

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-018007**Date Inspected:** 25-Oct-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. Chen xi**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:

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This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3049-001-086,114. Welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW Repair welding of weld joint FB3327-001-028. 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-345-FCAW-3G (3F)-Repair-1. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR16106. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-17197.

FCAW Repair welding of weld joint FB3343-001-254. Welder is identified as 045276. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS:

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WPS-345-FCAW-2G (2F)-Repair-1. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR16133. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-17234.

FCAW Repair welding of weld joint FB3343-001-097. Welder is identified as 045280. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR16141. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-17234.

Submerged Arc Welding Repair welding of weld joint LD3051-001-003. Welder is identified as 045265. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables appeared to comply with the Applicable WPS: WPS-345-SAW-1G (1F)-FCM. The repair welding was being performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR2080. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-18030.

ZPMC UT Technicians performing Ultrasonic Testing for the welds located on Vertical plate VP3011A. Refer the attached photos for reference.

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The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07097.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated UT report for this date. The members are identified as OBG Floor beam weld Components. Total number of welds UT Tested: 5 No's. The weld designations are review as follows:

1. FB3286-001-262,256,227,221,049.

FCAW of weld joint LD3041-001-104. Welder is identified as 217805. 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 SA3324-001-052. Welder is identified as 052696. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2232-TC-U4b-F.

FCAW of weld joint SA3324-001-031. 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-2233-TC-U4b-F.

Shielded Metal Arc Welding (SMAW) Tack welding of weld joint SA3338-001-036~039. Welder is identified as

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215169. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- P-2112.

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