

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016756**Date Inspected:** 12-Sep-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. Huang min		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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:

Flux Cored Arc Welding (FCAW) of weld joint VP3014-001-019. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW of weld joint VP3014-001-052. 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-2232-TC-U4b-F.

FCAW of weld joint VP3015-001-021. Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

BAY- 4

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FCAW of weld joint EP3028-001-005. Welder is identified as 044830. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-F.

BAY- 6

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-135. Welder is identified as 054467. ZPMC Quality Control (QC) is identified as Mr. Huang min. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3311-TC-P4.

SMAW of weld joint WJF-0-145. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Huang min. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3311-TC-P4.

SMAW of weld joint WJF-0-156. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Mr. Huang min. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-3311-TC-P4.

During the QA random in-process observations of the fabrication of OBG Cross beam (CB) CB18, this Caltrans QA observed during the fit up of the floor beam diaphragms on CB18 ZPMC personnel appear to have overheated the flange base metal. The material was heated to a bright red/yellow condition. AWS D1.5 2002 defines the color of material heated to 650oC as a “dull red color”. The corner diaphragm flange is identified as X3735A. The weld joint number nearest to the heated area is identified as FB3168-003-026. The area being heated is approximately 65 mm from the above mentioned weld joint. The length of the heated area is approximately 110 mm parallel to the above mentioned weld joint.

This QA generated an incident report on this date for the above issue, for further information see the incident report and attached photos.

BAY- 7

FCAW of weld joint SA3078-006-001. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2333-C-P2-F.

FCAW of weld joint W2-SB1H-002-100~105. Welder is identified as 051246. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2133.

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