

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-017202**Date Inspected:** 30-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**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-SB5-014-126~131. Welder is identified as 066399. 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-SB1-015-126~131. Welder is identified as 066421. 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

FCAW of weld joint E5-SB1-001-019,050. Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhu Jun. The welding variables appeared to comply with the Applicable WPS: WPS-B-

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T-2232-TC-U4b-F.

FCAW of weld joint E5-SB4-001-126~131. Welder is identified as 207465. 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 FB3329-001-084,085. 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-2132-3.

BAY- 3

FCAW of weld joint FB3260-001-023,024. Welder is identified as 206623. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3260-001-132,133. Welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2133.

BAY- 6

ZPMC MT Technician performing Magnetic Particle Testing for the welds located on Side Plate SP3149-001. Refer the attached photo for reference.

BAY- 7

FCAW of weld joint FB3241-001-011,012. Welder is identified as 062447. 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. Refer the attached photo for reference.

FCAW of weld joint SA3077-006-002. Welder is identified as 068920. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-C-P2-F-2.

FCAW of weld joint SA3077-007-001. Welder is identified as 068494. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2331-C-P2-F-2.

FCAW of weld joint X4253E-001-001. Welder is identified as 053742. ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. 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

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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

Reviewed By: Hall,Steven

QA Reviewer