

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-019298**Date Inspected:** 12-Jan-2011**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:

FCAW in the 1G position for the OBG Segment 12BW to 12CW for splice joint weld No. OBE12A-001. The welder is identified as #040759. ZPMC QC is identified as Mr. Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2231(T)-ESAB.

During random visual inspection at trial assembly area, before root pass welding of splice joint OBE12A-001, this QA inspector verified the root opening of this joint and found accepted according to the approved WPS. The data recorded for root opening approx. 8~12 mm. And after root pass this QA found lots of visual longitudinal crack found at center of the weld and informed to ZPMC QC and ABF QA to verify with magnetic particle testing. The QA witnessed the MPT and recorded all Y location of repaired area for future verification. For details please refer the attached photo.

SMAW in the 4G position for the OBG Segment 12BE to 12CE weld No. OBE12C-001. The welder is identified

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as #040320. 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 12BW to 12CW weld No.BP3024-001-037. The welder is identified as #046704. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 3G position for the OBG Segment 12BW to 12CW weld No.BP3023-001-038. The welder is identified as #040611. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

FCAW in the 2F position for the OBG Segment 12BW for weld No.BP3022-001-027/028. The welder is identified as #040736. ZPMC QC is identified as Mr.Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-T-2132-ESAB.

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 butt joint joining between side Plate to bottom 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

SEG3001A-004

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 butt joint joining between side Plate to bottom Plate for OBG segment 12BE 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

SEG3002A-004

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 deck Plate to deck Plate for OBG segment 12AE to 12BE. 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.

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The Weld Designation is as follows

OBW12-003

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



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