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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023110
Date Inspected: 19-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Mr. Liu hua jie			**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 Trial Assembly open yard.

Segment:13E

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.08873.

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 on this date. The members are identified as OBG deck panel weld Components. Total number of welds UT Tested: 5 No’s. The weld designations inspected were as follows:

1. DP3091-001-022,023,028
2. DP3104-001-244,249

Segment:13AW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as FB3202-001-174. Welder is identified as 066443. 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-2211-B-U2-FCM-1.

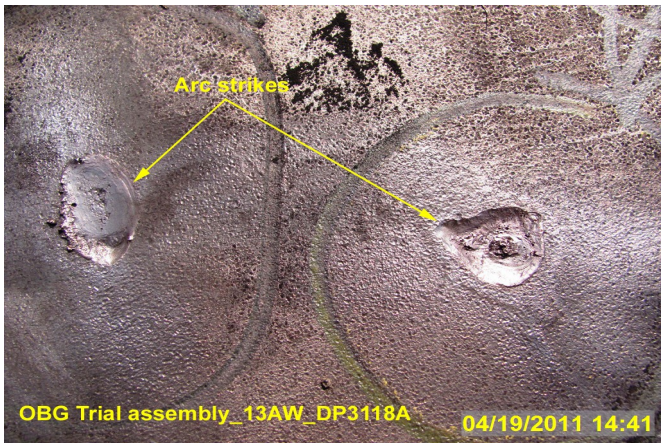
SMAW welding of weld joint identified as FB3178-001-167. Welder is identified as 067588. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-B-P-2212-TC-U4b-FCM-1.

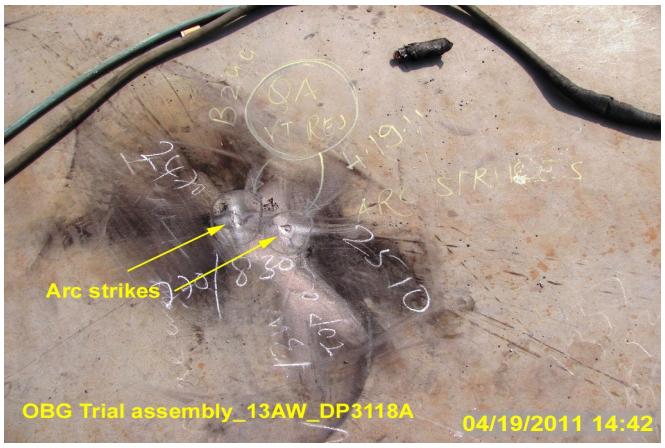
SMAW welding of weld joint identified as SEG3013AA*-065. Welder is identified as 070432. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2114-FCM-1.

SMAW welding of weld joint identified as SEG3013AA*-107. Welder is identified as 066002. 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-2114-FCM-1.

During a random in process visual inspection of OBG member identified as deck plate DP3118A, this QA observed arc strikes on the deck plate. This QA marked the affected areas and informed ZPMC Quality Control (QC) indentified as Mr. Shen jian bo of this issue. Mr. Shen jian bo informed this QA that the arc strikes would be corrected in a manner compliant with the contract documents. See attached photos for further details.

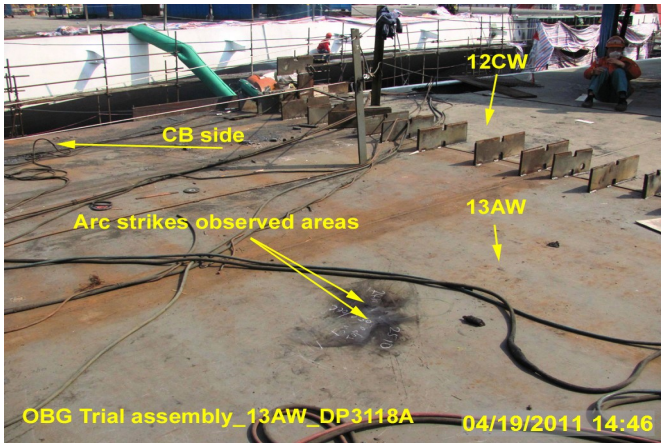
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

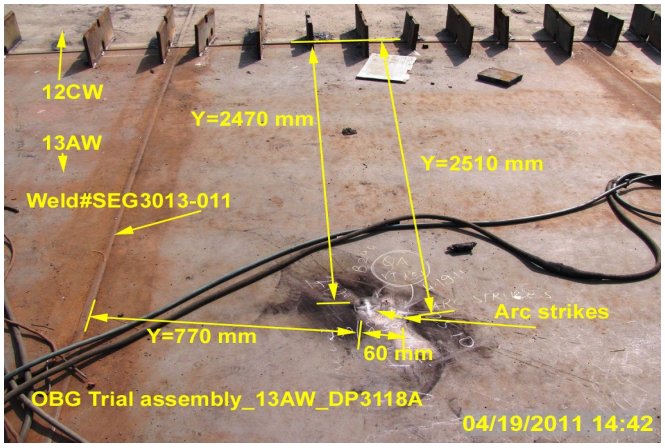




WELDING INSPECTION REPORT

(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