

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019434**Date Inspected:** 09-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Shi Lei (east) Bao Lei Zhang (west)			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 Kenneth Riley 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 Chang Xing Island in Shanghai, China.

Bay 9

On this date the QA inspector was present at ZPMC to witness the welding of U-Ribs to Deck plates for two (2) deck panels with the following identification numbers, DP3136(PL3332A&B)-001 and DP3138(PL3334A)-001. It was observed that ZPMC had 4 welders at gantry #2, welders identifications and the welds that were welded by each welder per deck panel are as follows;

DP3136(PL3332A)-001

203805-W001, W003 / 059378-W002, W004 / 059418-W005, W007 / 059421-W006, W008 / 059416-W009 / 201788-W010

DP3136(PL3332B)-001

203805-W171, W173 / 059378-W172, W174 / 059418-W175, W177 / 059421-W176, W178 / 059416-W179 / 201788-W180

DP3138(PL3334A)-001

059418-W005, W007 / 059421-W006, W008 / 059416-W047 / 201788-W048

ZPMC had a CWI Quality control personnel onsite who was identified as Zhao Zhong Jie. The Deck Panels that were being welded are SPMC material and the following Welding Procedure Specification (WPS) was followed;

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2342-U1-Rev 5, which includes a 60 degree celsius minimum preheat for welding which this QA inspector had witnessed and observed. During the welding of the GMAW root pass on Deck Panel DP3136 plate A, the equipment malfunctioned and the welding had stopped at a Y location of 2280mm for weld W009 and W010 at approximately 1504 hrs due to equipment malfunction. At Approximately 1630 hrs the area had been ground and Magnetic Particle (MT) was performed by ZPMC Quality Control (QC) personnel. ZPMC and ABF representatives witnessed this process and agreed with the acceptable results. ZPMC completed the welding process of the above stated Deck Panels at approximately 2030hrs.

Bay 1

This QA Inspector observed the following work in progress: FCAW welding of weld joint 11 located on PCMK, 2OTR2. Welder is identified as 203710. ZPMC QC is identified as Zhu Tian Shu. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G-Repair. This is a weld repair under B-WR-13438.

Bay 2

This QA Inspector observed the following work in progress: FCAW welding of weld joint 084 and 085 located on PCMK- FB3178-001. Welder is identified as 045276. ZPMC QC is identified as Zhu Tian Shu. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Bays 3-8

No welding was observed at the time this QA Inspector was present at these locations.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Conversations This date.

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:	Riley, Ken	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------