

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-018157**Date Inspected:** 16-Nov-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. Li zhi jiang**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 LD3048-001-038. Welder is identified as 058245. 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.

FCAW of weld joint SEG3020K-011. Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Mr. Zhu jun. The welding variables appeared to comply with the Applicable WPS: WPS-B- T-2231-TC- U5-F.

FCAW of weld joint FB3343-001-347. Welder is identified as 067942. 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.

ZPMC UT Technicians performing Ultrasonic Testing for the welds located on Floor beam identified as FB3343A. Refer the attached photos for reference.

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BAY- 3

FCAW Repair welding of weld joint FB3286-001-327. 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-345-FCAW-2G (2F)-Repair. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR16797. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-17512.

FCAW Repair welding of weld joint FB3286-001-018. Welder is identified as 044830. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair. The repair welding was being performed as per the Welding Repair Report (WRR) No: B-WR16799. This weld was rejected by ZPMC UT Technicians and recorded on UT report No: B787-UT-17512.

FCAW of weld joint SEG3019M-007. 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-2231-TC-U5-F.

FCAW of weld joint SEG3019L-086. Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhan hai feng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW of weld joint SEG3019K-255. Welder is identified as 067036. 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-U5-F.

This QA Inspector performed photo documentation on Lift 14 Hinge plates are identified as FB3286A, FB3273A, FB3272A, FB3328B, FB3327A, FB3343A, SA3325A, SA3324A, SA3409A and SA3410A located in sub assembly bay 2 and 3. These photos have been sent to QA lead Inspector and Structural Material Representative (SMR) by mail.

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
Reviewed By:	Hall,Steven	QA Reviewer
