

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-015466**Date Inspected:** 06-Jul-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
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- 5

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06133.

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 weld Components. Total number of welds UT Tested: 05 No's. The weld designations are review as follows:

1. 20TR2-002-009,011,013,015,017.

Signed off the following green tag:

1.13296.

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BAY- 6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06137.

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 Bottom Panel weld Components. Total number of welds MT Tested: 34 No's. The weld designations are review as follows:

1. BP3042-001-013,014,025,026,037,038,049,050,061,062.
2. BP3064-001-019,020,031,032,043,044,055,056,067,068
3. BP3067-001-013~024,037,038

Signed off the following green tags:

1. 13301 ~ 13303.

This QA Inspector Randomly observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint WJF-0-188. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables 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 2 (Two) Arc strikes on the Bottom Panel identified as BP3042-001 near to the weld No: BP3042-001-059. This QA informed to ZPMC Quality Control (QC) identified as Mr.Huang min and American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Liu Hua Jie of the above issue, As per ZPMC QC and AB/F QA the arc strikes shall be repaired by grinding and perform Magnetic Particle Testing(MT) for verifying no more defects.

Refer attached photos for additional details.

BAY- 7

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint EP3020-001-065/066. 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- P-2112.

SMAW Tack welding of weld joint EP3020-001-037/038. Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112. Refer the attached photos for reference.

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Flux Cored Arc Welding (FCAW) of weld joint BP3058-001-003/004. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Guo Pan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

ZPMC Personnel performing Heat Straightening for the Side Panel (SP) SP3064A. Heat straightening was being performed appeared to comply with the Applicable HSR Report# HSR1 (B)-8729 . ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng.

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
