

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-014235**Date Inspected:** 19-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. Tian Lei**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) / Tower**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-1

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint 20TR2-028-015. Welder is identified as 251246. ZPMC Quality Control (QC) is identified as Mr. Xian Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-F.

BAY-2

Submerged Arc Welding (SAW) welding of weld joint FB3192-001-011. 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.

BAY:6 (TOWER).

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005549.

Magnetic Particle Testing (MT)

This QA 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 member is identified as Tower- 9M Exterior Diaphragm weld Components. Total number of welds MT Tested: 08 No's. The weld designations are review as follows:

1. WD1-A8-3, 4, 61, 62.
2. ED1-A8-3, 4, 61, 62.

During Quality Assurance Magnetic Particle Testing (MT) review of welds located on Tower 9M Exterior diaphragm , this QA Inspector observed One (1) Longitudinal Linear indication measuring approximately 55 mm in length.The weld is identified as: WD1-A8-3.The weld measured to be an 8mm fillet weld.

This QA Inspector generated an incident report for the above issue on this date. for further information see the incident report and attached photographs.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted notification No: 005549.

Visual Inspection (VT)

This QA Inspector performed VT of the area previously tested and accepted by ZPMC QC Personnel. The member is identified as Tower- 9M Exterior Diaphragm weld Components. The weld designations are review as follows:

1. WD1-A8-3, 4, 61, 62.
2. ED1-A8-3, 4, 61, 62.

Signed off the following Green Tags on this date.

- 1.11650.
- 2.11651.

LAY DOWN NYARD.

SEGMENT:10AE-Panel Point#86~88.

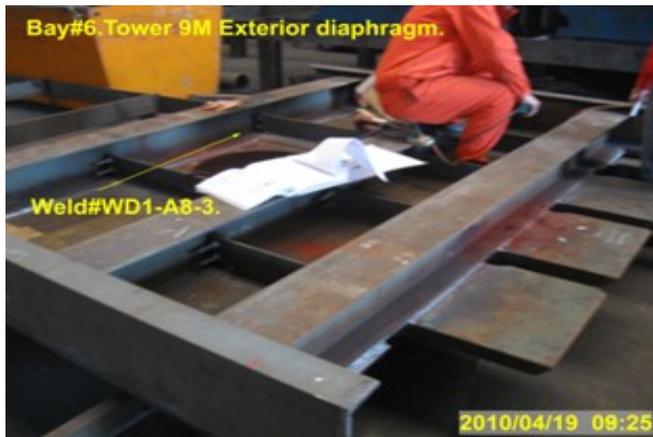
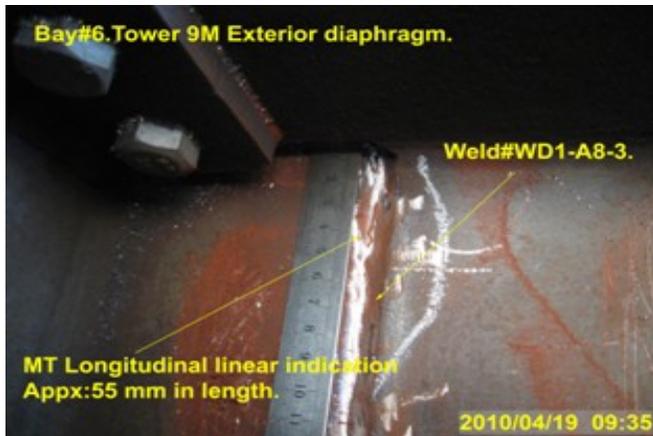
This QA Inspector witnessed and randomly measured 'T' Rib cope holes buckling areas by using 150 mm long steel scale at FL3 Location along with American Bridge/Fluor (AB/F) QA Inspectors Mr.Wang Heng and Mr. Wang Chao at Segment: 10AE-Panel Point#86~88. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

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This QA Inspector witnessed and randomly measured 'T' Rib Horizontal and vertical offset by using 1000 mm long scale and Cambridge respectively at FL3 Location along with American Bridge/Fluor (AB/F) QA Inspectors Mr. Wang Heng and Mr. Wang Chao at Segment: 10AE-Panel Point#86~88. The measured readings were data recorded, generated the report and submitted to the Task Leader for further action.

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/Skyler 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer