

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-015772**Date Inspected:** 18-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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- 2

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06225.

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 Floor beam weld Components. Total number of welds UT Tested: 06 No's. The weld designations are review as follows:

1. FB3236-001-001,009
2. FB3237-001-001,012
3. FB3238-001-005,012

BAY- 3

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06225.

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 Longitudinal Diaphragm weld Components. Total number of welds UT Tested: 12 No's. The weld designations are review as follows:

1. LD3025-001-007,008,031,032
2. LD3026-001-008,009,022,023
3. LD3030-001-006,007
4. LD3029-001-016,017

BAY- 5

This QA Inspector Randomly observed the following work in progress:

ZPMC personnel heat straightening OBG member identified as 10TR3-016. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Shen Jian Guo was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8076.

BAY- 6

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-188. 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-3211-TC-U4c. Refer the attached photos for reference.

BAY- 7

Flux Cored Arc Welding of weld joint BP3052-001-013,014. Welder is identified as 062447. 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.

SMAW Tack welding of weld joint SP3085-001-017,018. Welder is identified as 054456. 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.

SMAW Tack welding of weld joint BP3054-001-011,012. Welder is identified as 046813. 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.

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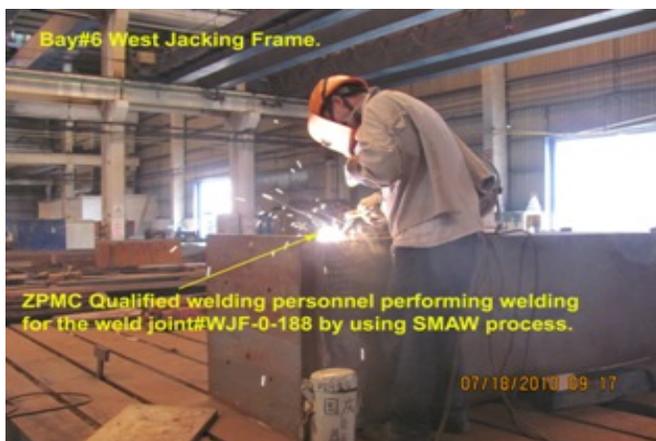
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SMAW Tack welding of weld joint SP3084-001-013,014. Welder is identified as 250833. ZPMC Quality Control (QC) is identified as Mr. Cui jun jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

BAY- 8

SMAW welding of weld joint BK004A5-056-090. Welder is identified as 045148. ZPMC Quality Control (QC) is identified as Mr. Yong Qing Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2114-B-U2.

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