

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-013078**Date Inspected:** 28-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

This QA Inspector Randomly observed the following work in progress:

SEGMENT: 7BE Deck Panel to Edge Panel (Bike Path Side).

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG036-047. Welder is identified as 058087. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. 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 been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1325 Rev. No: 0 and American Bridge/Fluor (AB/F) UT report # UT-7E-033 dated: 03/14/2010.

SEGMENT: 7CE Deck Panel to Edge Panel (Bike Path Side).

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA040-004. Welder is identified as 048047/051359. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by

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QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F) FCM-Repair-1 .The repair welding was been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1227 Rev. No: 1 and American Bridge/Fluor (AB/F) UT report # UT-7E-032R1 dated: 03/24/2010.

SEGMENT: 7BE-7CE, PP #52~53,Corner Assembly, Crossbeam (CB)side.

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint DP656-001-021. Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Zhang Sheng Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-485-SMAW-3G (3F) FCM-Repair. The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR 11356 Rev.No:0.

SEGMENT: 7AW, PP#47.5, CB Side.

Flux Cored Arc Welding (FCAW) welding of Repair weld joint SP437-001-019. Welder is identified as 220063. 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-FCAW-2G (2F)-Repair. The repair welding was been performed against the Welding Repair Report (WRR) No: B-WR 11447 Rev.No:0.

SEGMENT: 7BE, PP#51,CB Side (FL3 Location).

Flux Cored Arc Welding (FCAW) welding of weld joint SSD27-PP051-043. Welder is identified as 220066. 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-T-2132.

SEGMENT: 7BE-7CE, PP#52-53, Side panel, CB side.

This QA Inspector observed American Bridge/Fluor (AB/F) QA Inspector Mr.Tao Linying was performing Magnetic Particle Testing (MT) for Side panel ‘T’ Rib Holdback fillet welds at SEGMENT: 7BE-7CE, PP#52-53, Side panel, CB side.

The attached photographs provide additional detail.

SEGMENT: 7BE, Deck panel to Edge panel (CB Side).

This QA Inspector observed ZPMC MT Technician Mr.Liu Zhang Min was performing Magnetic Particle Testing (MT) for Deck panel to Edge panel Repair weld excavated area.

The attached photographs provide additional detail.

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
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Reviewed By:	Miller,Mark	QA Reviewer
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