

**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-019417**Date Inspected:** 16-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. 08192.

**Magnetic Particle Testing (MT)**

This QA performed MT of approximately 100% 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 Deck panel weld Components. Total number of welds MT Tested: 80 No's. The weld designations inspected were as follows:

1. DP3120-001-245,246,249,252~257,262~267,272~277,282~286,
2. DP3121-001-281~285,290~295,300~305,310~315,320~325,330~332
3. DP3122-001-282~286,272~277,262~267,252~257,245,246,249.

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During QA MT review of welds located on OBG Lift 13AW Deck plate DP3120A, this QA observed one transverse surface linear indication on base metal. The nearest weld is identified as: DP3120-001-273. The “Y” location is approximately 100 mm as shown on the picture below. This QA Inspector informed to Lead QA Inspector for the above issue. Refer the attached photos for reference.

This QA Inspector randomly observed the following work in progress:

Flux Cored Arc Welding (FCAW) welding of weld joint identified as DP3171-001-291,292. 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 Welding Procedure Specification (WPS): WPS- B-T-2233-ESAB.

FCAW welding of weld joint identified as DP3171-001-411,412. Welder is identified as 048696. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as DP3170-001-077,078. Welder is identified as 203871. 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-2233-ESAB.

Shielded Metal Arc welding (SMAW) welding of weld joint identified as AH3003-082. Welder is identified as 069493. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables recorded by QC personnel appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

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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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art	QA Reviewer
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