

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-014317**Date Inspected:** 23-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. Liu Fa Wen
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005802.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Traveler Rail Bracket weld Components. Total number of welds MT Tested: 10 No's. The weld designations are review as follows:

1. TR6A-PP066-002.
2. TR6A-PP070-002.
3. TR6A-PP068-002.
4. TR5B-PP061-004.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5. TR5D-PP063-007.
6. TR5C-PP067-005.
7. TR2A-PP060-001.
8. TR1A-PP049-001.
9. TR2A-PP052-001.
10. TR5D-PP051-007.

BAY-6

This QA Inspector Randomly observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint WJF-0-202. Welder is identified as 053748. 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-3221-TC-U4a-S-1.

BAY-7

Flux Cored Arc Welding (FCAW) of weld joint DP3129-001-001/002. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

FCAW of weld joint DP3129-001-011/012. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

FCAW of Repair weld joint 22TR2-001-007. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1. The repair welding was been performed as per the Welding Repair Report (WRR) No: B-WR11864. This weld was rejected by ZPMC UT Technicians and recorded on UT Report No: B787-UT-12193.

FCAW of Repair weld joint 22TR1-001-009. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1. The repair welding was been performed as per the Welding Repair Report (WRR) No: B-WR11855. This weld was rejected by ZPMC UT Technicians and recorded on UT Report No: B787-UT-12192.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
