

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-019737**Date Inspected:** 29-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:** Lv Li Qing**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad 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:

BAY 14, OBG (NWIT # 7537)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3009V-043

BAY 14, OBG (NWIT # 7546)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3019AY-006

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BAY 14, OBG (NWIT # 7543)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3014L-191, 193~195 (EXTERIOR SIDE)

SEG3014L-192

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

AT PP119 (B-WR17728)

FCAW welding of weld joints 104 located on SEG3007V of segment 13AE.

Welder is identified as 066471. ZPMC QC is identified as Mr. Zhong Yong Gang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR-1.

Floor Beam (FB) 3154 TO Edge Beam (EB) 3027

SMAW welding of weld joints 400 located on SEG3011J of segment 13CE at PP123.

Welder is identified as 044772. ZPMC CWI is identified as Mr. Lv Li Qing.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1.

Segment 13AE

During random in process inspection this QA inspector observed that ZPMC personnel was performing welding on the weld joint SEG3007AT-055. The weld is Partial Joint Penetration (PJP) weld joining stiffener to sub assembly (SA) 3017A at panel point (PP) 119. The welder is identified as 066283. During welding the width of weld pass observed as approx 30mm in 3G position, which does not comply with the code. This issue has been discussed with ZPMC CWI Mr. Lv Li Qing and CT lead QA. Attached photographs provide additional information.

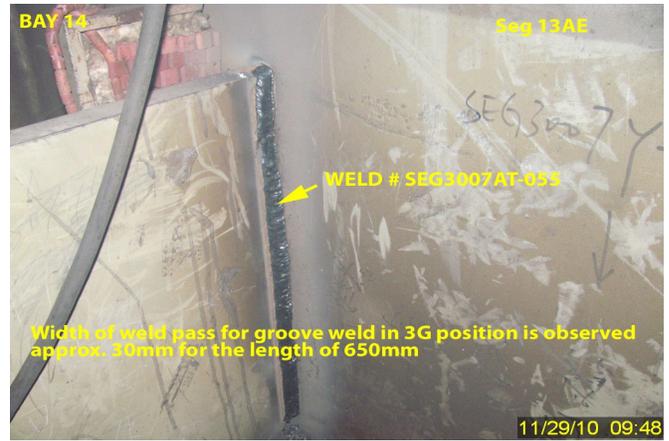
Segment 13CE

During random in process inspection this QA inspector observed that ZPMC personnel was performing repair welding on the weld joint FB3158A-001-005. The weld is Complete Joint Penetration (CJP) weld joining stiffener of floor beam at panel point (PP) 123.5. The welder is identified as 044772. The required documents provided by QC was mentioned that these CJP weld joints changed as Fillet weld. But the documents provided were not approved documents by engineer. This issue has been discussed with ZPMC CWI Mr. Lv Li Qing and CT lead QA. Attached photographs provide additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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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 Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer