

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-015163**Date Inspected:** 19-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:

BAY- 1

This QA Inspector Randomly observed the following work in progress:

ZPMC Personnel performing Heat Straightening for the Traveler Rail (TR) 21TR1-002. 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

Flux Cored Arc Welding (FCAW) of weld joint FB3188-001-048/049. 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 FB3188-001-016/017. 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:

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WPS-B-T-2132-3.

Shielded Metal Arc Welding(SMAW)Tack welding of weld joint FB3172-001-071/072. Welder is identified as 069894. 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-P-2112-FCM.

ZPMC MT Technician was performing Magnetic Particle Testing (MT) for the Floor beam weld joint are identified as FB3222-001-003/004/006.Refer attached photos for reference.

BAY- 3

FCAW of weld joint FB3110-001-047. Welder is identified as 052696. 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-2233-TC-U4b-F.

FCAW of weld joint FB3125-001-094 and 095. 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-2132-3.

FCAW of weld joint FB3109-001-011 and 012. Welders are identified as 206623and 055564 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-2231-TC-U4b-F.

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.

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Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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