

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012009**Date Inspected:** 07-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**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: 7AW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG033A-004. Welder is identified as 037932. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) FCM-Repair-1 and Welding Repair Report (WRR) No: B-WR10059.

Flux Cored Arc Welding (FCAW) welding of Repair weld joint SEG033B-011. Welder is identified as 220066. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-3G (3F)-Repair and Welding Repair Report (WRR) No: B-WR10059.

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SEGMENT: 7AW-7BW

Shielded Metal Arc Welding (SMAW) welding of weld joint DP639-001-19. Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3213-B-U3b.

SEGMENT: 7BW-7CW

Flux Cored Arc Welding (FCAW) welding of weld joint BP036-001-32. Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233T.

SEGMENT: 6AW-6BW

ZPMC Quality Control (QC) MT Technician Mr. Tan Chao Wei was performing Magnetic Particle Inspection (MT) for welds located on Segment: 6AW-6BW

During Random Witness of MT this QA discovered the following issue:

- One (1) linear indication observed on base metal, measuring approximately 63 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 50 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 and Mr. Ding of the above issue.

The attached photographs provide additional detail.

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