

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-019849**Date Inspected:** 01-Feb-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 wen**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.

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as DP3148-001-243. Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of weld joint identified as DP3148-001-249. Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020H-176. Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang xiang pin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B--T-2231-ESAB.

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FCAW welding of weld joint identified as SEG3020F-063. Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Wang xiang pin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B--T-2231-ESAB.

FCAW welding of weld joint identified as DP3169-001-018. Welder is identified as 067888. American Bridge/Fluor (AB/F) QA is identified as Mr. Shao jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as DP3169-001-266. Welder is identified as 203781. American Bridge/Fluor (AB/F) QA is identified as Mr. Shao jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as DP3170-001-165. Welder is identified as 066239. American Bridge/Fluor (AB/F) QA is identified as Mr. Shao jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

SMAW welding of weld joint identified as DP3173-001-284. Welder is identified as 067707. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

During random in process inspection of member identified as 14 West Panel Point(PP)#128 longitudinal diaphragm LD3051A, this QA observed a cracked tack weld on weld joint identified as SEG3020Y-066. This weld is joining to LD3051A to stiffener plate (X4970N). The “Y” location is approximately 185 mm from nearest end of the stiffener plate. The “Y” location is measured from PP#128 side as shown on the picture below. This QA marked the cracked tack and informed ZPMC Quality Control (QC) identified as Mr. Wang xiang pin of this issue. Mr. Wang xiang pin informed this QA that the cracked tack would be corrected in a manner compliant with the contract documents prior to start the welding. Refer the attached photos for reference.

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



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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
