

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013703**Date Inspected:** 22-Apr-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. Zhu Tian Shu**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:

This QA Inspector Randomly observed the following work in progress:

BAY-1- Traveler Rail (TR)

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-028-009. Welder is identified as 251246. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW welding of weld joint 20TR2-036-011. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

FCAW welding of weld joint 20TR1-039-003. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW welding of weld joint 20TR2-040-003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

BAY-2-Floor Beam (FB)

Submerged Arc Welding (SAW) welding of weld joint FB3184-001-002. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3c-S-2.

The attached photographs provide additional detail.

SAW welding of weld joint FB3186-001-005. Welder is identified as 045270. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3c-S-2.

FCAW welding of weld joint FB3189-001-014. Welder is identified as 045203. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B- U3a-F-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005571.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The member is identified as FB weld Components. Total number of welds UT Tested: No's. The weld designations are review as follows:

1. FB3171-001-002,FB3232-001-002,FB3230-001-002.
2. FB3207-001-002,FB3223-001-001,FB3197-001-057.
3. FB3211-001-001,FB3180-001-002,005,FB3238-001-006,FB3236-001-018.
4. FB3219-001-002.

BAY-3-FB.

This QA Inspector observed ZPMC Tack welder was performing Tack welding by SMAW process for the FB weld joint FB3102-001-011. The tack welder was identified as 203176. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu The tack welding was being performed against the Caltrans Engineer approved Welding Procedure Specification (WPS): WPS-B-P-2112.

The attached photographs provide additional detail.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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:	Hall,Steven	QA Reviewer
