

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-019415**Date Inspected:** 12-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.

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No. 08148.

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 a MT report for this date. The members are identified as OBG Floor beam weld Components. Total number of welds MT Tested: 9 No's. The weld designations inspected were as follows:

1. FB3217-001-148,149,139,140,130,131,122,123,115.

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020K-032. Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed recorded by QC personnel appeared to comply with WPS: WPS-B-T-2231-ESAB.

FCAW welding of weld joint identified as SEG3020BB-019. Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed recorded by QC personnel appeared to comply with WPS:WPS-B-T-2232-ESAB.

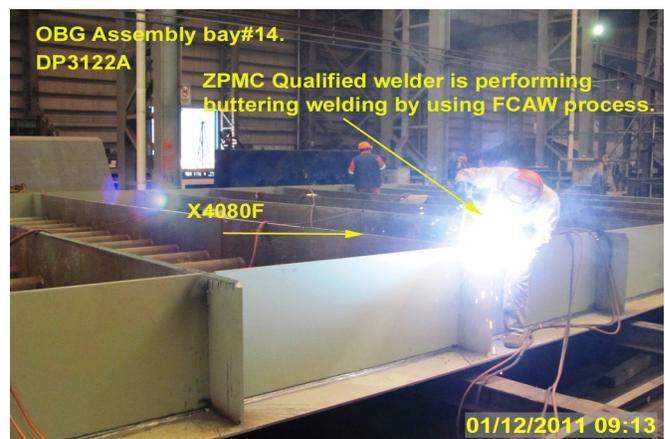
FCAW welding of weld joint identified as DP3177-001-163,164. Welder is identified as 048433. ZPMC Quality Control (QC) is identified as Mr. Li ping. The welding variables recorded by QC personnel observed recorded by QC personnel appeared to comply with WPS:WPS-B-T-2133-ESAB.

FCAW welding of weld joint identified as DP3177-001-171,172. Welder is identified as 048433. 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.

Shielded Metal Arc welding (SMAW) welding of weld joint identified as SEG3020M-200~203. Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Sun tian liang. The welding variables recorded by QC personnel appeared to comply with WPS:WPS-B-P-2214-TC-U4b-FCM-1.

FCAW buttering welding on deck panel diaphragm piece mark identified as DP3122A-X4080F. Welder is identified as 207465. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-345-FCAW-1G-ESAB-repair. The buttering welding was being performed as per the Welding Repair Report (WRR) No: B-WR19633.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:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
