

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-024661**Date Inspected:** 11-Jun-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 blast shop#4.

Segment: 13CW

The following Non Destructive Testing (NDT) Inspection was carried out as per the ZPMC submitted Notification No.09461.

Magnetic Particle Testing (MT)

This QA randomly witnessed and 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 weld Components. Total number of welds MT tested: (94). The weld designation inspected was as follows:

1. SEG3015D-198,199,192,193,186,187,180,181,174,175,168,169,162,163
2. SEG3015D-156,157,150,151,144,145,138,139,132,133,126,127,121

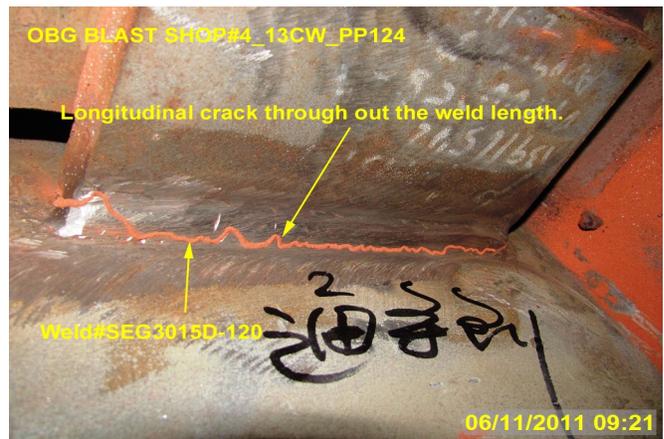
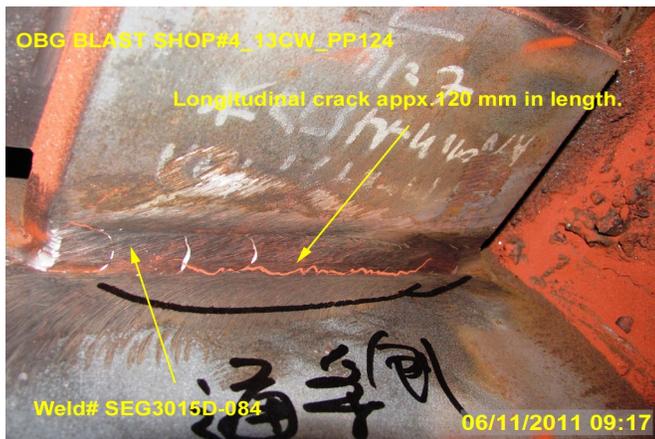
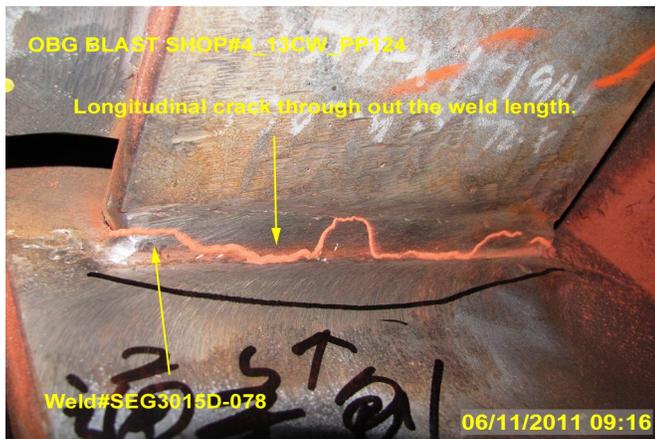
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3. SEG3015D-115,097,091,085,079
4. SEG3015F-194,195,188,189,182,183,176,177,170,171,164,165
5. SEG3015F-158,159,152,153,146,147,140,141,134,135,128,129,122
6. SEG3015F-123,116,117,110,111,105,098,099,092,093,087,088,082
7. SEG3014C-086,090,094,098,102,106,110,114,118,122,126,130
8. SEG3015L-091,096,101,106,111,116,121,126,131,136,141,146

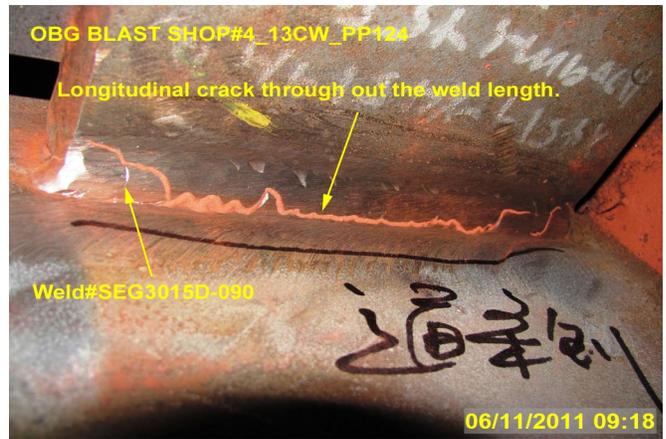
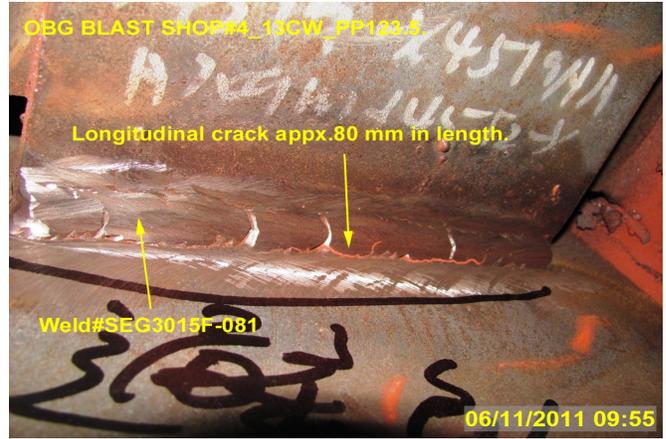
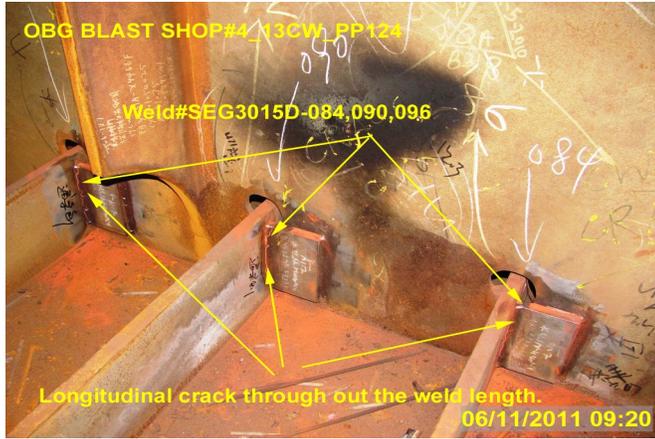
During random witness of weld joints is identified as SEG3015D-120,114,096,090,084,078 and SEG3015F-104, 081, this QA observed linear cracks on the welds. This QA along with ZPMC QC MT Technicians marked the affected areas and informed ZPMC Quality Control (QC) CWI indentified as Mr. An Qing Xiang of this issue. Mr. An Qing Xiang informed this QA that the cracks would be corrected in a manner compliant with the contract documents. This QA Inspector also informed to 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.

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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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