

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-012341**Date Inspected:** 28-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**SEGMENT: 6BE**

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005241

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The member is identified as OBG Segment: 6BE Component. The weld designation reviewed as: SEG030A-010.MT performed on Heat Straightening performed area only.

SEGMENT: 6CW (Panel Point#44~45)

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005242

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This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The member is identified as OBG Segment: 6CW Component. The weld designations are reviewed as follows:
(MT has been performed to removal of punch list items #406&407.)

1. SP516-001-085~090.
2. SP516-002-082,083.
3. SP476-001-099~106.
4. SP476-002-107~120.

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 6AW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SSD11A-PP039-168. Welder is identified as 054467. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G (4F) FCM-Repair-1 .The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR 10688 Rev-0. And ZPMC UT report # B787-UT-10646.

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW6F-003. Welder is identified as 037840. ZPMC Quality Control (QC) is identified as Mr.Zhang Yong Gong. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.
(See attached photographs)

SEGMENT: 6BW-6CW

This QA Inspector observed ZPMC QC MT Technician Mr.Tan Chao Wei was performing Magnetic Particle Testing (MT) for OBG Segment 6BW-6CW (Panel Point #43-44) on “T”Rib hold back welds connected to bottom plate.
(See attached photographs)

SEGMENT: 6CW

This QA Inspector observed ZPMC personnel’s at Segment 6CW side panel T-Ribs between PP 44 to 44.5 bolts snug tightening is in progress.
(See attached photographs)

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