

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-014645**Date Inspected:** 05-Jun-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. Huang Min**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.

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) buttering welding of Traveler Rail 20TR2-008. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair-1. The Buttering welding was been performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR1582.

BAY-6.

ZPMC Personnel performing Heat Straightening for the Deck Panel DP3142-001. Heat straightening was being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Report# HSR (B)-368. ZPMC Quality Control (QC) is identified as Mr. Shu Yang hua.

Submerged Arc Welding (SAW) of weld joint WJF-0-195. Welder is identified as 054458. ZPMC Quality Control

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(QC) is identified as Mr. Zhao jian hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3221-TC-U4a-S-1.

BAY-7.

Shielded Metal Arc Welding (SMAW) Tack welding on Bottom panel weld joint BP3057-001-0014. Welder is identified as 203204. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2112-FCM.

American Bridge/Fluor (AB/F) QA Inspector was performing Magnetic Particle Testing for the Deck panel tack weld joint number identified as DP3042-001-014.

Refer attached photos for additional details.

BAY-8.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005900.

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 weld Components. Total number of welds MT Tested: 70 No's. The weld designations are review as follows:

1. 10TR1-027-005~014.
2. 11TR3-002-005~014.
3. 11TR12-002-005~014.
4. 11TR8-002-005~014.
5. 11TR11-001-005~014.
6. 11TR10-002-005~014.
7. 11TR10-001-005~014.

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

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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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