

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-012693**Date Inspected:** 09-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. 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

LIFT: 6-East (Individual Survey by Caltrans)

This QA Inspector along with Caltrans QA Mr. Manjunath Math performed Joint Inspection for the Deck panel to Deck panel diaphragm offset measured for LIFT:6-East between Panel Point (PP) 38~43. Total number of readings taken 234 no's. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

The maximum offset readings noted in each Panel Points as follows:

1. Segment: 6AE-PP#38, Survey point: 5 (West side), Maximum offset reading is: 6.5 mm.
2. Segment: 6AE-PP#39, Survey point: 28 (West side), Maximum offset reading is: 15.5 mm.
3. Segment: 6AE-PP#40, Survey point: 29 and 31 (West side), Maximum offset reading is: 11 mm.

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4. Segment: 6AE-PP#41, Survey point: 29 (West side), Maximum offset reading is: 9.5 mm.

5. Segment: 6AE-PP#42, Survey point: 5 (West side), Maximum offset reading is: 6.5 mm.

6. Segment: 6AE-PP#43, Survey point: 11 (West side), Maximum offset reading is: 8.5 mm.

The attached photograph provide additional detail of item number 2 (see above) of maximum deformation measured method.

SEGMENT: 6AE-6BE - PP#40-41.

This QA Inspector observed ZPMC Personnel's performing bolt tightening for the U-Ribs to U-Ribs internal splice plate at Segment 6AE-6BE-PP#40-41(Crossbeam side).

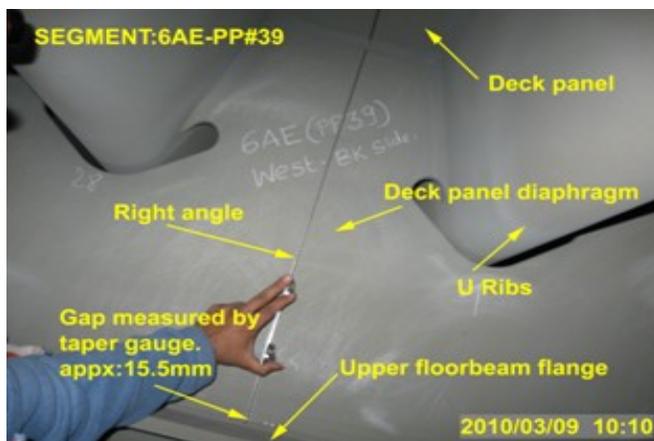
The attached photograph provide additional detail

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 6AW – PP#38(FL3 Location)

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SSD10A-PP038-170. 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 been performed against the Welding Repair Report (WRR) No: B-WR10687 and ZPMC Ultrasonic Testing (UT) Report No: B787-UT-10646, dated: 02/16/2010.

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
