRAVELER RAIL (TR)

This QA Inspector observed ZPMC Personnel's performing grinding for the TR weld back gouged area. The TR Numbers are review as 20TR1-037~040.

The attached photographs provide additional detail.

This QA Inspector observed ZPMC Ultrasonic Testing (UT) Technicians performing UT for the TR No: 20TR1-018.

The attached photographs provide additional detail.

BAY-2-FLOORBEAM (FB)

Submerged Arc Welding (SAW) welding of weld joint FB3186-001-001. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with

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the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint FB3201-001-011. Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) welding of weld joint FB3192-001-009. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2a-F-1.

This QA Inspector observed ZPMC Tack welder was performing Tack welding by Shielded Metal Arc Welding (SMAW) process for Floor beam weld joint FB3176-001-012. The tack welder was identified as 207464. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Feng. The tack welding was being performed against the Caltrans Engineer approved Welding Procedure Specification (WPS): WPS-B-P-2112.

This QA observed Inspector ZPMC Personnel's performing Heat Straightening for the Traveler Rail 11TR2-016. The Heat Straightening was performed against the HSR Report# HSR1 (B)-8160 Rev No: 0. ZPMC Quality Control (QC) is identified as Mr. Zhulin.

BAY-6-WEST JACKING FRAME (WJF)

SMAW welding of weld joint WJF-0-299. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Shun Yanghua. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3112-1.

SMAW welding of weld joint WJF-0-381. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Shun Yanghua. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3112-1.

SMAW welding of weld joint WJF-0-293. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Shun Yanghua. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3112-1.

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
Reviewed By:	Hall,Steven	QA Reviewer
