

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-022971**Date Inspected:** 24-Apr-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. 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.

Segment: 13AW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3013AA*-025. Welder is identified as 066326. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-B-P-2213-TC-U4b-FCM-1.

SMAW repair welding of weld joint identified as SEG3013L-100. Welder is identified as 067572. ZPMC QC is identified as Mr. Shen jian bo. 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-WR20693.

SMAW welding of weld joint identified as SEG3013AA*-004. Welder is identified as 066179. ZPMC QC is

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identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013M-077. Welder is identified as 047864. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4a-FCM-1.

SMAW repair welding of weld joint identified as SEG3013N-176. Welder is identified as 067765. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR20693.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3013V-524,525. Welder is identified as 048696. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2133-ESAB.

FCAW welding of weld joint identified as SEG3013D-054. Welder is identified as 203871. ZPMC 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 UT Technician was performing Ultrasonic Testing for the weld joint identified as SEG3013AA-114. See attached photos for further details.

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