

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-014433**Date Inspected:** 26-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-2.

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3200-001-040/041. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhu lin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

BAY-3.

Submerged Arc Welding (SAW) of weld joint FB3126-001-005. Welder is identified as 062406. ZPMC Quality Control (QC) is identified as Mr. Shi lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

SAW of weld joint FB3126-001-007. Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Shi lei. The welding variables recorded by QC appeared to comply with the Applicable WPS:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2221-B-L2c-S-2.

BAY-5

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005830 and 005834.

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: 20 No's. The weld designations are review as follows:

1. TR1D-PP063-007.
2. TR1E-PP064, 062-009.
3. TR2A-PP068, 066, 062,070, 064-001.
4. TR1A-PP069, 063, 065-001.
5. TR1B-PP067, 065, 071-003.
6. TR1C-PP066-005.
7. TR1D-PP069-007.
8. TR1B-PP060-005.
9. TR1E-PP050-009.
10. TR1E-PP052-009
11. TR1D-PP051-007.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005830 and 005834.

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 members are identified as OBG Traveler Rail bracket weld Components. Total number of welds UT Tested: 07 No's. The weld designations are review as follows:

1. TR2A-PP068, 066-001.
2. TR1A-PP063-001.
3. TR1B-PP049-003.
4. TR1B-PP059-003.
5. TR1E-PP068-009.
6. TR1D-PP051-007.

BAY-7

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

FCAW buttering welding of Traveler Rail 22TR1-002. Welder is identified as 204342. 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-FCAW-1G (1F)-Repair-1. The repair welding was been performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR1374.

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
