

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-018053**Date Inspected:** 13-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:

BAY- 1

This QA Inspector Randomly observed the following work in progress:

ZPMC MT Technician performing Magnetic Particle Testing (MT) for the welds located on Steel barrier identified as E2-SB4-002. Refer the attached photos for reference.

BAY- 2

Flux Cored Arc Welding (FCAW) of weld joint FB3349-001-007,008. Welder is identified as 070046. 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 FB3343-001-016. Welder is identified as 045227. 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-U5-F-2.

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FCAW of weld joint FB3343-001-015. 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-2232-TC-U5-F-2.

FCAW of weld joint FB3339-001-001. Welder is identified as 068916. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2233-B-U2-F.

ZPMC MT Technicians performing MT for the welds located on Floor beam identified as FB3341A. Refer the attached photos for reference.

BAY- 3

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06937.

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 Floor beam weld Components. Total number of welds MT Tested: 20 No's. The weld designations are review as follows:

1. FB3289-001-001~010,013~016,019,020,027~030.

Shielded Metal Arc Welding (SMAW) Repair welding of weld joint FB3261-001-044,045. Welder is identified as 204339. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-FCM-Repair. The repair welding was being performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR2040. These welds was rejected by ZPMC MT Technicians and recorded on MT report No: B787-MT-30120.

FCAW of weld joint FB3320-001-003,004. 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-2132-3.

BAY- 4

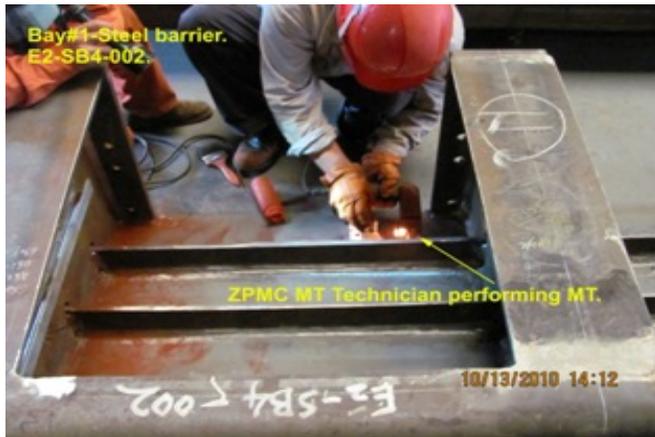
Submerged Arc Welding (SAW) of weld joint SA3358-001-001. Welder is identified as 050502. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

SAW of weld joint SA3362-001-001. Welder is identified as 207288. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2221-B-L2c-S-2.

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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
