

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-016571**Date Inspected:** 25-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. Li Jia / 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:

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This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3168-002-006. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Li Jia. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2133-TC-U4b-F.

FCAW of weld joint FB3168-002-003,004. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Li Jia. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

During Random in process visual inspection of Cross beam CB18 Side Plate SP3089A, this QA Inspector observed the base metal has been gouged approximately 4.5 mm in depth. The nearest weld is identified as CB3002D-018-001. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Li Jia and American Bridge/Fluor (AB/F) QA Inspector Mr. Mr. Liu Hua Jie of this issue. Mr. Li Jia and Mr. Mr. Liu Hua Jie informed this QA that the Base metal would be corrected in a manner compliant with the contract

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documents. Refer the attached photos for further information.

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FCAW of weld joint SP3122-001-015,016. 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.

FCAW of weld joint SP3122-001-033,034. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Guopan. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

Submerged Arc Welding (SAW) of weld joint DP3183-001-031. Welder is identified as 215960. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

FCAW of weld joint DP3156-001-025. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-B-U2-F.

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint BP3098-001-001,002. Welder is identified as 049771. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

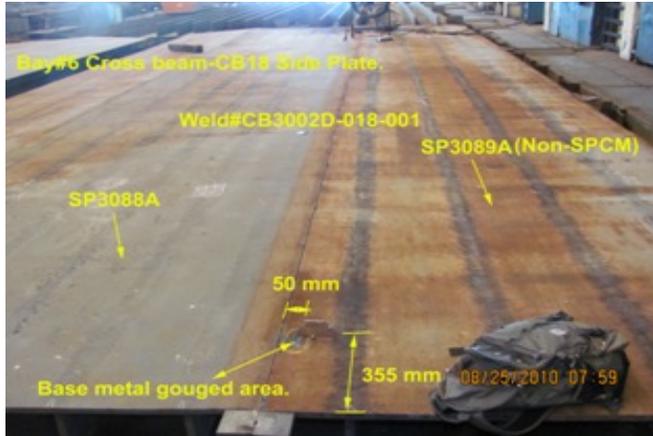
SMAW Tack welding of weld joint DP3181-001-011,012. Welder is identified as 046819. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112-FCM.

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
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Reviewed By:	Hall,Steven	QA Reviewer
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