

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017312**Date Inspected:** 12-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. Chen xi**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) of weld joint 9TR2-002-017. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-B-U2-F.

FCAW of weld joint 9TR1-002-017. Welder is identified as 216575. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-B-U2-F.

BAY- 2

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06927.

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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 Longitudinal diaphragm weld Components. Total number of welds MT Tested: 03 No's. The weld designations are review as follows:

1. LD3049-001-001~003.

FCAW of weld joint FB3320-001-003,004. Welder is identified as 067877. 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 E5-SB1-003-022,023. Welder is identified as 045240. 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 FB3349-001-013,014. Welder is identified as 070046. 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.

ZPMC UT Technicians performing Ultrasonic Testing for the welds located on SA3410A. Refer the attached photos for reference.

BAY- 3

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06930.

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 Floor beam weld Components. Total number of welds MT Tested: 56 No's. The weld designations are review as follows:

1. FB3262-001-017,022,023,027~030,034,035,040,043~046,049,052,055,057,063,066,067,078~080, 117,118,124, 126,127.
2. FB3280-001-003,007~010,013,014,017,018,027,029,037~039,041~046,030,051~053,058,061,062.

FCAW of weld joint FB3266-001-090,091. 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.

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BAY- 4

Submerged Arc Welding (SAW) of weld joint SA3359-001-001. Welder is identified as 050502. 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.

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