

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-019541**Date Inspected:** 29-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:** Qiu Wen**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 13BW (NWIT # 08306)

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.

SA3231-011

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

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: SEG3020E-056 [Bottom Plate (BP) 3093A to Floor beam (FB) 3343A, complete joint penetration (CJP) weld at panel point (PP) 128.3]. The welder is identified as 066398 and was observed

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2734 Rev-1.

Repair welding of weld joint no: SEG3020D-052 [Bottom Plate (BP) 3092A to Floor beam (FB) 3343A, complete joint penetration (CJP) weld at panel point (PP) 128.3]. The welder is identified as 066038 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2734 Rev-1.

Repair welding of weld joint no: SEG3020BB-019 [Vertical Shear Plate, Sub Assembly (SA) SA3445A to Bottom Plate (BP) 3088A, complete joint penetration (CJP) weld]. The welder is identified as 067942 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2752 Rev-0.

Repair welding of weld joint no: SEG3020AL-005 [Side Plate (SP) 3142C to Floor beam (FB) 3321A, complete joint penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 067609 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 18585 Rev-0.

OBG Seg 13BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: DP3133-001 [X4126A to X4079M stiffeners on Deck Panel (DP) 3133A, complete joint penetration (CJP) weld at Panel Point (PP) 122]. The welder is identified as 037840 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with welding procedure specification (WPS): B-P-2213-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3133-026 (X4126B to X4079M stiffeners on DP3133A, CJP weld at PP121.5). The welder is identified as 037932 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

OBG Seg 13AW:

The SMAW process on weld joint no: SEG3013P-207 [RS3431A I-rib stiffener on Side Panel (SP) 3099A to Floor Beam (FB) 3180A, CJP weld at PP118]. The welder is identified as 066361 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

with WPS: B-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013P-149 (RS3432C I-rib stiffener on SP3100A to FB3180A, CJP weld at PP118). The welder is identified as 067876 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

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

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
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Reviewed By:	Peterson,Art	QA Reviewer
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