

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-016796**Date Inspected:** 19-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 / Mr. Tian Lei	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- 1

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint E2-SB1A-001-126~131. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Mr. Xiang Feng Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint E2-SB1-016-126~131. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Mr. Xiang Feng Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 2

Submerged Arc Welding (SAW) of weld joint FB3325-001-027. Welder is identified as 250050. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS:

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WPS-B- T-2221-B-L2c-S-2.

FCAW of weld joint FB3316-001-054,055. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3321-001-136. Welder is identified as 058246. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-TC-U4b-F.

BAY- 3

FCAW of weld joint FB3274-001-064,065. Welder is identified as 066283. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3260-001-084,085. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 4

During random in process inspection of OBG member identified as Lift 14 East Bottom plates BP3084A and BP3085A, this QA observed a cracked tack welds on weld joints identified as BP3084-001-047 and BP3085-001-090 respectively. This QA marked the cracked tacks and informed ZPMC Quality Control (QC) identified as Mr. Shen jian guo of this issue. Mr. Shen jian guo informed this QA that the cracked tacks would be corrected in a manner compliant with the contract documents. Refer the attached photos for reference.

BAY- 7

FCAW of weld joint W2-SB1C-006-126~131. Welder is identified as 215689. 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 FB3242-001-016. Welder is identified as 0624475. ZPMC Quality Control (QC) is identified as Mr. Cui Jun Jie. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-B-U2-F.

BAY- 8

FCAW of weld joint BK004A8-053-029,030. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132.

BLAST SHOP#1

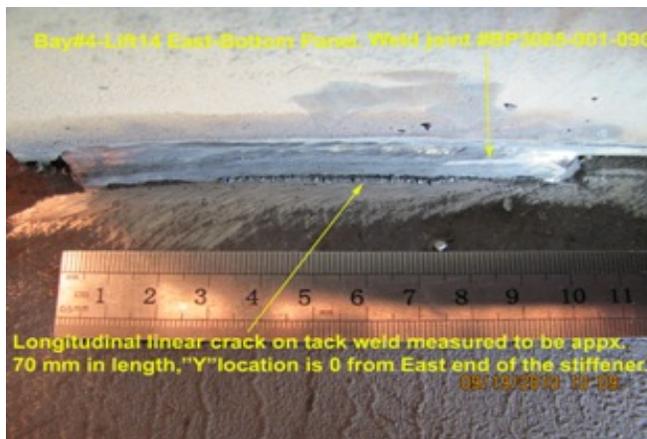
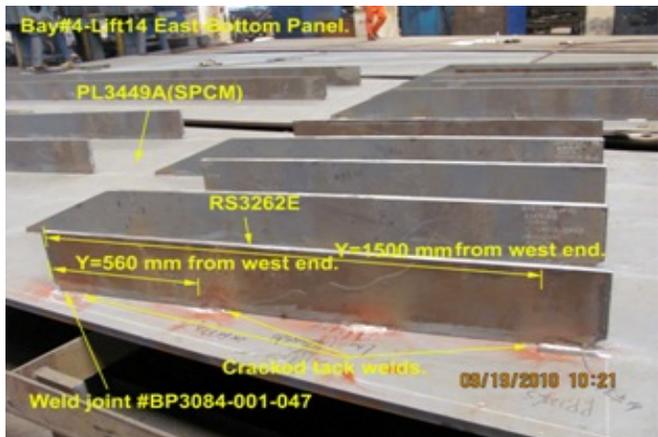
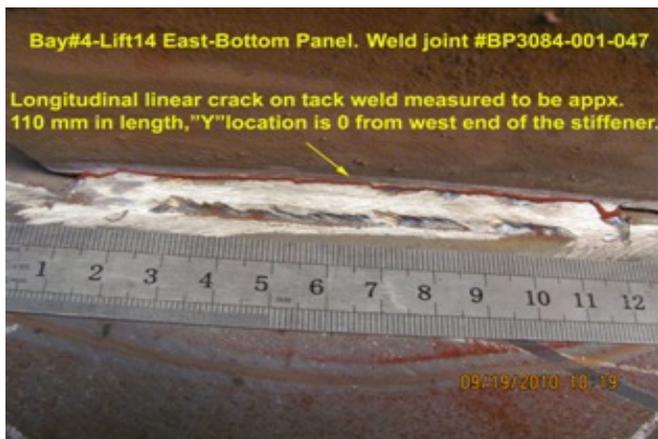
Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG Segment 11CW Exterior

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skin after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA. Repair work is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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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
