

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-019403**Date Inspected:** 13-Jan-2011**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. An Qing xiang**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:

OBG Assembly Bay- 14.

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc welding (SMAW) welding of weld joint identified as SEG3020G-021,026. Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-P-2212-B-U2-FCM.

SMAW welding of weld joint identified as SEG3020F-027,036. Welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel appeared to comply with WPS: WPS- B-P-2212-B-U2-FCM.

SMAW welding of weld joint identified as SEG3020P-098,099. Welder is identified as 067520. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel appeared to comply with WPS: WPS- B-P-2212-B-U2-FCM.

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SMAW welding of weld joint identified as SEG3020J-002,005. Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-P-2212-B-U2-FCM.

SMAW welding of weld joint identified as SA3232-001-002. Welders are identified as 066459 and 037779. ZPMC Quality Control (QC) is identified as Mr. Li ping. The welding variables recorded by QC personnel appeared to comply with WPS:WPS-B-P-2211-B-U2b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as DP3172-001-348,349. Welder is identified as 048696. ZPMC Quality Control (QC) is identified as Mr. Li ping. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-T-2133-ESAB.

FCAW welding of weld joint identified as SA3149-001-009,010. Welder is identified as 054069. ZPMC Quality Control (QC) is identified as Mr. Li ping. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-T-2132-ESAB.

ZPMC UT Technician was performing Ultrasonic Testing for the deck panel splice weld joint identified as SEG3013-003. Refer the attached photos for reference.

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



Summary of Conversations:

No significant conversations were reported on this date.

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.

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Inspected By: Prabhu,Surendra

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer