

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-020912**Date Inspected:** 20-Feb-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) welding of weld joint identified as SEG3015L-014. Welder is identified as 045196. 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-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3015L-162. Welder is identified as 037996. ZPMC Quality Control (QC) is identified as Mr. Sun tian liang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3020U-588. Welder is identified as 067707. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

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SMAW welding of weld joint identified as SEG3020T-058. Welder is identified as 069896. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2114-FCM-1.

SMAW welding of weld joint identified as SA3174-001-005. Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2211-B-U3b.

SMAW welding of weld joint identified as SA3173-001-005. Welder is identified as 066674. ZPMC Quality Control (QC) is identified as Mr. Zheng zhi wei. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2211-B-U3b.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3020BB-117. Welder is identified as 067888. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

FCAW welding of weld joint identified as SEG3020BB-116. Welder is identified as 066695. ZPMC Quality Control (QC) is identified as Mr. Zhulin. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC MT Technicians performing Magnetic Particle Testing for west line Anchor plate bearing block castings. 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

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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
