

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-014462**Date Inspected:** 30-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. Huang Min**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:

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This QA Inspector Randomly observed the following work in progress:

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 20TR2-003. Heat straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8350. ZPMC Quality Control (QC) is identified as Mr. Shen Jian Guo.

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Submerged Arc Welding (SAW) of weld joint WJF-0-193. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Huang Min. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3221-TC-U4a-S-1.

During random in process Visual Inspection this QA Inspector observed 1 (one) crack tack on the joint No identified as DP3129-001-005. This QA informed to ZPMC Quality Control (QC) identified as Mr. Huang Min and American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Chang of the above issue, As per ZPMC QC and

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AB/F QA the Crack Tack weld shall be removed by grinding and perform Magnetic Particle Testing(MT) for verifying no more defects.

Refer attached photos for additional details.

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005858.

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

1. 10TR2-007-008,009,011,012,005~007,010,013,014.
2. 10TR2-006-008,009,011,012,005~007,010,013,014.
3. 10TR1-014-008,009,011,012,005~007,010,013,014.
4. 10TR2-003-008,009,011,012,005~007,010,013,014.
5. 10TR2-008-008,009,011,012,005~007,010,013,014.
6. 10TR1-009-008,009,011,012,005~007,010,013,014.
7. 10TR3-026-008,009,011,012,005~007,010,013,014.
8. 10TR3-003-008,009,011,012,005~007,010,013,014.

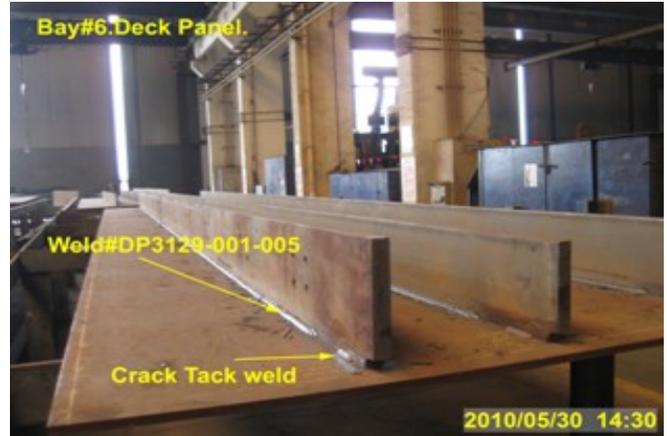
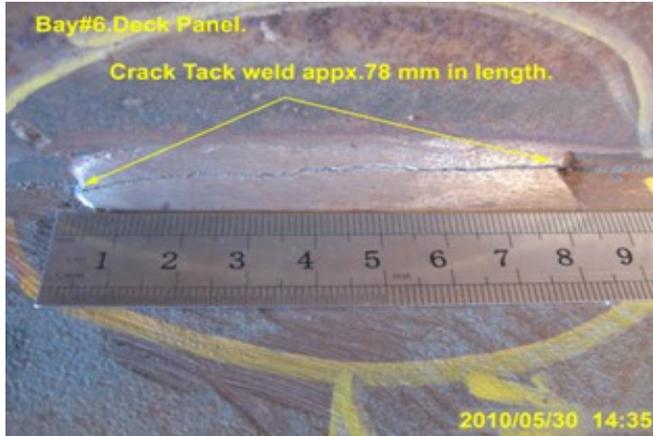
Shielded Metal Arc Welding (SMAW) Tack welding on Deck panel weld joint DP3082-001-0014/015. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

SMAW Repair Welding on Traveler Rail (TR) flange edge for the TR No identified as 22TR4-004. Welder is identified as 057795. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-1G (1F) Repair. The repair welding was been performed as per the Welding Repair Report (WRR) No: B-WR9612.

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
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Reviewed By:	Hall,Steven	QA Reviewer
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