

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-016979**Date Inspected:** 22-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-SB1-012-082~087. Welder is identified as 067601. ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2133. Refer the attached photos for reference.

FCAW of weld joint E2-SB5A-001-126,127. Welder is identified as 069043. ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3. Refer the attached photos for reference.

BAY- 2

Submerged Arc Welding (SAW) of weld joint FB3220-001-049. Welder is identified as 250050. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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

FCAW of weld joint FB3321-001-084,085. 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-2132-3.

FCAW of weld joint E5-SB1-034-126~131. Welder is identified as 203871. 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.

BAY- 6

Shielded Metal Arc Welding (SMAW) of weld joint WJF-0-002. Welder is identified as 057795. 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-0-003. Welder is identified as 048659. 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-0-0128. Welder is identified as 053753. 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.

FCAW of weld joint CB3002K-003-031,032. Welder is identified as 217185. ZPMC Quality Control (QC) is identified as Mr. Zhang zhi wei. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 7

FCAW of weld joint W2-SB1-028-112,114. Welder is identified as 048625. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint W2-SB1-021-126~131. Welder is identified as 215689. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

BAY- 8

FCAW of weld joint BK004A1-054-043. Welder is identified as 067184. ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4c-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
