

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-020658**Date Inspected:** 16-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. An qing xiang**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) repair welding of Anchor plate bearing block (APBB) casting block identified as APBB1-095-14. Welder is identified as 066481. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

SMAW repair welding of APBB casting block identified as APBB1-094-4. Welder is identified as 066481. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

SMAW repair welding of APBB casting block identified as APBB1-099-2. Welder is identified as 066481. ZPMC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

SMAW repair welding of APBB casting block identified as APBB1-121-3. Welder is identified as 066481. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

SMAW repair welding of APBB casting block identified as APBB1-086-6. Welder is identified as 066481. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

SMAW repair welding of APBB casting block identified as APBB1-088-12. Welder is identified as 066481. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei and Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-casting-SMAW-1G-repair.-1 The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2784.

This QA Inspector randomly witnessed ZPMC QC personnel performing Magnetic Particle Testing (MT) for the above mentioned APBB1 casting blocks repair excavated areas. During random witness of MT this QA noted that ZPMC MT Technician observed one longitudinal linear indication measuring approximately 60 mm in length. This indication has been groundout at approximately 18 mm depth and MT retested found acceptable. Refer the attached photos for reference.

This QA Inspector measured the repair excavated depth, length, width and exact repair location for the following APBB and performed photo documentation. These photos have been sent to lead QA Inspector by mail.

1. APBB1-095-14
2. APBB1-094-4
3. APBB1-099-2
4. APBB1-121-3
5. APBB1-086-6
6. APBB1-088-12
7. APBB1-108-8
8. APBB1-122-3
9. APBB1-121-14

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