

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-015207**Date Inspected:** 16-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. Li Zhi jing**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) 21TR3-002. Heat straightening was being performed appeared to comply with the Caltrans Engineer approved Applicable HSR Report# HSR (B)-363. ZPMC Quality Control (QC) is identified as Mr. Xiang Feng Feng.

BAY- 2

Flux Cored Arc Welding (FCAW) of weld joint FB3184-001-029/030. Welder is identified as 067079. 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-2132-3.

BAY- 3

FCAW of weld joint FB3126-001-129/130. Welder is identified as 048038. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables recorded by QC appeared to comply with the Applicable

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WPS: WPS-B-T-2132-3.

TOWER JETTY

This QA Inspector witnessed final Bolt tension verification for the Lift 1 East and South Tower Grating supports. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed as per the ZPMC submitted Notification No. 00384 and 00386, dated: June 16, 2010.

Details of bolt size, RC Set # and final torque value are as follows:

Bolt sizes used were M22X55, RC Set# DHGM220011 and final torque value was 457 N-m.

Bolt sizes used were M22X110, RC Set# DHGM220067 and final torque value was 687 N-m.

Manual Torque wrenches were used with serial number noted as XO2-687.

Some locations are not ready for the inspection, all those information noted in the NDT tracking sheet and submitted to Team Leader.

During Quality Assurance Inspection of fabrication in East Tower Lift 1 this Caltrans Quality Assurance (QA) Inspector observed Three (3) additional bolt holes at 43m. These additional holes are deviation from the approved contract drawings. ZPMC personnel installed four (4) bolts into slotted/elongated holes at 38m for the ladder support.

This QA Inspector generated an incident report for the above issue, for further information see the incident report and attached photos.

OBG TRIAL ASSEMBLY.

Signed off green tags.

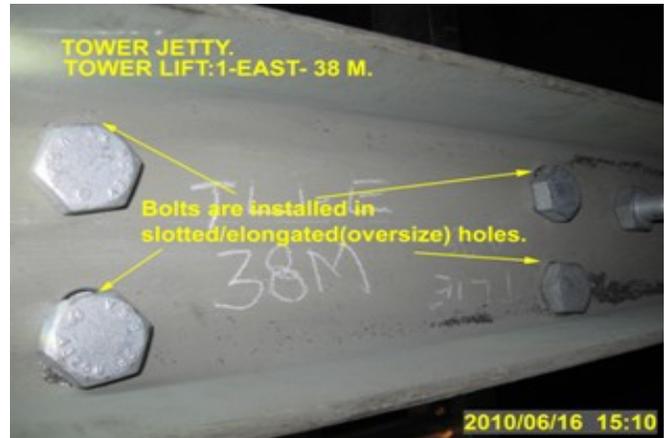
This QA Inspector signed off the following green tags on this date. Bolt Tension random verification witnessed on June 7th 2010.

1. 928~932.

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 /Michael Ng 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer