

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-018831**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li jia**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:

Flux Cored Arc Welding (FCAW) Welding of miscellaneous member identified as SA3334C. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Mr. Xiang feng feng. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2132-ESAB.

ZPMC personnel performing bolt hole drilling for the steel barrier rail identified as E2-SB16A-002. Refer the attached photos for reference.

ZPMC Certified Welding Inspector performing Visual Testing for the steel barrier rail identified as E2-SB1-055.

American Bridge /Fluor QA Inspector performing Visual Testing for the steel barrier rail identified as E2-SB2-012.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY- 2

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07814.

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 Anchor plate weld Components. Total number of welds UT Tested: 3 No's. The weld designations are review as follows:

1. AP3032-001-841,547,679

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 UT Technicians performing UT for welds located on the Grillage plate identified as SA7512A.

BAY- 3

ZPMC Welding personnel removing the welds by carbon arc gouging process to correct the distortion on side plate identified as SP3121A.The welds removed as per the Welding Repair Report B-WR16811.ZPMC QC Mr. Cui jun jie was present at site during the gouging process.

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 BK004A6-057-063. Welder is identified as 500405. ZPMC Quality Control (QC) is identified as Mr. Feng ya jun. The welding variables appeared to comply with Applicable the WPS: WPS-B-T-2232-ESAB.

FCAW Welding of weld joint identified as BK004A5-057-090. Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Mr. Feng ya jun. 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