

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-022263**Date Inspected:** 31-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. Shi zhi**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 08695 to perform dimensional inspection of Traveler Tail (TR) identified as 20TR2-038. Dimensional inspections performed on this traveler rail include, but is not limited to overall length, beam sweep, 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 and further action.

OBG Trial Assembly open yard.

Segment: 13AW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013AD-061,063. Welder is identified as 047864. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

personnel observed appeared to comply with Welding Procedure Specification (WPS):
WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013G-041,046. Welder is identified as 037779. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2112-FCM-1.

SMAW welding of weld joint identified as SEG3013AA-087. Welder is identified as 070432. ZPMC QC is identified as Mr. Shen jian bo. 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 SEG3013S-201,205. Welder is identified as 048433. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint identified as SEG3013M-040. Welder is identified as 048696. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

SMAW repair welding of weld joint identified as SEG3013AA-118. Welder is identified as 069683. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20525. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-20612.

AB/F QA Inspectors performing Ultrasonic Testing for the side panel to bottom panel at Panel point 119 cross beam side. See attached photos for further information.

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
