

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-018194**Date Inspected:** 18-Nov-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:** 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:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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 randomly observed the following work in progress:

OBG TRIAL ASSEMBLY YARD

NDT:

Segment 11AW

This QA Inspector performed Ultrasonic Testing (UT) Verification inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations verified are as follows.

SEG065A- 002, 003.

Nondestructive testing (NDT) notification No. 07401

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WELDING:

Segment 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 053871 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-007; located On Orthotropic Box Girder (OBG) Side Plate to Side Plate Transverse CJP Weld. The Welding Repair Report (WRR) was B-WR17231. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

Segment 11CE ~ 11DE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE11-007; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate Transverse CJP Weld. The Welding Repair Report (WRR) was B-WR17233. ZPMC QC is identified as Mr. Wang Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1.

Segment 11EE

This QA Inspector observed ZPMC qualified welding personnel identified as 052910 perform Shielded Metal Arc Welding (SMAW), weld joint identified as LB4-003-075; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate PJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2314-TC-P4. See attached photo for further details.

Segment 11EW

This QA Inspector observed ZPMC qualified welding personnel identified as 045175 perform Flux Core Arc Welding (FCAW), weld joint identified as CSD9-PP108-153; located On Orthotropic Box Girder (OBG) Corner Assembly Floor Beam to Skin Plate Stiffener CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2333-TC-U4b-FCM

Cross Beam 16

This QA Inspector observed ZPMC qualified welding personnel identified as 044551 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA202A-016-013; located On Orthotropic Box Girder (OBG) Deck Plate to Side Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhou Peng. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2214-TC-U4b-FCM.

Unless otherwise noted, all work observed on this date appeared to generally comply with the 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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer