

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-018825**Date Inspected:** 24-Dec-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:

BAY- 1

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) Welding of weld joint identified as E2-SB21-026~028. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2132-ESAB.

ZPMC personnel performing bolt hole drilling for the steel barrier rail identified as E2-SB1-039. Refer the attached photos for reference.

BAY- 2

American Bridge/Flour QA Inspectors performing Magnetic Particle Testing for the Anchor plate AP3032A.

ZPMC personnel heat straightening OBG member identified as SA3415-002. Distortion appeared to be caused by

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welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Li jia was present to monitor the heat straightening process. The heat straightening appeared to comply with the Heat Straightening Report (HSR) HSR1 (B)-9974.

BAY- 3

Shielded Metal Arc Welding (SMAW) welding of weld joint SP3071-001-237,245. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2213-TC-U4b.

Flux Cored Arc Welding (FCAW) Buttering welding of side plate identified as SP3083A-PL3264A. Welder is identified as 208035. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with the Applicable WPS: WPS-345-FCAW-1G-ESAB-Repair. The repair welding was being performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR2390.

BAY- 4

This QA observed that no significant work was being performed in this bay during the time QA was present.

BAY- 8

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07905.

Visual Testing (VT)

This QA performed along with Caltrans QA Mr. Kelly bennet random VT of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. The members are identified as OBG bike path weld Components. The component designations are review as follows:

1. BK004A2-061-002,028,013,021.
2. BK004AS1-061-022~024,027,001~004.

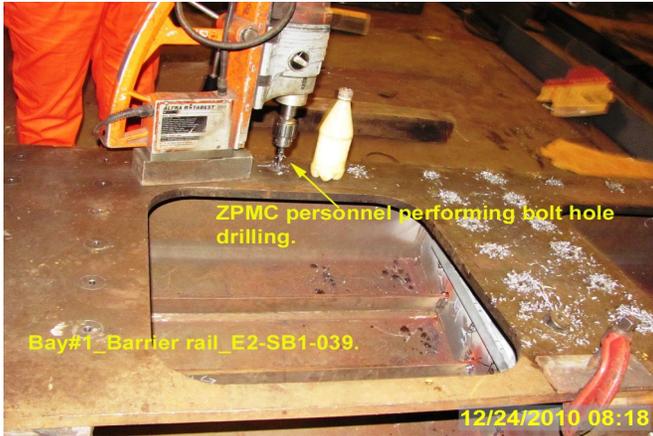
SMAW buttering Welding of weld stringer plate identified as BK004A-057-BKX8A. Welder is identified as 069894. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with Applicable the WPS: WPS-345-SMAW-3G(3F)-Repair.

SMAW welding of weld joint BK004A3-064-002,003. Welder is identified as 069894. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2211-TC-U4c.

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