

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019848**Date Inspected:** 31-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. Qiu wen**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) Repair welding of weld joint identified as SEG3020X-008. Welder is identified as 045246. ZPMC Quality Control (QC) is identified as Mr. Wang xiang pin. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS):

WPS-345-SMAW-3G (3F)-FCM-Repair. The repair welding was being performed as per approved Critical Welding Repair Report (CWR) No: B-CWR2792. This weld was previously rejected by ZPMC QC personnel and recorded on UT report B787-UT-19154R1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as DP3169-001-262. Welder is identified as 066239. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as DP3170-001-019. Welder is identified as 067572. American

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as DP3171-001-018. Welder is identified as 203871. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian yuan. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

SMAW welding of weld joint identified as DP3173-001-244. Welder is identified as 067707. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM.

SMAW welding of weld joint identified as DP3073-001-245. Welder is identified as 067904. ZPMC Quality Control (QC) is identified as Mr. Qui wen. American Bridge/Fluor (AB/F) QA is identified as Mr. Shen jian. The welding variables recorded by QA personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM.

FCAW welding of weld joint identified as SEG3013P-163. Welder is identified as 067876. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2233-ESAB.

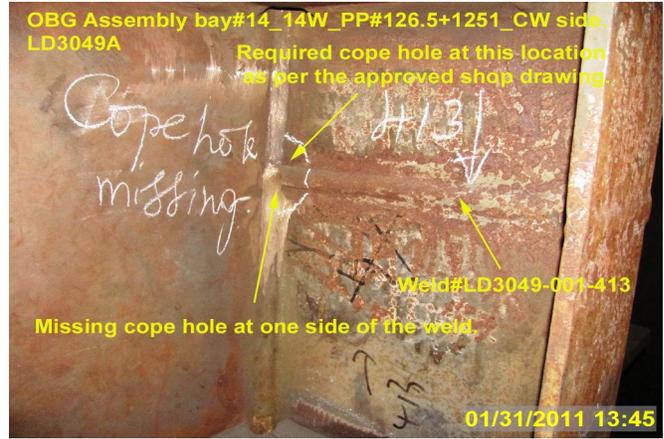
SMAW welding of weld joint identified as SEG3013P-222. Welder is identified as 066361. ZPMC Quality Control (QC) is identified as Mr. Zhang lin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

During random Visual inspection of 14West longitudinal diaphragm member identified as LD3049A, this QA observed a missing cope hole at one location. The approved shop drawing identified as LD3049C Section V specify that cope hole required both side of the butt weld. The effective weld is identified as LD3049-001-413. The effective open rib stiffeners are identified as X4920A (SPCM) and X4920C (SPCM). This QA marked the area and informed ZPMC Quality Control (QC) identified as Mr. Qui wen of this issue. Mr. Qui wen informed this QA that the ZPMC will cut the cope hole as per the approved shop drawing. This QA also informed to shop lead QA of this issue. Refer the attached photos for reference.

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:

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