

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-016977**Date Inspected:** 26-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. Tian Lei /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
Bridge No:	34-0006	Delayed / Cancelled:	Yes	No N/A
		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-SB1B-001-082~087. Welder is identified as 215397. 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-SB1-008-082~087. 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.

During random in process inspection of OBG member identified as Traveler Rail 9TR1-001, this QA observed cracked tack welds on weld joint identified as 9TR1-001-020. This QA marked the cracked tacks and informed ZPMC Quality Control (QC) identified as Mr. Xiang feng feng of this issue. Mr. Xiang feng feng informed this QA that the cracked tacks would be corrected in a manner compliant with the contract documents. Refer the

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

attached photos for reference.

BAY- 2

FCAW of weld joint FB3321-001-082. Welder is identified as 045203. 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 FB3321-001-152,153. Welder is identified as 062708. 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 FB3329-001-136~143. 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-2233-B-U2-F.

BAY- 3

Submerged Arc Welding (SAW) of weld joint LD3042-001-003. Welder is identified as 044780. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

SAW of weld joint LD3043-001-001. Welder is identified as 207288. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

BAY- 4

SAW of weld joint CB3002C-018-002. Welder is identified as 053748. ZPMC Quality Control (QC) is identified as Mr. Zhang zhi wei . The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

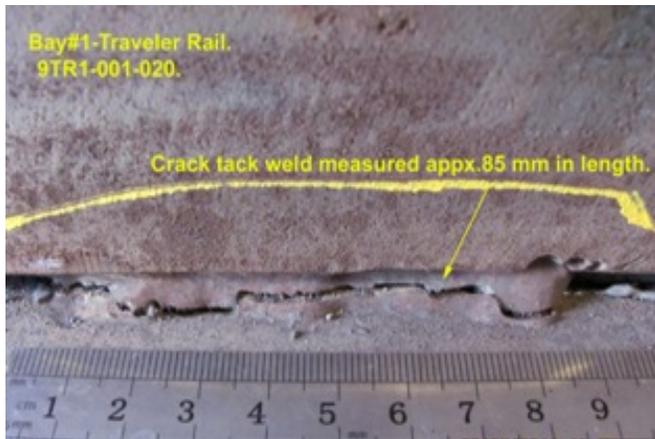
FCAW of weld joint BP3083-001-089,090. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Shen jian guo. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3079-001-211. 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-2232-TC-U4b-F.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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