

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-014066**Date Inspected:** 04-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. 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:

BAY-5

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) on Traveler Rail (TR) Repair weld joint 10TR3-027-014. Welder is identified as 050969. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair. The repair welding was been performed according to the Welding Repair Report (WRR) No: B-WR11298. This weld was rejected by ZPMC UT Technicians and recorded on UT Report No: B787-UT-10837R1.

BAY-6

SMAW on West Jacking Frame (WJF) weld joint WJF-0-108. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Zhao jian Hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3312-TC-P4.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW on WJF weld joint WJF-0-125. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Zhao jian Hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3312-TC-P5.

Flux Cored Arc Welding (FCAW) on U-Rib Extra Big Splice weld joint USPL1-433-001. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Gou. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4b-F.

FCAW on U-Rib Extra Big Splice weld joint USPL1-444-001. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Shu Jian Gou. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4b-F.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005657.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The member is identified as OBG U Rib Connection Plate weld Components. Total number of welds UT Tested: 26 No's. The weld designations are review as follows:

1. USPL1-387-001,002.
2. USPL1-392-001,002.
3. USPL1-393-001,002.
4. USPL1-394-001,002.
5. USPL1-395-001,002.
6. USPL1-396-001,002.
7. USPL1-397-001,002.
8. USPL1-398-001,002.
9. USPL1-401-001,002.
10. USPL1-402-001,002.
11. USPL1-404-001,002.
12. USPL1-405-001,002.
13. USPL1-407-001,002.

BAY-7

SMAW Tack welding on Deck panel weld joint DP3085-001-012. Welder is identified as 203204. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

FCAW Buttering welding on Traveler Rail 22TR4-003. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Wang jian. The welding variables recorded by QC appeared to comply with the

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Applicable WPS: WPS-345-FCAW-1G(1F)Repair-1. The buttering was performed the Critical Welding Repair Report (CWR) No: B-CWR 1374.

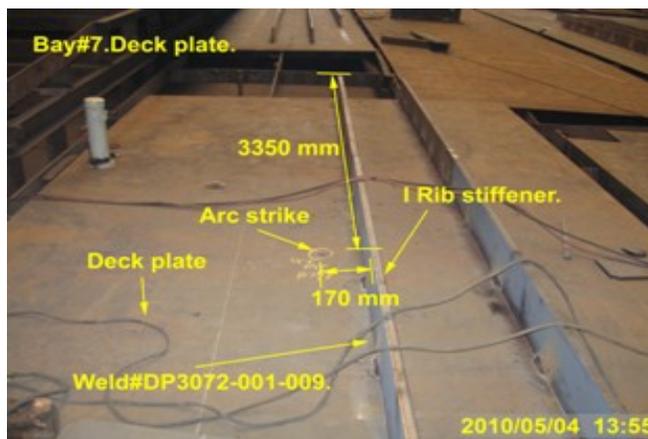
During random in process Visual Inspection this QA Inspector observed 1 (one) Arc strike on Deck plate near to the weld No: DP3072-001-009. This QA informed to ZPMC Quality Control (QC) identified as Mr. Cui jun jie and American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Chang of the above issue, As per ZPMC QC and AB/F QA the arc strike shall be repaired by grinding and perform Magnetic Particle Testing (MT) for verifying no more defects.

Refer attached photos for additional details.

BAY-8.

This QA Inspector observed ZPMC Personnel performing Heat Straightening for the BKX10A9 (058)-084,085. Heat Straightening was being performed appeared to comply with the Applicable HSR Report# HSR1 (B)-8325. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng.

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
