

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-018258**Date Inspected:** 20-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:** Xu Xian Ping**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 date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # Crossbeam CB18

This QA observed ZPMC qualified welding personnel identified as 054467 perform Shielded Metal Arc Welding (SMAW) Process repair welding on various weld joints. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng zhi wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

During the Caltrans Quality Assurance in-process observations of the fabrication of Crossbeam CB18, this Quality Assurance Inspector (QA) discovered the following issue. One mill to bear surface that did not appear to comply with the contract documents. Shear key tie down seat vertical stiffener plate to bottom panel gap measured approximately 2mm for approximately 110mm. The total width of the tie down seat vertical stiffener plate is 260mm length. As per approved shop drawing the tie down seat vertical stiffener shall have a mill to bear fit to the bottom panel. The vertical stiffener is near CB3002E Intermediate Web Panel- 1 (East side panel). This QA notified ZPMC QC identified as Mr. Zheng zhi wei of this issue and that an incident report would be generated. For further information, please see the attached pictures below.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG # SEGMENT 11DE

This QA observed ZPMC qualified welding personnel identified as 041713 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SEG072D-022,023. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu yuan yuan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

OBG # SEGMENT 11DW

This QA observed ZPMC qualified welding personnel identified as 046704 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SSD25-PP105-145,146. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu yuan yuan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113-FCM-1.

OBG # SEGMENT 12AW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12AW at panel point 111 to panel point 112.5, after the grit blast of the internal components of the Side panels, bottom panels, Corner assembly, and longitudinal diaphragm of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

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



Summary of Conversations:

As mention above

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 150-00422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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