

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017268**Date Inspected:** 05-Oct-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. Tian Lei /Mr. Xu xian ping	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:

BAY- 2

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint E5-SB1-003-126~131. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3329-001-011. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW of weld joint FB3327-001-059. Welder is identified as 045227. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

BAY- 3

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FCAW of weld joint FB3290-001-013,014. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW of weld joint FB3290-001-015,016. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

FCAW of weld joint FB3272-001-052. Welder is identified as 050242. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

FCAW of weld joint FB3273-001-024. Welder is identified as 05564. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

BAY- 6

Submerged Arc Welding (SAW) of weld joint CB3003F-019-001. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

BAY- 7

FCAW of weld joint FB3243-002-007,008. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Xu hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

During QA random in-process observations of the fabrication of OBG Cross Beam (CB) CB19 Corner Floor beam (FB)Diaphragms, this QA observed tack welds on Seismic Performance Critical Material (SPCM) that did not appear

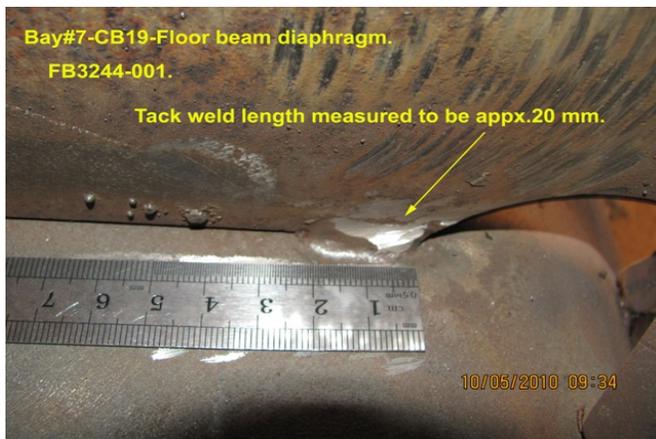
to comply with the minimum tack weld length requirement of AWS D1.5 2002. The welds are fillet weld T joints joining the Floor beam webs to flanges and stiffeners. The FB web, stiffener and flange plates are designated as Seismic Performance Critical Material (SPCM) on the approved shop drawings. The length of these tack welds, as measured by this QA, is approximately 20mm to 60 mm in length.

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

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
