

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012008**Date Inspected:** 09-Feb-2010**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. Wuzhi Chang / Mr. Li Yang	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 TRIAL ASSEMBLY

This QA Inspector observed the following work in progress:

SEGMENT: Crossbeam CB6

Shielded Metal Arc Welding (SMAW) welding of weld joint CB202-006-018. Welder is identified as 067665. ZPMC Quality Control (QC) is identified as Mr. Wuzhi Chang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2214-TC-U4b-FCM-1.

Shielded Metal Arc Welding (SMAW) welding of weld joint CB202-006-003. Welder is identified as 066316. ZPMC Quality Control (QC) is identified as Mr. Wuzhi Chang. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-P-2214-TC-U4b-FCM-1.

SEGMENT: 6AW

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Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG027F-008. Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F)-FCM-Repair and Welding Repair Report (WRR) No: B-WR10627.

SEGMENT: 7BW-7CW

Flux Cored Arc Welding (FCAW) welding of weld joint BP090-001-48. Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

Flux Cored Arc Welding (FCAW) welding of weld joint SP439-001-061. Welder is identified as 048696. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

SEGMENT: 6AW-6BW

ZPMC Quality Control (QC) MT Technician Mr. Chang Fang jie was performing Magnetic Particle Inspection (MT) for base metal linear indication excavated area which was found previously by MT. This QA witnessed indication excavation process and after excavation the area has been re inspected by MT and found acceptable. The detail of excavation process is below and the attached photographs provide additional detail.

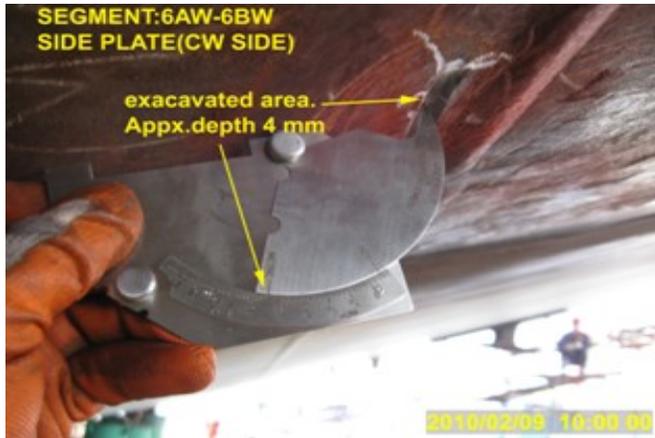
- The indication was removed at approximately 4 mm depth.
- The excavated area on base metal measuring approximately 65 mm in length.
- The nearest weld is identified as: OBW6B-002.
- The distance from the longitudinal weld and weld no OBW6B-002 approximately 13 mm and 48 mm Respectively.
- Segment 6AW-6BW is located near the OBG TRIAL ASSEMBLY AREA.

This QA notified ZPMC QC identified as Mr. Wuzhi Chang and ABF inspector identified as Mr.Zhuhu was present at site during this time.

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

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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

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: Miller,Mark QA Reviewer