DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018830
Date Inspected: 19-Dec-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Mr. Li jia

	Yes	No	N/A
Inspected CWI report:	☐	☑	☐
Electrode to specification:	☑	☐	☐
Qualified Welders:	☑	☐	☐
Approved Drawings:	☑	☐	☐

	Yes	No	N/A
CWI Present:	☑	☐	
Rod Oven in Use:	☑	☐	☐
Weld Procedures Followed:	☑	☐	☐
Verified Joint Fit-up:	☐	☑	☐
Approved WPS:	☑	☐	☐
Delayed / Cancelled:	☐	☑	☐

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 personnel heat straightening OBG member identified as 20TR2-036. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Xiang feng feng was present to monitor the heat straightening process. The heat straightening appeared to comply with the Caltrans Engineer approved Heat Straightening Report (HSR) HSR (B)-362.

ZPMC MT Technician performing Magnetic Particle Testing for the welds located on the steel barrier rail identified as E2-SB1-055.Refer the attached photos for reference.

ZPMC personnel performing bolt hole drilling for the steel barrier rail identified as E2-SB1-045.Refer the attached photos for reference.

BAY- 2

American Bridge/ Fluor QA Inspectors performing Magnetic Particle Testing (MT) for the welds located on the Anchor plate identified as AP3032A.MT was being performed after completion of all transverse cracks repair welding.

ZPMC personnel heat straightening OBG Grillage plate identified as SA7512A. Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Zhu jun was present to monitor the heat straightening process. The heat straightening appeared to comply with the Caltrans Engineer approved Heat Straightening Report (HSR) HSR (B)-442.

BAY- 3

Shielded Metal Arc Welding (SMAW) welding of weld joint SP3071-001-085. Welder is identified as 058102. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2213-TC-U4b.

Flux Cored Arc Welding (FCAW) Welding of weld joint identified as AH3150A-076,077. Welder is identified as 208035. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2132-ESAB.

FCAW Welding of weld joint identified as AH3150-002. Welder is identified as 050977. ZPMC Quality Control (QC) is identified as Mr. Wang liyang. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2231-ESAB.

BAY- 4

This QA observed that no significant work was being performed in this bay during the time QA was present.

BAY- 8

FCAW Welding of weld joint identified as BK004A-064-070. Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2232-ESAB.

FCAW Welding of weld joint identified as BK004A-057-063. Welder is identified as 500479. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2232-ESAB.

FCAW Welding of weld joint identified as BK004A-064-070. Welder is identified as 500479. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2232-ESAB.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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