

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-015158**Date Inspected:** 26-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. Zhu Tian Shu / Mr. Huang mi			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- 1

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) buttering welding of Traveler Rail 21TR3-002. Welder is identified as 216575. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair-1. The buttering was been performed as per the Critical Welding Report (CWR) No: B-CWR1568.

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 20TR1-030. Heat straightening was being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Report# HSR (B)-363 Rev.No:1. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng.

BAY- 2

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 20TR1-004. Heat straightening was

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being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Repot# HSR (B)-370. ZPMC Quality Control (QC) is identified as Mr. Cai Xiao Fang.

FCAW of weld joint FB3192-001-048/049. Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

BAY- 3

FCAW of weld joint FB3105-001-023. Welder is identified as 214945. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW of weld joint FB3123-001-027. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

BAY- 6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 006059.

Magnetic Particle Testing (MT)

This QA 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 West Jacking Frame weld Component. Total number of welds MT Tested: 12 No's. The weld designations are review as follows:

1. DP3129-001-011,012,006,007,001,002,014,015,009,010,004,005.

During the Quality Assurance (QA) random in process observations of the fabrication of OBG Deck Panel (DP) DP3072A, this QA Inspector observed ZPMC removed Seismic Performance Critical Member (SPCM) welds without the Engineer's approval. The weld joints are identified as DP3072-001-075 and 076. The welds are fillet weld T-joints, joining the Rib stiffener to the SPCM areas of Deck Panel DP3072A. SPCM Deck plate is identified as X3168A. The stiffener is identified as RS3112C.

This QA Inspector generated an incident report on this date for the above issue, for further information see the incident report and attached photos.

BAY- 7

FCAW of weld joint BP3043-001-013/014. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables recorded by QC appeared to comply with the Applicable WPS:

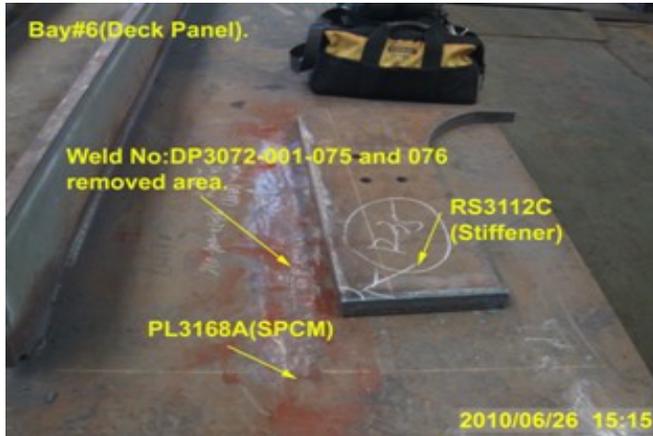
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WPS-B-T-2132-3.

FCAW of weld joint BP3043-001-021/022. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

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
