

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-022253**Date Inspected:** 28-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

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|------------------------------------|-----------------|----|-----|
| CWI Name: | Mr. Liu hua jie | | |
| Inspected CWI report: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A |

| | | | |
|----------------------------------|-----|----|-----|
| CWI Present: | Yes | No | |
| Rod Oven in Use: | Yes | No | N/A |
| Weld Procedures Followed: | Yes | No | N/A |
| Verified Joint Fit-up: | 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 Trial Assembly open yard.

This QA Inspector randomly observed the following work in progress:

Segment: 13AW

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013-004. Welder is identified as 067764. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint identified as SEG3013E-233. Welder is identified as 070432. ZPMC QC is identified as Mr. Zhang Qiang. 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 SEG3013AH-005. Welder is identified as 069683. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply

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with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

SMAW repair welding of weld joint identified as SEG3013P-061. Welder is identified as 067707. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-3G (3F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20399.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3013C-065. Welder is identified as 048433. ZPMC QC is identified as Mr. Zhang Qiang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC personnel performing air-carbon arc gouging on weld joint identified as SEG3013P-081 at Panel point no. 118 counter weight side. See attached photos for further details.

During random in process inspection of OBG Segment 13AW at Panel Point 119-1500 on floor beam identified as FB3184A, this QA observed an arc strike. This QA marked the affected area and informed ZPMC QC identified as Mr. Zhang Qiang and AB/F QA Inspector identified as Mr. Kasi wang of this issue. Mr. Zhang Qiang and Mr. Kasi wang informed this QA that the arc strike would be corrected in a manner compliant with the contract documents. See attached photos for further information.

Segment:13AE

FCAW welding of weld joints identified as SEG3007R-011. Welder is identified as 066236. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

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.

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