

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-014723**Date Inspected:** 09-Jun-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 / Mr. Wuzhi Cheng	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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		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:

OBG TRIAL ASSEMBLY.

SEGMENT: 8AW-8BW.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding Repair welding of weld joint EP073-001-027. Welder is identified as 205718. ZPMC Quality Control (QC) is identified as Mr. Shi lei. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) –FCM-Repair-1. The repair welding was been performed as per the Welding Repair Report (WRR) No: B-WR13290. This weld was been rejected by ZPMC UT Technicians and recorded on UT Report no: B787-UT-13021.

SMAW Repair welding of weld joint EP073-001-028. Welder is identified as 205718. ZPMC Quality Control (QC) is identified as Mr. Shi lei. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) –FCM-Repair-1. The repair welding was been performed as per the Welding Repair Report (WRR) No: B-WR13291. This weld was been rejected by ZPMC UT Technicians and recorded on UT

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Report no: B787-UT-13021.

SMAW Repair welding of weld joint OBW8-002. Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Shi lei. The welding variables appeared to comply with the Applicable WPS:

WPS-345-SMAW-4G (4F) –FCM-Repair-1. The repair welding has been performed as per the Caltrans Engineer Approved Critical Welding Repair (CWR) No: B-CWR1597 Rev.1. This weld was rejected by American Bridge/Fluor (AB/F) QA Inspectors and recorded on AB/F UT Report no: UT-8W-031-R1.

SEGMENT: 8BW-8CW.

ZPMC Personnel performing match bolt drilling holes with splice plate for the “U” Rib transverse splice joint. Refer attached photo for reference.

SEGMENT: 9AW-9BW.

SMAW of weld joint OBW-9B-002. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS:

WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) of weld joint BP043-001-037. Welder is identified as 045240. 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-B-T-2233-B-U2a-F.

ZPMC Personnel performing weld flush grinding for the transverse splice weld joint at bottom and Side panel(Counter weight side). Refer attached photo for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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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
