

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-015574**Date Inspected:** 08-Jul-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 / 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. 06150.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The members are identified as OBG Traveler Rail bracket weld Components. Total number of welds UT Tested: 05 No's. The weld designations are review as follows:

1. TR1A-PP095-001
2. TR2A-PP096-001
3. TR5B-PP095, 097-004
4. TR5C-PP095-005

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY- 6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06156.

Magnetic Particle Testing (MT)

This QA 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 Bottom and Side Panel weld Components. Total number of welds MT Tested: 70 No's. The weld designations are review as follows:

1. BP3066-001-025~036,047,048.
2. BP3043-001-025~036,045,046
3. BP3048-001-001,002,013~024,047,048,050,052.
4. BP3069-001-025~036,047,048
5. SP3061-001-021~030

Signed off the following green tag:

1. 1309~13313.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-446. Welder is identified as 053753. ZPMC Quality Control (QC) is identified as Mr. Huang min. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3112-1.

Submerged Arc Welding (SAW) of weld joint WJF-0-187. Welder is identified as 054458. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3221-TC-U4a-S-1.

BAY- 7

SMAW Tack welding of weld joint EP3022-001-021/022. Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112. Refer the attached photo for reference.

Flux Cored Arc Welding (FCAW) of weld joint SP3096-001-023/024. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3. Refer the attached photo for reference.

FCAW of weld joint SP3096-001-027/028. Welder is identified as 217185. ZPMC Quality Control (QC) is

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2132-3. Refer the attached photo for reference.

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
Reviewed By:	Hall,Steven	QA Reviewer
