

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-016033**Date Inspected:** 02-Aug-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. Lu 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:

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This QA received ZPMC inspection notification sheet 06317 to perform dimensional inspection of Traveler Tails (TR) identified as 10TR1-008 and 11TR2-006. Dimensional inspections performed on this traveler rail include, but is not limited to, overall length, beam sweep, beam camber, flange tilt and flange warpage. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurements survey: Traveler Rails and submitted to CT QA lead for review.

During dimensional inspection this QA Inspector observed the width of the flange has been reduced approximately 5 mm due to the excess grinding on the Traveler rail flange at end of the TR buttering welding performed area. The TR is identified as 10TR1-008. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Zhulin and American Bridge/Fluor (AB/F) QA Inspector Mr. Wang wen Bin of this issue. Mr. Zhulin and Mr. Wang wen Bin informed this QA that the flange width would be corrected in a manner compliant with the contract documents. Refer the attached photos for further information.

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06321.

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 Plate weld Components. Total number of welds MT Tested: 13 No's. The weld designations are review as follows:

1. DP3128-001-068,079,072,073,074,075,070,084,060,082,085,080,071.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06323.

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 Plate weld Components. Total number of welds MT Tested: 04 No's. The weld designations are review as follows:

1. WJF-0-024,104~106.

Signed off the following green tags.

1.13415

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint WJF-0-006. Welder is identified as 049769. ZPMC Quality Control (QC) is identified as Mr. Zhao Jian Hang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3312-TC-P5.

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Flux Cored Arc Welding (FCAW) of weld joint DP3113-001-001,002. 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 DP3113-001-005,006. Welder is identified as 217185. 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 SP3123-001-012,013. 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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SMAW Tack welding of weld joint SP3141-001-005,006. 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-FCM.

BAY- 8

Submerged Arc Welding of weld joint BK004A1-059-009. Welder is identified as 040813. ZPMC Quality Control (QC) is identified as Mr. Liu Chaun Gang. 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

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your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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