

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-013084**Date Inspected:** 21-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 Cheng**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: 7AE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA036-004. This weld joins the Deck Panel to the Edge panel. Welder is identified as 051359. 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 1224 Rev. No:1 and American Bridge/Fluor (AB/F) UT report # UT-7E-030R1 dated: 03/18/2010.

SEGMENT: 7BE

Shielded Metal Arc Welding (SMAW) welding of weld joint EP90-013. Welder is identified as 037932. ZPMC

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Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2211-B-U2-FCM-1.

SEGMENT: 7BE-7CE

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG036A-028. Welder is identified as 037743. 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-B-P-2212-TC-U4b-FCM-1.

SEGMENT: 7CE

Shielded Metal Arc Welding (SMAW) welding of weld joint CA034-001. Welder is identified as 037743. 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-B-P-2212-TC-U4b-FCM-1.

SEGMENT: 7AW-7BW

Shielded Metal Arc Welding (SMAW) welding of Base Metal Repair (BMR) at Segment 7AW-7BW Temporary jig removed areas. Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Zhang Hai Tao . 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 11052 Rev.No:0.

The attached photographs provide additional detail.

SEGMENT: 7CW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA037-004. This weld joins the Deck Panel to the Edge panel. Welder is identified as 066422. 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 been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1228 Rev.No:0 and AB/F UT report # UT-7W-027 dated: 03/07/2010.

SEGMENT: 7AE-7BE-Panel Point(PP)#49-49.5.

This QA Inspector observed ZPMC UT Technician Mr.Xu Rong gang was performing Ultrasonic Testing (UT) on Transverse splice "T" Rib web to web Complete Joint Penetration (CJP) welds at Bottom Panel.

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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