

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023949**Date Inspected:** 24-May-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:** 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:

Trial Assembly:-

Shielded Metal Arc (SMAW) welding of Weld Joint DP3133-001-030(13BW, Deck panel to Longitudinal Diaphragm Weld, CB Side), and Welding Repair Report(WR)B-WR21033, Welder is identified as 057220; ZPMC Quality Control (QC) is identified as Mr. An Qing Xing, The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3015M-100(13CW Floor beam I Rib Hold back weld, CB Side), and Welder is identified as 069896; ZPMC Quality Control (QC) is identified as Mr. An Qing Xing, The welding variables appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

Flux Cored Arc (FCAW) welding of Weld Joint SA7508-001-005~008(13BW+13CW Bottom splice plate weld, BK Side), and Welder is identified as 066825; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang, The welding variables appeared to comply with the Applicable

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WPS-B-T-2231-ESAB(CJP)/WPS-B-T-2131-ESAB(PJP).

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3014C-086(13BW Side panel I Rib to Floor beam Weld, CB Side), and Welding Repair Report(WR)B-WR21062, Welder is identified as 066156; ZPMC Quality Control (QC) is identified as Mr. An Qing Xing, The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G,(3F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3014C-130(13BW Side panel I Rib to Floor beam Weld, CB Side), and Welding Repair Report(WR)B-WR21062, Welder is identified as 044541; ZPMC Quality Control (QC) is identified as Mr. An Qing Xing, The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G,(3F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013AH-095(13AW KP I Rib Weld), and Welder is identified as 067588; ZPMC Quality Control (QC) is identified as Mr. A QING Xing, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 09237.

Magnetic Partical 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 14 East welds, the weld designations reviewed are as follows.

1. SEG3019AL-009 (MT Done at Face A)

The following Non Destructive Testing (NDT) Inspection carried out as per the ABF submitted Notification No. 05242011-2.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between decks plates to deck plate splice weld joint located on 14East at bike path side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows:

1. SEG3019*-007.

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

Summary of Conversations:

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