

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-012587**Date Inspected:** 07-Mar-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

LIFT: 7-East -Panel Point (PP) #48~55.

This QA Inspector Randomly performed joint Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Panels flatness measured at Lift-7 East between PP#48~55. The flatness deformation was measured only at location which were accessible using available scaffolding. The following location is not comply with the contract document.

During random flatness inspection this Caltrans Quality Assurance Inspector (QA) observed a following Issues:

- The Deformation was measured to be approximately 19 mm in 2250 mm Maximum template size.
- The Segment and Panel Point no is 7BE-PP#50 Facing West at Bike Path(BK) Side.

This QA generated a report on this date for the above issue and submitted to the Task Leader for further action.

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The attached photographs provide additional detail.

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 048659. 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 .The repair welding was performed against the Welding Repair Report (WRR) No: B-WR10688 and ZPMC Ultrasonic Testing (UT) Report No: B787-UT-10646, dated: 02/16/2010.

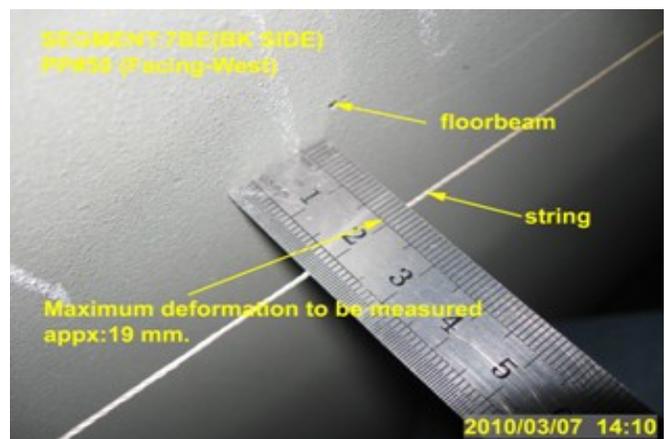
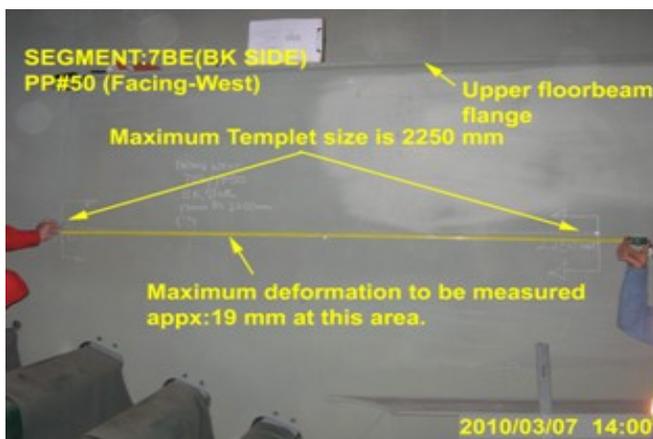
SEGMENT: 6CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA030-005. 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-1G (1F) FCM-Repair-1 .The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR10758 and ZPMC Ultrasonic Testing (UT) Report No: B787-UT-11441, dated: 02/26/2010.

SEGMENT: 6AE

This QA Inspector observed American Bridge/Fluor (AB/F) QC MT Technicians Mr.Chen Wen jun and Mr.He Zhishun was performing Magnetic Particle Testing (MT) for OBG Segment 6AE (Panel Point #39&40) on Stiffener Hold back welds.

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



Summary of Conversations:

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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
