

**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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020769**Date Inspected:** 20-Jul-2010**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 Huajie.**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:** OBG Trial assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**SEGMENT # 9W:**

Shielded Metal Arc Welding (SMAW) welding of weld joint OBW9B-006/007(SP-SP, CW SIDE). Welder is identified as 045196,066326,069683,067765. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of welds joint CA059-005, CA061-001(SP-EP), Welder is identified as 068097. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2214-TC-U4b-FCM-1.

Flux Cored Arc Welding (FCAW) welding of welds joint DP672-001-021(9BW-9CW), Welder is identified as 037932. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3213-B-U3b.

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FCAW welding of welds joint BP098-001-020(9BW-9CW), Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-2233-B-U2-FCM.

### SEGMENT#9E

Flux Cored Arc Welding (FCAW) welding of welds joint OBE9C-006/007(SP-SP, 9DE-9EE), Welder is identified as 053609, 053742/051246, ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-T-2233T.

Shielded Metal Arc Welding (SMAW) welding of weld joint SEG056A-021(SP-BP).Welder is identified as 067942. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint SEG052A-045, SEG054A-014(9BE-9CE), And Critical Welding Repair Report (CWR) B-CWR-1679-1, Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06237

### Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG Bike Path weld. The weld designations reviewed are as follows.

1. BK004A7-055-003~012,027~0036, 063~072,099~108,125~135,161~173,200~213.
2. BK004A6-055-094.

During MT Observed One Indication as shown on fig. And after grinding found MT acceptable.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06240

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This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG Bike Path weld. The weld designations reviewed are as follows.

- 1.FB3203A-001-01~010

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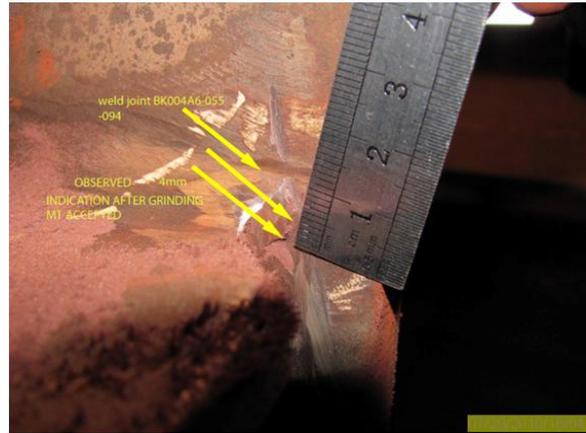
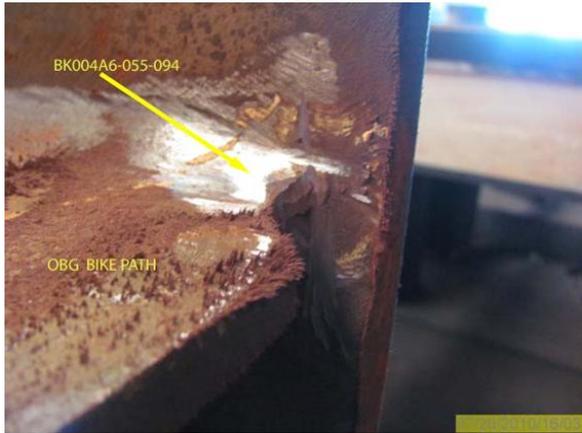
# WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## 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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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**Inspected By:** Tharikoppada,Reddy

Quality Assurance Inspector

**Reviewed By:** Miller,Mark

QA Reviewer

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