

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-016575**Date Inspected:** 23-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. Tian Lei / 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:

BAY- 2

This QA Inspector Randomly observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint FB3328-001-026. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

Flux Cored Arc Welding (FCAW) of weld joint FB3349B-001-003,004. Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3348-001-003,004. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

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FCAW of weld joint LD3026-001-075. Welder is identified as 055564. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

BAY- 4

This QA received ZPMC inspection notification sheet 06463 to perform dimensional inspection of Traveler Tail (TR) identified as 10TR3-028. 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 11TR2-003. This QA marked the affected area and informed ZPMC Quality Control (QC) identified as Mr. Shen jian guo and American Bridge/Fluor (AB/F) QA Inspector Mr. Wang wen Bin of this issue. Mr. Shen jian guo 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.

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint EP3027-001-093,094. Welder is identified as 215169. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

BAY- 6

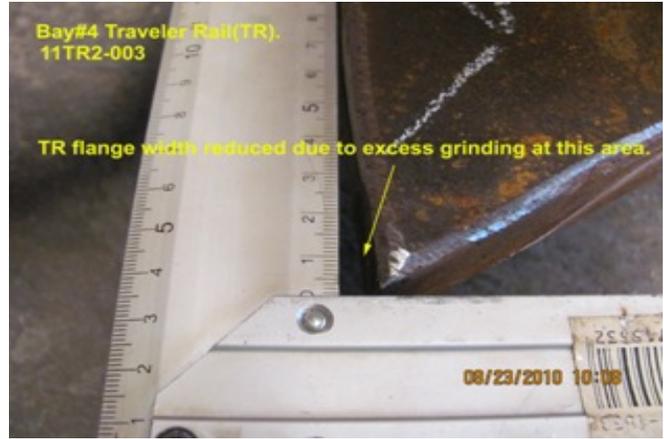
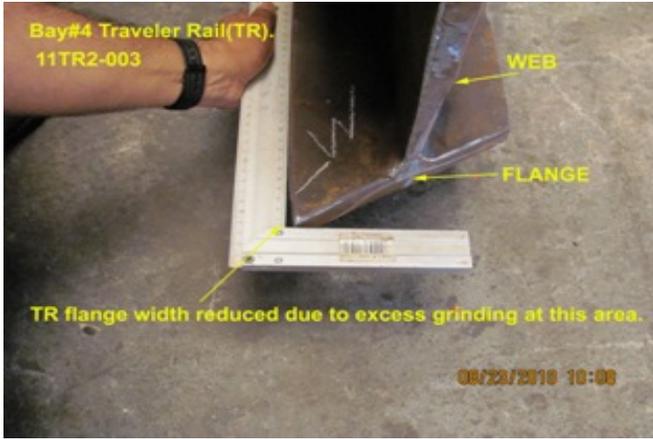
SAW of weld joint CB3002H-018-002. Welder is identified as 054458. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2c-S-2.

FCAW of weld joint CB3002B-018-004. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

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