

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-014434**Date Inspected:** 24-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. Xu Xian ping**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. 005814.

Visual Testing (VT)

This QA Inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. The members are identified as OBG Traveler Rail Bracket weld Components. Total number of brackets VT Tested: 37 No's. The component designations are review as follows:

1. TR6A-PP048, 060, 064, 066, 070, 062, 068.
2. TR5B-PP067, 049, 063, 069, 065, 071, 061.
3. TR5D-PP051, 069, 063.
4. TR6C-PP050, 070, 064.
5. TR6B-PP048, 066.

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6. TR5C-PP071, 061, 065,067.
7. TR2A-PP058, 060, 056,054,050,048.
8. TR1A-PP053, 055, 059,057,051.

Signed off following green tag.

1. 12431.

BAY-6

This QA Inspector Randomly observed the following work in progress:

ZPMC Personnel performing Heat Straightening for the Deck Panel DP3096-001. Heat Straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8498. ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua.

BAY-7

Flux Cored Arc Welding (FCAW) of weld joint DP3153-001-029/030. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

FCAW of weld joint DP3153-001-041/042. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-4132.

FCAW buttering welding of Traveler Rail 22TR3-003. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair-1. The repair welding was been performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR1374.

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 22TR2-001. Heat straightening was being performed appeared to comply with the Applicable HSR Repot# HSR1 (B)-8051. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie.

OBG TRIAL ASSEMBLY.

This QA Inspector was inspected the final bolt tension verification on date 18th May 2010 and 22nd May 2010. Inspected 10% on a random basis and found the tension to be in general compliance thus this QA Inspector signed off the following green tags on this date.

1. 863~868.
2. 885~901.

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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
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Reviewed By:	Hall,Steven	QA Reviewer
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