

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-018615**Date Inspected:** 10-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei.**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 OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, CB15, PP099, 11BE side.

During Random Visual in process Inspection, this QA inspector observed repair excavation of butt joint at partial diaphragm inside Crossbeam 15. This QA inspector has been informed that the excavation was performed according to ZPMC UT report "B787-UT-16472"; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The attached photographs provide additional detail.

Trial assembly yard, CB17, DP-SP (East).

SMAW Repair welding of weld joint CB3001A-017-002 (WRR# B-WR18721); located at Trial assembly yard. Welder is identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Feng Ya Jun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-REPAIR-1.

Trial assembly yard, CB17, DP-SP (West).

SMAW Repair welding of weld joint CB3001A-017-020 (WRR# B-WR18722); located at Trial assembly yard. Welder is identified as 067904; ZPMC Quality Control Inspector (QC) is identified as Feng Ya Jun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-REPAIR-1.

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Trial assembly yard, 11AW-12BW, EP-B3.

SMAW welding of weld joint CA3012-007; located at Trial assembly yard. Welder is identified as 044551; ZPMC Quality Control Inspector (QC) is identified as Shi Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1.

Trial assembly yard, 11AW-12BW, EP-F9.

SMAW welding of weld joint OBW12-003; located at Trial assembly yard. Welder is identified as 040656; ZPMC Quality Control Inspector (QC) is identified as Shi Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1.

Trial assembly yard, Connection Plate.

FCAW welding of weld joint USPL1-654-001; located at Trial assembly yard. Welder is identified as 053486; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-ESAB. The attached photographs provide additional detail.

This QA Inspector carried out NDE on following

Trial assembly yard, 11BW CB 15 extension.

This QA inspector performs Random Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel (NWIT # 07712). This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as

SSD027-PP099-163 to170, 172, 173, 175, 176, 141 to 144, 125 to 128, 111 to 114, 085, 086, 089 to 096, 224, 225, 103, 104, 106, 065, 066, 053, 054, 043 to 046, 019, 020, 023, 024, 027, 028, 030, 033, 035, 036.

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



Summary of Conversations:

No relevant conversations.

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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, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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