

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-019007**Date Inspected:** 30-Dec-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:** Liu Hua Jie**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 day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG Segment 12AE to 12BE for splice joint of bottom plate to bottom plate, UT repair weld No. OBE12B-001. The welder is identified as #044515. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The repair report is identified as WR19699.

SMAW in the 4F position for the OBG Segment 12AW, weld No. LD3020-001-049. The welder is identified as #041713. ZPMC QC is identified as Mr. Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 1G position for the OBG Segment 12AW to 12BW for near deck plate splice joint weld No. OBW12-001. The welder is identified as #057333. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The repair report is

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identified as WCWR2126.

SMAW in the 3G position for the OBG Segment 12AE for Stiffener RS3004A buttering weld. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The repair report is identified as WR19617.

Bay#11

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG bike path, weld No.BK004ASD1-003-022. The welder is identified as #040655. ZPMC QC is identified as Mr. Yu Dong Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2211-Tc-U4b.

SMAW in the 1G position for the OBG bike path, weld No.BK004ASD1-003-003. The welder is identified as #046769. ZPMC QC is identified as Mr. Yu Dong Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2211-Tc-U4b.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between edge Plate to edge Plate for OBG segment 12AE at bike path side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA6502-007

CWR verifications(CWR2510 R2)

Type – (D-scan)

This QA Inspector was notified via email for verification of B – CWR2510 R2 at 1620 hours the following was observed:

- The component for verification was identified as CA3006-002 (12AW edge panel to deck panel field splice holdback @ W2)
- Weld repair was to be performed on location where rejectable indication was observed during Ultrasonic Testing (UT)
- ZPMC QC Zhou Zhog Hai was present on site to direct and record all repair work.
- WPS to be used for repair was WPS-345-SMAW-2G(2F)-FCM-Repair-1.

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

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ZPMC personnel performing SMAW for weld joint BK004-ASD1-003-022 at 1G position on Bike path at bay#11



The ABF QA inspector performed D-Scan Ultrasonic Testing for splice joint joining between side plate to side plate at crossbeam side on segment 12AE to 12BE at trial assembly area



ZPMC personnel performing SMAW for buttering weld on stiffener RS3004A at 3G position on segment 12AE



ZPMC performing Carbon Arc Back Chouging for UT repair splice joint joining between Side plate to side plate at bikepath side on Segment 12AE to 12BE



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.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer
