

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012163**Date Inspected:** 16-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. 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 Randomly observed the following work in progress:

SEGMENT: 6AW

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-2G (2F)-FCM-Repair and Welding Repair Report (WRR) No: B-WR10627.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) for Base metal damaged area at Crossbeam side for Segment 6AW. The welder was identified as 067665. ZPMC Quality Control (QC) Certified Welding Inspector (CWI) is identified as Mr. Li Yang. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-SMAW-2G (2F)-FCM-Repair. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS and the base metal repair has

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR10667.

(The attached photographs provide additional detail.)

ZPMC Tack welding personnel performing Shielded Metal Arc Welding (SMAW) for Deck panel to counter weight connection plate. The tack welder was identified as 205770. ZPMC Quality Control (QC) is identified as Mr. He Yannbing.

(The attached photographs provide additional detail.)

SEGMENT: Crossbeam CB5

ZPMC QC MT Technician Mr. Tan Chao Wei was performing Magnetic Particle Testing (MT) for CB5 on base metal temporary jig removed area.

(The attached photographs provide additional detail.)

SEGMENT: 5AE

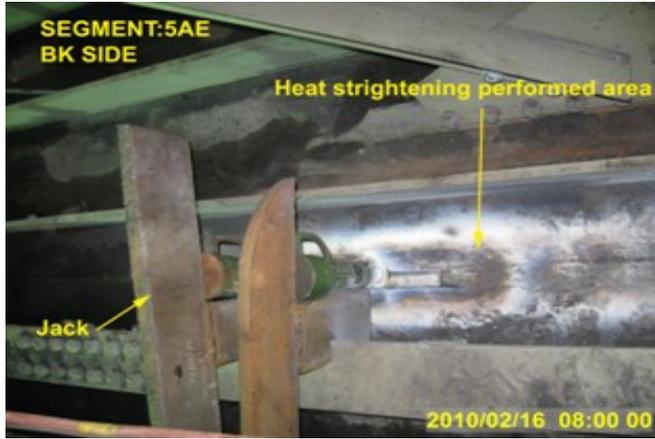
This QA Inspector observed ZPMC personnel performing Heat Straightening on weld joint no: SEG022A-10. The weld is connecting to Side plate (SP304A) and Side plate (SP423A). Plate thickness is 18 mm. Against Caltrans Engineer approved document No: HSR (B)-352.Rev 0. ZPMC Quality Control (QC) is identified as Mr. Wang Xu. (The attached photographs provide additional detail.)

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:

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
