

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-015688**Date Inspected:** 08-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**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:

OBG TRIAL ASSEMBLY.

SEGMENT: 8AE -Panel Point (PP) # 61-64)

This QA performed Visual Testing (VT) and dimensional inspection on cope and weld access holes inside Orthotropic Box Girder (OBG) lift 8E. A number of the cope holes did not appear to comply with the contract documents. American Bridge Fluor (ABF) QA inspectors have previously inspected and accepted these cope holes and recorded their findings on ABF document CWAHIR-8AE-02 date 6/7/10.

This QA Inspector performed VT on bolt holes and gap checked between deck panel and Top plate for the below mentioned OBG Suspender Brackets. Inspection was performed as per the ZPMC submitted Notification No. 00007 Dated: June 08, 2010.

1. SB48W.
2. SB54W.

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This QA Inspector Randomly observed the following work in progress:

Lift: 7 West.

ZPMC personnel heat straightening OBG member identified as OBW7N-013/014. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Wang jie was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8474. Refer attached photo for reference.

Lift: 8East.

Flux Cored Arc Welding (FCAW) welding of weld joint FB028-010-128. 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-2232-TC-U4b-F.

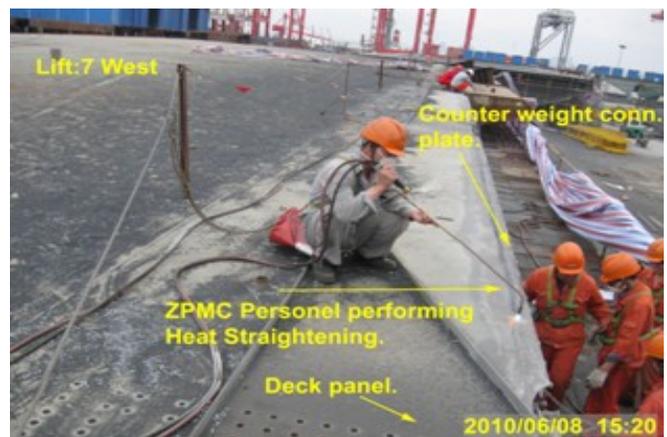
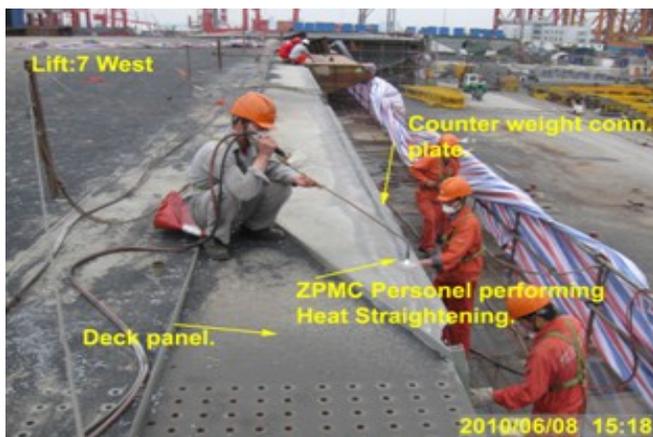
Lift: 9 West.

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW-9B-003. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Hai. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Bay # 7.

This QA received ZPMC inspection notification sheet 5923 to perform dimensional inspection of traveler rails identified as 10TR1-014 and 10TR3-003. Dimensional inspections performed on each of these traveler rails include, but is not limited to, overall length, beam sweep, beam camber, flange tilt and flange warpage. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurements survey: Traveler Rails and submitted to CT QA lead for review.

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
Reviewed By:	Hall,Steven	QA Reviewer
