

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-018051**Date Inspected:** 16-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. 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. 06982.

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Steel barrier weld Components. Total number of welds MT Tested: 42 No's. The weld designations are review as follows:

1. E2-SB1-003-126~131,019,050,081,102,103,082,083,095.
2. E2-SB1-010-126~131,019,050,081,102,103,082,083,095.
3. E2-SB1D-015-126~131,019,050,081,102,103,082,083,095.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

During the Caltrans QA MT verification of the steel barriers, this QA observed ZPMC has welded over the snipe areas on steel barrier sections. The welds are fillet welds joining the internal stiffeners to the skins. The barrier affected by this condition is identified as E2-SB1-003. The effected welds are identified as E2-SB1-003-064,066, 068,070,072,074,076,078,083,087 and 126~131. This QA informed American Bridge/Fluor (AB/F) QA Inspector identified as Mr. Wang wen bin of this issue. Mr. Wang wen bin informed this QA that ABF will submit an RFI concerning this issue also informed to Caltrans Lead QA Inspector for the above issue. Refer the attached photos for reference.

BAY- 2

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06984.

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Steel barrier weld Components. Total number of welds MT Tested: 27 No's. The weld designations are review as follows:

1. E5-SB1-004-126~131,019,050,081.
2. E5-SB1-032-126~131,019,050,081.
3. E5-SB1-006-126~131,019,050,081.

This QA Inspector Randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3316-001-086~093. Welder is identified as 067877. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2133.

FCAW of weld joint FB3315-001-060,063. Welder is identified as 201583. 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 FB3320-001-027,028. Welder is identified as 068554. 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 FB3261-001-004,005. 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.

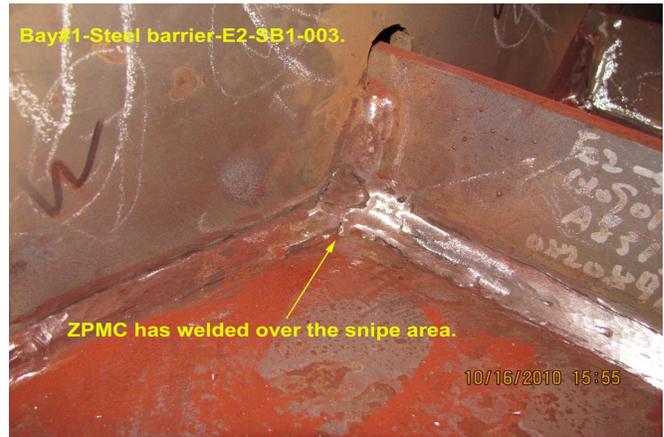
FCAW of weld joint LD3040-001-010,011. Welder is identified as 208035. ZPMC Quality Control (QC) is

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2232-3.

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
