

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-019401**Date Inspected:** 06-Jan-2011**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. Qiu wei**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 Assembly Bay- 14.

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.08065.

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 a UT report for this date. The member is identified as OBG weld Component. Total number of welds UT Tested: 1 No. The weld designation inspected was review as follows:

1. SEG3007J-048.

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020BB-055. Welder is identified as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

066695. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS:WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as SEG3020BB-037. Welder is identified as 068445. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as SEG3020BB-073. Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as SEG3020BB-064. Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW) Repair welding of weld joint identified as SEG3013F-080. Welder is identified as 066163. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-2G (2F)-FCM-Repair. The repair welding was being performed as per the Critical Welding Repair Report (CWR) No: B-CWR2598.

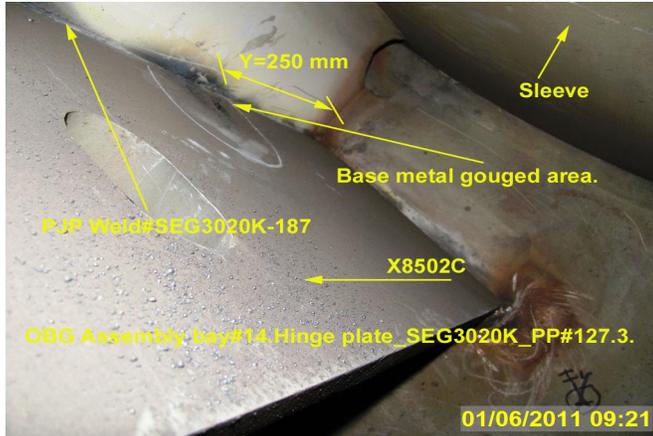
SMAW Repair welding of weld joint identified as SEG3013F-003. Welders are identified as 045221. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-2G (2F)-FCM-Repair. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR19195.

During random Visual Testing of OBG 14 West hinge plate SEG3020K at Panel Point 127.3(Counter weight side), this QA observed base metal gouged on Piece Mark (PCMK) identified as X8502C. The "Y" location is approximately 250 mm from south cope hole. This QA marked the affected area and measured the depth approximately 4mm and informed ZPMC Quality Control (QC) Certified Welding Inspector identified as Mr. An Qing xiang of this issue. Mr. An Qing xiang informed this QA that the gouged area would be corrected in a manner compliant with the contract documents. This QA also informed the above issue to shop Lead QA inspector (verbally). Refer the attached photos for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

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: Peterson,Art

QA Reviewer