

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-015685**Date Inspected:** 15-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**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- 6

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06204.

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 Plate weld Components. Total number of welds MT Tested: 26 No's. The weld designations are review as follows:

1. BP3060-001-001~012.
2. BP3068-001-013~024,039,046.

Signed off the following green tags:

- 1.13340 and 13341.

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This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-110. Welder is identified as 057795. ZPMC Quality Control (QC) is identified as Mr. Zhao jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3311-TC-P4.

ZPMC personnel heat straightening OBG member identified as WJF-14. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Huang min was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8746.

Flux Cored Arc Welding (FCAW) of weld joint BP3095-001-120,121. Welder is identified as 057609. ZPMC Quality Control (QC) is identified as Mr. Xia Yong Zheng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-4133.

BAY- 7

FCAW of weld joint EP3022-001-075,076. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint EP3022-001-033,034. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint EP3022-001-069,070. Welder is identified as 051246 ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 8

FCAW of weld joint BK004A8-056-041,042. Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Yong Qing Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132.

During random in process inspection of OBG member identified as Bike Path BK004A6-056, this QA observed a longitudinal linear crack measuring approximately 5 mm in length on weld joint identified as BK004A6-056-022. This QA marked the cracked area and informed ZPMC Quality Control (QC) identified as Mr. Feng Ya Jun of this issue. Mr. Feng Ya Jun informed this QA that the crack would be corrected in a manner compliant with the contract documents. Refer the attached photos for reference.

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
