

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-019740**Date Inspected:** 03-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:** Lv Li Qing, Liu Yang**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 (NWIT # 7595)

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.

SEG3014R-001

AP3013-001-004, 007

AP3014-001-025

AP3016-001-007

BAY 14, OBG (NWIT # 7602)

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.

WELDING INSPECTION REPORT

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FB3233-001-021

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

Bay 14

SEGMENT 14E

Repair welding by FCAW (ESAB) process of weld joint SEG3019A-009 joining Bottom Plate (BP) to Side Panel (SP) of segment 14E. Welder is identified as 044824. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-ESAB-REPAIR.

SEGMENT 13AE (B-WR17556)

Repair welding by SMAW process of weld joint SEG3007G-017 joining Floor Beam (FB) to Longitudinal Diaphragm (LD) at panel point (PP) 119+1500 of segment 13AE. Welder is identified as 200113. ZPMC CWI is identified as Mr. Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1.

SEGMENT 13AW

Welding by SMAW process of weld joint SEG3013Y-013 at panel point (PP) 119 of segment 13AW. Welder is identified as 066413. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U4b-FCM.

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
Reviewed By:	Patterson,Rodney	QA Reviewer
