

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019683**Date Inspected:** 30-Nov-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:** Mr. An Qing Xing.**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 TRIAL ASSEMBLY**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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:

This QA Inspector observed the following work in progress:

Lift 11EE

Flux Cored Arc (FCAW) welding of Weld Joint SEG074A-011 (11EE, CB Side), And Welder is identified as 047353; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2231-ESAB.

Shielded Metal Arc (SMAW) welding of Weld Joint BP190-001-025,026 (11EE, T Ribs, Hold back, CB Side), And Welder is identified as 053871; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS- B-P-2112-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint BP136-001-035,036 (11EE, T Ribs, Hold back, BK Side), And Welder is identified as 044515; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS- B-P-2112-FCM-1.

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Lift 12AE:

Shielded Metal Arc (SMAW) welding of Weld Joint CA3001-002 (12AE,BK Side), And Welder is identified as 040320; ZPMC Quality Control (QC) is identified as Mr. An Qing Xing. The welding variables appeared to comply with the Applicable WPS- B-P-2214-TC-U4b-FCM-1.

LIFT 11W:-

Heat straitening:

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as \_\_\_\_11EW Longitudinal Diaphragm. Distortion appeared to be caused by welding . ZPMC Quality Control (QC) inspector identified as Mr. Zhu Zhong Hai was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1(B) -9552.

BAY 11:

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07560

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Bike path welds. The weld designations reviewed are as follows.

1. BK004A1-023-043

Note:-Green tag.13858 has been signed for above weld joint.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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**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.

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<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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