

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016758**Date Inspected:** 09-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:

LAY DOWN YARD.

Segment: 11EE

This QA performed a joint survey dimensional inspection of corner assembly cope holes on segment 11EE. The inspection was performed along with Caltrans (CT) QA Mr. Manoj Prabune. Measurements of the cope holes were taken from Panel Point (PP) 107 to PP108.5 at the following locations: E1~E2, S1~S5 and T1~T3 on both the crossbeam and bike path sides. Details of these locations can be found on CT / QA document titled "OBG DCP Hand Measurement Survey: Corner Assembly Cope Holes". This QA recorded the measurements and submitted the information to CT / QA lead inspector for review.

This QA performed Visual Testing (VT) and dimensional inspection on cope and weld access holes inside OBG lift 11EE. A number of the cope holes did not appear to comply with the contract documents. American Bridge Fluor (ABF) QA inspectors have previously inspected and accepted these cope holes and recorded their findings on ABF document CWAHIR-11EE-01 date 6th September 2010.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY- 6

This QA Inspector Randomly observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint CB3002G-018-001. Welder is identified as 215960. ZPMC Quality Control (QC) is identified as Mr. Shu Yang Hua. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

BAY- 7

Flux Cored Arc Welding (FCAW) of weld joint BP3098-001-001,002. Welder is identified as 062447. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint BP3098-001-003,004. Welder is identified as 205386. ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint W2-SB1-006-032~043. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint W2-SB1-005-075~078. Welder is identified as 204342. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint X4254B-002-001. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-TC-U4b-F-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 your project.

Inspected By: Prabhu,Surendra

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Hall, Steven

QA Reviewer