

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-019741**Date Inspected:** 04-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, Geng Wei**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:

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

Bay 14

SEGMENT 13AW

Welding by SMAW process of weld joint SEG3013A-015 joining Bottom Plate (BP) to Side Panel (SP) of segment 13aw. Welder is identified as 037723. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

SEGMENT 13AW

Welding by FCAW process of weld joint SEG3020-010 joining Deck Panel (DP) 3176 to Deck Panel (PP) 3177 of segment 13AW. Welder is identified as 045175. ZPMC CWI is identified as Mr. Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T2231-ESAB.

SEGMENT 13BW

Welding by SMAW process of weld joint SEG3014K-116, 118 joining stiffener to Longitudinal Diaphragm (LD)

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3032 at panel point (PP) 121 of segment 13BW. Welder is identified as 037932. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

Welding by SMAW process of weld joint SEG3014K-115, 117 joining stiffener to Longitudinal Diaphragm (LD) 3032 at panel point (PP) 121 of segment 13BW. Welder is identified as 037932. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

SEGMENT 13CW

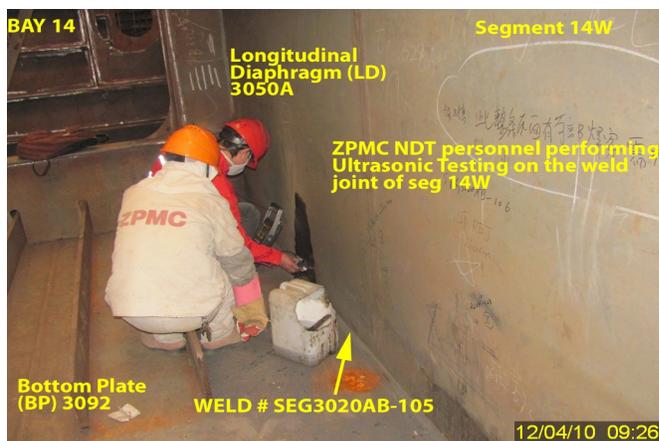
Welding by SMAW process of weld joint SEG3015M-187, 189 joining Floor Beam (FB) 3228 to Longitudinal Diaphragm (LD) 3032 at panel point (PP) 124 of segment 13CW. Welder is identified as 0045916. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

Welding by FCAW process of weld joint SEG3015D-311, 312 joining stiffener of side panel at panel point (PP) 124 of segment 13CW. Welder is identified as 0045143. ZPMC QC is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

During random in process inspection this QA inspector observed that ZPMC NDT personnel were performing Ultrasonic Testing (UT) on the weld joint SEG3020AB-105 joining Longitudinal Diaphragm (LD) 3050A to Bottom Plate (BP) 3092 of segment 14W. During inspection ZPMC NDT personnel found UT rejectable indication on the same location where the weld joint was previously rejected twice. Attached photograph provide additional details.

During random in process inspection this QA inspector observed that ZPMC personnel performing free hand thermal cutting on the edge of stiffener of floor beam hinge FB3286-001. The thickness of the part was identified as 45mm and 350mm length. As per contract document guide has to be used for the thermal cutting. This issue has been discussed with ZPMC CWI Mr. Geng Wei and CT lead QA. ZPMC CWI Mr. Geng Wei agreed to use guide for further work as per contract document. Attached photograph provide additional details.

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

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
