

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-023117**Date Inspected:** 26-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: 13AE

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.08934.

Magnetic Particle Testing (MT)

This QA performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a MT report for this date. The members are identified as OBG bottom and side plate weld Components. Total number of welds MT Tested: 20 No's. The weld designations inspected were as follows:

1. SEG3007S-030~033
2. SEG3007N-017~020, 261

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3. KP3001-001-009~ 019

Segment:13AW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)welding of weld joint identified as SEG3013P-135. 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 Welding Procedure Specification (WPS): WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013C-169. Welder is identified as 069712. 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-2214-TC-U4b-FCM-1.

SMAW repair welding of weld joint identified as AH3001-035. Welder is identified as 037779. 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-WR20812.

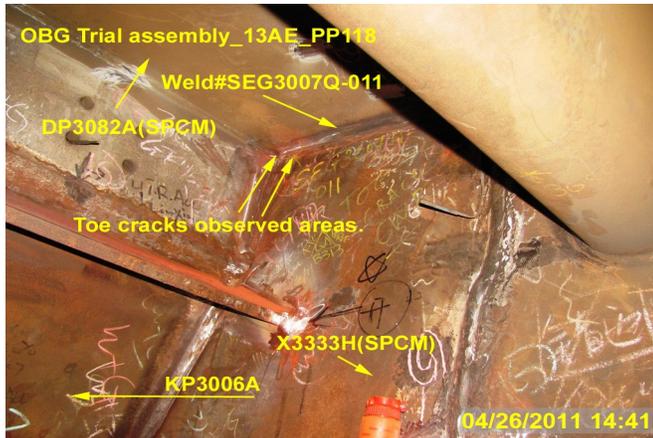
SMAW repair welding of weld joint identified as SEG3013E-139. Welder is identified as 066002. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-345-SMAW-3G (3F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR20604.

During a random in process visual inspection of OBG member identified as deck plate DP3082A, this QA observed 2 longitudinal toe cracks measuring approximately 25 mm and 18 mm in length respectively. The weld joint is identified as SEG3007Q-011.The weld is fillet weld joining to deck plate (DP3082A-SPCM) to deck panel diaphragm(X3333H-SPCM) members. This QA marked the affected areas and informed ZPMC Quality Control (QC) CWI indentified as Mr. Liu hua jie of this issue. Mr. Liu hua jie informed this QA that the cracks would be corrected in a manner compliant with the contract documents. This QA Inspector also informed to shop Lead QA Inspector of the issue. See attached photos for further details.

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