

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020831**Date Inspected:** 30-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. Zhao Chen Sun.**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:** TOWER (BAY 10& 11)**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:

BAY 10:

Shielded Metal Arc Welding (SMAW) welding of weld joint SSD1-TL5-1B/F-12,27,28,29,30, Welder is identified as 040581,052930,052493,056200,040582. ZPMC Quality Control (QC) is identified as Mr. Li Peng. The welding variables appeared to comply with the Applicable WPS-B-T-3313-TC-P5.

SMAW welding of welds joint NSD1-TL5-3F-F-12B/5A Welder is identified as 040273. ZPMC Quality Control (QC) is identified as Mr. Yu Zhi Lai. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3213-TC-U5b.

SMAW welding of welds joint SSD1-TL5-1F-F-15 Welder is identified as 037997,066326/067707,066443. ZPMC Quality Control (QC) is identified as Mr. Li Peng. The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3213-TC-P5.

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BAY 11:

Shielded Metal Arc Welding (SMAW) welding of weld joint ESD1-TL5-2B/F-13, Welder is identified as 040611. ZPMC Quality Control (QC) is identified as Mr. Mao Bin Bin. The welding variables appeared to comply with the Applicable WPS-B-T-3213-TC-U4c.

SMAW welding of welds joint ESD1-TL5-2B/F-26B, Welder is identified as 044541,044551. ZPMC Quality Control (QC) is identified as Mr. Mao Bin Bin . The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3213-TC-U5b.

SMAW welding of welds joint WSD1-SPSA5-17-1B, Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Mr. Li Jun . The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5b-1.

SMAW welding of welds joint ESD1-SPSA5-17-1B, Welder is identified as 046704. ZPMC Quality Control (QC) is identified as Mr. Li Jun . The welding variables appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5b-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06307.

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. The weld designations reviewed are as follows.

1. EP3017-001-024/025,028/029,032/033,036/037,053/054,057/058,061/062,

Visual Testing (VT)

This QA Inspector performed VT of the area previously Inspected and accepted by ZPMC Quality Control personnel. The member is identified as OBG. The weld designations reviewed are as follows.

1. EP3017-001-024/025,028/029,032/033,036/037,053/054,057/058,061/062,

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

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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.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
