

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-024167**Date Inspected:** 29-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

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3013C-262. Welder is identified as 066002. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-3G (3F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20604.

SMAW repair welding of weld joint identified as SEG3013G-085. Welder is identified as 069683. ZPMC QC is identified as Mr. Li ping. 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.

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Segment:13BW

Flux Cored Arc Welding (FCAW) repair welding of weld joint identified as SEG3014K-102. Welder is identified as 066734. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-FCAW-3G (3F)-ESAB-repair-FCM. The repair welding was being performed as per WRR No: B-WR21110.

FCAW welding of weld joint identified as SEG3014F-345. Welder is identified as 045240. 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.

SMAW welding of weld joint identified as SEG3014D-305. Welder is identified as 066156. ZPMC QC is identified as Mr. Liu fang. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-Tc-U4b-FCM-1.

Segment:14W

ZPMC personnel performing bolt hole drilling at deck plate extension location. 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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