

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-012699**Date Inspected:** 18-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. Wang Li Yang /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 Randomly observed the following work in progress:

SEGMENT: 7BW-7CW

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW7-007. Welder is identified as 066326. 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-P-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW7-008. Welder is identified as 066361. 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-P-2214-B-U2-FCM-1.

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW7-009. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appeared to comply

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with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

SEGMENT: 7BE-7CE

Shielded Metal Arc Welding (SMAW) welding of weld joint OBE7C-008. Welder is identified as 067572. ZPMC Quality Control (QC) is identified as Mr. Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

SEGMENT: 7CW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA037-004. Welder is identified as 066028. ZPMC Quality Control (QC) is identified as Mr. Sun Bai Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F) FCM-Repair-1. The repair welding was performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1228 and American Bridge/Fluor (AB/F) UT report # UT-7W-027 dated: 03/07/2010.

SEGMENT: 6BE –Panel Point (PP) #42.5.

This QA Inspector observed ZPMC Personnel's performing Final bolt tightening for the Walk way support at SEGMENT: 6BE –PP #42.5.

The attached photographs provide additional detail.

SEGMENT: 7AE PP#48.

This QA Inspector observed ZPMC MT Technician performing Magnetic Particle Testing (MT) for Bottom panel T Rib Holdback fillet welds at SEGMENT: 7AE PP#48.

The attached photographs provide additional detail.

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



Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

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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
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Reviewed By:	Miller,Mark	QA Reviewer
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