

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-015034**Date Inspected:** 20-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. Chen Xi**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

Flux Cored Arc Welding (FCAW) buttering welding of Traveler Rail 20TR1-022. Welder is identified as 216575. 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-345-FCAW-1G (1F)-Repair-1. The buttering was been performed as per the Critical Welding Report (CWR) No: B-CWR1568.

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 21TR2-002. Heat straightening was being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Report# HSR (B)-363 Rev.No:1. ZPMC Quality Control (QC) is identified as Mr. Ai Wei.

BAY- 2

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 20TR1-007. Heat straightening was

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being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Repot# HSR (B)-370. ZPMC Quality Control (QC) is identified as Mr. Cai Xiao Fang.

FCAW of weld joint FB3191-001-019/020. Welder is identified as 067079. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

FCAW of weld joint FB3191-001-0025/026. Welder is identified as 067947. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-3.

BAY- 3

FCAW of weld joint FB3150-001-043 and 044. Welders are identified as 208035 and 050977 respectively. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-F.

FCAW of weld joint FB3158-001-009. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-TC-U4b-F.

FCAW of weld joint FB3146-001-082. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132-F.

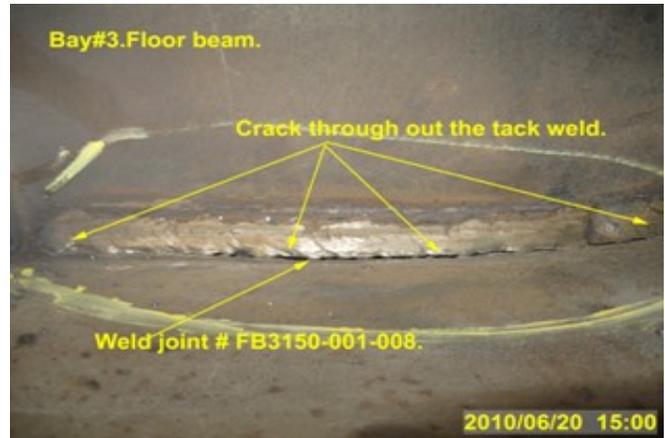
During random in process Visual Inspection this QA Inspector observed 1 (one) Crack tack on Floor beam weld joint No: FB3150-001-008. This QA informed to ZPMC Quality Control (QC) identified as Mr. Zhan hai feng and American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Wang wen bin of the above issue, As per ZPMC QC and AB/F QA the Tack weld shall be removed by grinding and perform Magnetic Particle Testing (MT) for verifying no more defects prior to start the final welding.

Refer attached photos for additional details.

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
Reviewed By:	Hall,Steven	QA Reviewer
