

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-016034**Date Inspected:** 01-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. 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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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06313.

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: 26 No's. The weld designations are review as follows:

1. DP3127-001-037,066,042,043,031,032,024,025
2. DP3127-001-028,029,021,022
3. DP3096-001-042,043
4. DP3096-001-040,041,044,045
5. DP3072-001-069,070
6. DP3116-001-069~074

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Signed off the following green tags.

1.13413

2.13414

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint WJF-0-097. 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-3313-TC-P5. Refer the attached photos for reference.

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ZPMC personnel heat straightening OBG member identified as SP3121A. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Cui Jun Jie was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) HSR1 (B) 8970.

Flux Cored Arc Welding (FCAW) of weld joint DP3114-001-001,002. 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 DP3114-001-005,006. 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 SP3142-001-005,006. Welder is identified as 054456. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

SMAW Tack welding of weld joint SP3140B-001-109,110. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Wang Liang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

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
