

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-013085**Date Inspected:** 20-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 weld joint CA033-006. This weld joins the Deck Panel to the Edge panel. Welder is identified as 037932. 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-2214-TC-U4b-FCM-1.

SEGMENT: 7BE

Shielded Metal Arc Welding (SMAW) welding of weld joint CA036-006. This weld joins the Deck Panel to the Edge panel. Welder is identified as 037932. 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-2214-TC-U4b-FCM-1.

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SEGMENT: 7CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA039-004. This weld joins the Deck Panel to the Edge panel. Welder is identified as 048047. 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 1227 and American Bridge/Fluor (AB/F) UT report # UT-7E-031 dated: 02/27/2010.

SEGMENT: 7AW

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint SEG033A-004. This weld joins the Side Panel to the Bottom panel. Welder is identified as 048659. 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-1G (1F) FCM-Repair-1 .The repair welding was been performed against the Caltrans Engineer Approved Critical Welding Repair Report (CWR) No: B-CWR 1212 Rev.1 and AB/F UT report # UT-7W-023R1 dated: 03/02/2010.

SEGMENT: 7AE-7BE.

This QA Inspector observed ZPMC MT Technician Mr.Liu Zhang Min was performing MT on Transverse splice weld flush ground area and temporary jig removed repaired areas for Side panel at SEGMENT: 7AE-7BE Crossbeam side.

The attached photographs provide additional detail.

SEGMENT: 6AW-Panel Point (PP) #38.

This QA Inspector observed ZPMC personnel at Segment 6AW - FL3 Location bolts installation was in progress. The attached photographs provide additional detail.



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Summary of Conversations:

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

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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