

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-014058**Date Inspected:** 10-May-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 Jia**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:

BAY-5

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005702.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Traveler Rail bracket weld Components. Total number of welds MT Tested: 10 No's. The weld designations are review as follows:

1. TR6A-PP100, 108-002.
2. TR6C-PP100, 104-005.
3. TR1B-PP107-003.
4. TR1C-PP102-005.

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5. TR1D-PP099-007.
6. TR2A-PP100-001.
7. TR5B-PP099-004.
8. TR5C-PP103-005.

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This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) on Traveler Rail (TR) bracket weld joint TR6B-PP048-004. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4c-F.

FCAW on TR bracket weld joint TR5B-PP071-003. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4c-F.

FCAW on TR bracket weld joint TR6A-PP048-001. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4c-F.

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Shielded Metal Arc Welding (SMAW) Tack welding on Deck panel weld joint DP3153-001-031. Welder is identified as 046813. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

SMAW Tack welding on Deck panel weld joint DP3126-001-122. Welder is identified as 250833. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

SMAW Tack welding on Deck panel weld joint DP3126-001-124. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-4112-4.

This QA Inspector observed ZPMC Personnel performing Heat Straightening for the 22TR2-002. Heat Straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8051. ZPMC Quality Control (QC) is identified as Mr. Wang Jian.

BAY-9

FCAW on Deck Panel weld joint DP3150-001-149. Welder is identified as 062265. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233-TC-U4b-F.

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Refer attached photos for reference.

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.

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
