

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-019065**Date Inspected:** 28-Dec-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. Huang min
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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- 7-Cross beam (CB)-CB19 (Segment tagging).

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07933.

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 CB Deck plate, bottom plate, side plate, diaphragms weld Components. Total number of welds MT Tested: 22 No's. The weld designations are review as follows:

1. CB3003J-002-007,008,071,072,076,099,100
2. CB3003J-001-007,008,071,072,103,104
3. DP3181-001-061
4. DP3180-001-033
5. CB3003K-001-007,008,015,017

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6. BP3100-2-001-005,002
7. BP3098-2-001-010

During random Visual Testing of OBG CB19 deck plate, this QA observed base metal gouged on Piece Mark (PCMK) identified as DP3181A. The “Y” location is approximately 1100 mm from south side cope hole. This QA marked the affected area and measured the depth approximately 2mm and informed ZPMC Quality Control (QC) Certified Welding Inspector indentified as Mr. Huang min of this issue. Mr. Huang min informed this QA that the gouged area would be corrected in a manner compliant with the contract documents. Refer the attached photos for reference.

BAY- 8

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07963.

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 Bike path weld Components. Total number of welds UT Tested: 4 No’s. The weld designations are review as follows:

1. BK004ASD1-063-005,006,018,021.

This QA Inspector Randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) Repair welding of weld joint identified as BK004A1-062-043. Welder is identified as 066459. ZPMC Quality Control (QC) is identified as Mr. Liu fa wen. The welding variables appeared to comply with the Applicable WPS: WPS-345-SMAW-2G (2F)-Repair. The repair welding was being performed as per the Caltrans Engineer approved Critical Welding Repair Report (CWR) No: B-CWR2481. This weld is rejected by ZPMC UT Technicians and recorded on ZPMC UT Report no.B787-UT-17775.

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
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Reviewed By:	Hall,Steven	QA Reviewer
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