

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-021317**Date Inspected:** 01-Mar-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:

Sub assembly bay- 1

This QA received ZPMC inspection notification sheet 08422 to perform dimensional inspection of Traveler Tail (TR) identified as 9TR1-002. Dimensional inspections performed on this traveler rail include, but is not limited to overall length, beam sweep, beam camber, flange tilt and flange warpage. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurements survey: Traveler Rails and submitted to CT QA lead for review.

During dimensional inspection this QA Inspector observed that the vent holes have not drilled on tube. The TR's are identified as 9TR1-001,002,9TR2-001 and 002. The approved shop drawing identified as TR9 specify that vent holes placed on top and bottom of the tube identified as TRX1E. This QA marked the affected areas and informed ZPMC Quality Control (QC) Certified Welding Inspector identified as Mr. Tian lei and American Bridge/Fluor (AB/F) QA Inspector Mr. Wang of this issue. This QA Inspector informed to CT lead QA Inspector of this issue. Refer the attached photos for further information.

OBG Assembly bay- 14.

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This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013AA-116. Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013R-026. Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Liu fang. 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 SEG3013M-035. Welder is identified as 066002. ZPMC Quality Control (QC) is identified as Mr. Liu fang. 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 SEG3013P-061. Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Liu fang. 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 SEG3013F-025. Welder is identified as 066912. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

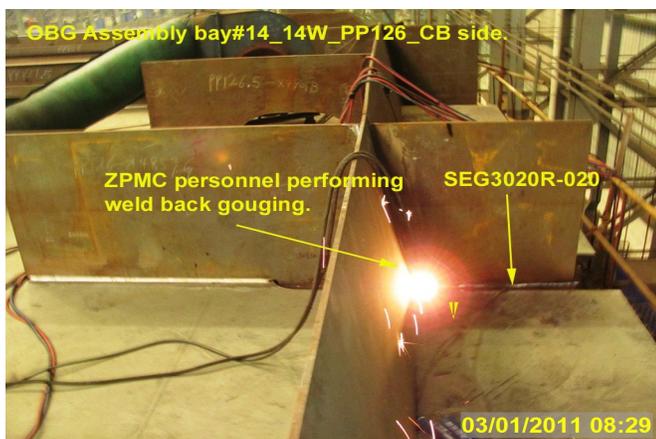
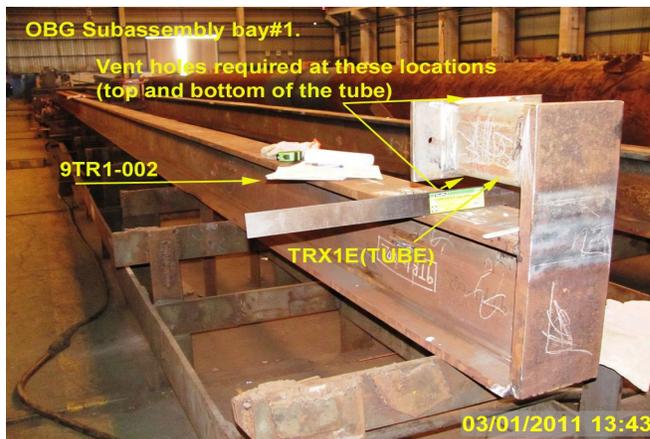
SMAW repair welding of weld joint identified as DP3174-001-034. Welder is identified as 067588. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-345-SMAW-2G (2F)-FCM-repair. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20289. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-19247.

ZPMC personnel performing weld back gouging for the weld identified as SEG3020R-020 at Panel Point no.126 Cross beam side. 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