

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-018016**Date Inspected:** 01-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 Xing	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 COMPONENT	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 11BE to 11CE, weld No.SP596-001-043. The welder is identified as #050289. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

FCAW in the 2F position for the OBG segment 11BE to 11CE, weld No.SP556-001-058. The welder is identified as #040458. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG segment 11DE to 11CE, weld No.SP551-001-008. The welder is identified as #040458. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 4G position for the OBG segment 11BE to 11CE, Base metal repair near weld joint .OBE11-008. The welder is identified as #040320. ZPMC QC is identified as Mr. Liu Hua Jie. The welding variables recorded

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR-1. The repair welding report is identified as CWR-1957.

SMAW in the 4G position for the OBG segment 11CE, weld No.SEG070A-011.The welder is identified as #500363. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 11CW to 11DW, weld No.BP107-020.The welder is identified as #044551. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

Bay#9

This QA Inspector observed the following work in progress:

During random visual inspection I OBG service platform at bay#9 the QA inspector observed that the ZPMC MT technician performing MT at service platform component and found one transverse crack like indication at weld joint SP4-B-1-002. The Y distance of the indication is approximately 350mm from bottom cope hole. After that the QA inspector informed to ZPMC QC Mr.Chen Shi Gang to make CWR for repair that mention weld .For more information see the attached photo.

During Quality Assurance (QA) random visual inspection of OBG service platform component external surfaces after grit blasting at front of blast shop no.2 this Caltrans (CT) QA Inspector observed the following issue that ZPMC has created two weld joints that are not detailed on the approved shop drawings, without the Engineers approval. The components are identified as SP5-13 & SP6-13(Ø89mm extra strong pipe).The approved shop drawings are identified as SP5-8 and SP6-8. OBG service platform component located at front of blast shop no.2. For further information, please see the attached pictures.

This QA generated an incident report on this date.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 4)



Summary of Conversations:

No relevant conversations

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 150-0042-2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	McClendon,Timothy	QA Reviewer
---------------------	-------------------	-------------