

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 #: 04-0120F4Cty: 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-024092**Date Inspected:** 23-May-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**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: 13AW

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.09211.

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: (4). The weld designations inspected were as follows:

1. SEG3013AX-127,128,131,124

This QA Inspector randomly observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3013AH-005. Welder is identified as 020432. ZPMC QC is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20692.

SMAW repair welding of weld joint identified as DP3122-001-014. Welder is identified as 066443. ZPMC QC is identified as Mr. Liu fang. 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-WR20560.

SMAW repair welding of weld joint identified as DP3120-001-015. Welder is identified as 069633. ZPMC QC is identified as Mr. Liu fang. 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-WR20560.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SEG3013N-281. Welder is identified as 067103. ZPMC QC is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as SEG3013L-087. Welder is identified as 067103. ZPMC QC is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2233-ESAB.

ZPMC personnel performing bolt hole drilling for the floor beam at FL3 area. 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
