

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-014057**Date Inspected:** 11-May-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 zhong hai**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:

BAY-7.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005712.

Visual Inspection (Dimensional survey).

This QA Inspector along with Caltrans QA Inspector Mr. Manjunath Math measured the length of Traveler Rail (TR), Depth at typical section and sliding connection, web to flange offset, flange tilt, cut angle at sliding connection, flange width at typical section and sliding connection, thickness at typical and sliding connection..

Total number of TR's: 01 No. The measured readings were data recorded, generated the report and submitted to the Task Leader. The TR designation is review as follows:

1. 11TR3-011.

OBG TRIAL ASSEMBLY.

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This QA Inspector along with Caltrans QA Inspector Mr. Manjunath Math measured the faying surface gap between template and Deck panel extension to Cross beam CB7 before drilling the bolt holes at Segment 7BW Panel Point No: 50~52. The maximum gap measured to be 12.7 mm at Y location is approximately 1965 mm. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action. Refer attached photos for reference.

BAY-14

This QA Inspector Randomly observed the following work in progress:

Segment: 12AW.

Submerged Arc Welding (SAW) welding of weld joint SEG3004*-021. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. 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) of weld joint SEG3004*-024. Welder is identified as 066673. ZPMC Quality Control (QC) is identified as Mr. Li Ming yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-223(2)1T-2.

Segment: 12CE.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3003K-007. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo hai. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

SMAW welding of weld joint SEG3003L-003. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo hai. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

SMAW welding of weld joint SEG3003F-007. Welder is identified as 048038. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo hai. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

SMAW welding of weld joint SEG3003G-006. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhong Guo hai. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132.

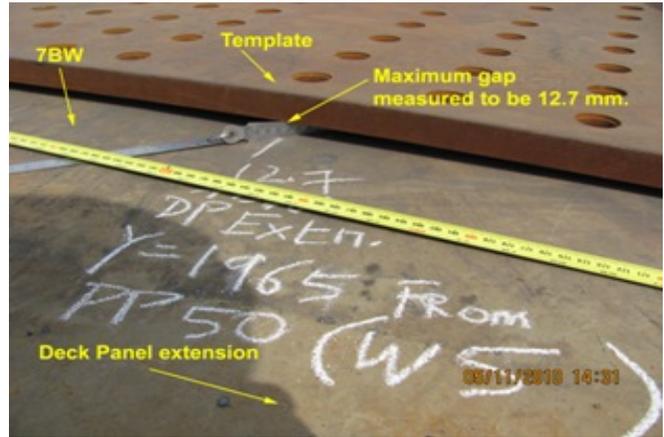
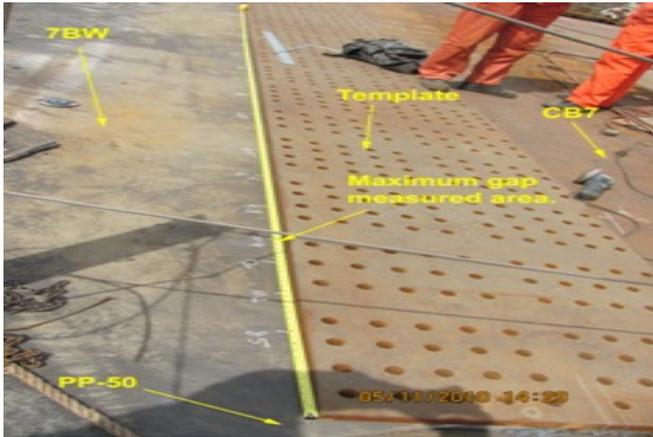
Segment: 12CW.

SMAW welding of weld joint SEG3006F-143. Welder is identified as 37723. ZPMC Quality Control (QC) is identified as Mr. Tao wei. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

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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.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
