

**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-021683**Date Inspected:** 11-Mar-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:** Zho Zhong Hai**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

**WELDING:**

## Segment 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040270 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA3005E-105; located On Orthotropic Box Girder (OBG) Deck Panel Diaphragm to Floor Beam Flange Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Zhu was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

## Segment 12CE

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## WELDING INSPECTION REPORT

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This QA Inspector observed ZPMC qualified welding personnel identified as 052910 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA3005D-091; located On Orthotropic Box Girder (OBG) Deck Panel Diaphragm to Floor Beam Flange Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Zhu was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

### Segment 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 069894 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3003E-010; located On Orthotropic Box Girder (OBG) Deck Panel Diaphragm to Floor Beam Flange Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Zhu was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

NDT :

Segment 12BE ~ 12CE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

SEG3001Z-013, 014, 027, 028, 041, 042

SEG3001Y-006, 007, 020, 021, 034, 035

Nondestructive testing (NDT) notification No.08509

Segment 12BE ~ 12CE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

OBE12A-001, 002, 003

CA6502-012, 010

Nondestructive testing (NDT) notification No.08515

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

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# WELDING INSPECTION REPORT

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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.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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