

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-017205**Date Inspected:** 28-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**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

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06792.

Visual Testing (VT)

This QA Randomly performed VT of Stud welds on Counter Weight CW94. These welds are previously tested and accepted by ZPMC Quality Control (QC) personnel.

This QA received ZPMC inspection notification sheet 06789 to perform dimensional inspection of traveler rail identified as 20TR1-023. Dimensional inspections performed this traveler rail include, but is not limited to, overall length, beam sweep, beam camber, flange tilt and flange warpage. The results of the inspection were recorded on Caltrans (CT) QA form OBG DCP Hand Measurements Survey: Traveler Rails and submitted to CT QA lead for review.

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BAY- 2

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint E5-SB10-003-032~043. Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2133.

FCAW of weld joint E5-SB1-007-026~031. Welder is identified as 062708. 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 FB3317-001-023,024. 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.

Submerged Arc Welding (SAW) of weld joint SA8501-001-001. Welder is identified as 207237. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-U3c-S-2.

During random in process inspection of OBG member identified as Vertical Plate VP3014A, this QA observed Base metal gouged approximately 3 mm in depth. The nearest weld joint identified as VP3014-001-052. The "Y" location is approximately 180 mm from weld toe and 740 mm from east end of the plate. This QA marked the gouged area and informed ZPMC Quality Control (QC) identified as Mr. Zhulin of this issue. Mr. Zhulin informed this QA that the gouged area would be corrected in a manner compliant with the contract documents. Refer the attached photos for reference.

BAY- 3

FCAW of weld joint FB3290-001-017,018. Welder is identified as 055491. 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.

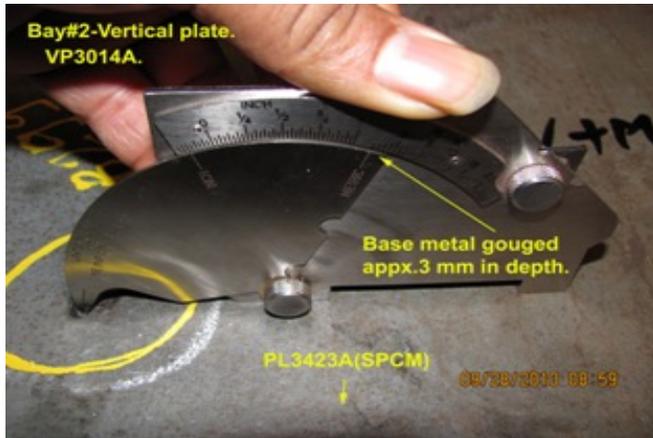
FCAW of weld joint FB3288-001-042,043. Welder is identified as 217805. ZPMC Quality Control (QC) is identified as Mr. Zhang Yaxu. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2132-3.

FCAW of weld joint FB3265-001-090,091. 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.

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

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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
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Reviewed By:	Hall,Steven	QA Reviewer
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