

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-021658**Date Inspected:** 09-Mar-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 / Mr. Sha zhi	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.08497.

Ultrasonic Testing (UT)

This QA performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The members are identified as OBG weld Components. Total number of welds UT Tested: 1 No. The weld designation inspected was as follows:

1. SEG3020BB-019.

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013M-069. Welder is identified as

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069683. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS):
WPS-B-P-2213-B-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013K-158. Welder is identified as 067609. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-B-U2-FCM-1.

SMAW welding of weld joint identified as SA3013G-025. Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Liu fang. 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 DP3122-001-024. Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3013E-222. Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. 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 SEG3013N-002. Welder is identified as 045213. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC personnel performing weld back gouging for the I rib stiffener plate weld joints located at panel point no 126.5. Refer the attached photos for reference.

ZPMC UT Technician performing Ultrasonic Testing for the west line Anchor plate bearing blocks. Refer the attached photos for reference.

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

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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
