

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-018378**Date Inspected:** 27-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:** Geng Wei**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 13AE I-RIB (NWIT # 7512)

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.

VP3007-001-001, 004, 007, 010, 013, 016, 019, 022, 026, 029, 032, 035

VP3007-001-039, 042, 045, 048, 052, 055, 058, 061, 065, 068, 071, 074

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

Bay 14

BP3010 TO SP 3060 (B-WR16170)

FCAW welding of weld joints 012 located on SEG3011 of segment 13CE at PP124.5.

Welder is identified as 044824. ZPMC CWI is identified as Mr. Lv Li Qing.

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

FB 3119 TO LD 3026 (B-WR17559)

SMAW welding of weld joints 170 located on SEG3007C of segment 13AE at PP120.

Welder is identified as 215553. ZPMC QC is identified as Mr. Zhong Yong Gang.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1.

LD 3025 TO FB 3119

FCAW welding of weld joints 125 located on SEG3007B of segment 13CE at PP120.

Welder is identified as 050242. ZPMC QC is identified as Mr. Zhong Yong Gang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G(3F)-REPAIR-1.

LIFT 14E

During random in process inspection this QA inspector observed that a ZPMC NDT personnel was performing Ultrasonic Testing (UT) on the weld joints of Longitudinal Diaphragm (LD 3042) to Bottom Plate (BP 3082) of OBG lift 14E. During inspection ZPMC NDT personnel found UT rejectable non conforming indications; these indications are clearly marked on the components. ZPMC personnel found third time rejectable indications on same locations of the same weld numbers previously tested. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3091AB-091, 092, 093, 095, 096

Segment 13CE

During random in process inspection this QA inspector observed that ZPMC personnel was performing repair welding of the weld joints of stiffener of side panel to Floor Beam (FB 3150) of OBG segment 13CE at PP122.5. During welding there was no run on/off tab at the end of weld joints identified as SEG 3011L-193, 198, 203, 213, 218. Welder is identified as 044772. This QA inspector informed ZPMC CWI Mr. Geng Wei and CT lead QA regarding this issue. Attached photographs provide additional information.

Segment 13BE

During random in process inspection this QA inspector observed that ZPMC personnel were performed and marked non conforming UT rejectable indications on the Complete Joint Penetration (CJP) welds. The welds are identified as joining the stiffener of side panel to Floor Beam (FB3134) at panel point (PP 120.5). 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: Clifford,William

QA Reviewer