

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015934**Date Inspected:** 24-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. Li Jia**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:

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This QA Inspector Randomly observed the following work in progress:

ZPMC MT Technicians performing Magnetic Particle Testing for the Traveler Rail (TR) welds on 10TR3-036 and 11TR1-015. Refer the attached photos for reference.

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Shielded Metal Arc Welding (SMAW) welding of weld joint WJF-0-115. Welder is identified as 215083. 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.

Flux Cored Arc Welding (FCAW) of weld joint DP3095-001-117. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Mr. Huang Min. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-TC-U4b-F-2.

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ZPMC personnel heat straightening OBG member identified as SP3084A. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Zhao Jian Hang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8901.

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06271.

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 Deck Panel weld Components. Total number of welds MT Tested: 24 No's. The weld designations are review as follows:

1. SA7034-001-019~024,027~032
2. SA7509-001-019~024,027~032

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 Deck Panel weld Components. Total number of welds UT Tested: 08 No's. The weld designations are review as follows:

1. SA7034-001-017,018,025,026
2. SA7509-017,018,025,026

FCAW of weld joint SP3086-001-007,008. Welder is identified as 062447. 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 SP3086-001-011,012. 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.

SMAW Tack welding of weld joint DP3114-001-005,006. 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.

SMAW Tack welding of weld joint SP3087-001-011,012. 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.

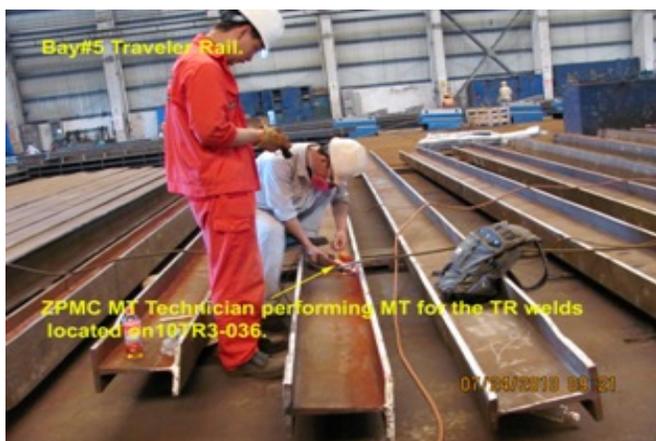
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BAY- 8

Submerged Arc Welding of weld joint BK004A1-061-009. Welder is identified as 040813. ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

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