

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-019746**Date Inspected:** 11-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:** 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 (NWIT # 7735)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3009B-026, 044, 030, 048, 036, 037, 054, 055, 042, 043, 060, 061, 018, 019

SEG3009C-071, 047, 048, 065, 066, 041, 042, 059, 060, 037, 038, 055, 056, 073, 074

SEG3009D-018, 019, 042, 043, 060, 061, 036, 037, 054, 055, 030, 048, 026, 027, 044, 045

SEG3009E-071, 072, 047, 048, 065, 066, 041, 042, 059, 060, 073, 074

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

Bay 14

SEGMENT 13AW

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding by SMAW process of weld joint SEG3013K-047 at Panel Point (PP) 119-1500 of segment 13AW. Welder is identified as 037780. ZPMC CWI is identified as Mr. Qiu Wen. The weld length observed to be 1700mm approximately and the repair length observed to 570mm approx. The weld is identified as Fracture Critical Weld (FCW). For this length engineer approval is required as per AWS D1.5 but ZPMC personnel was performing repair as per B-WR18560, without approval of engineer. This issue has been discussed with ZPMC CWI Mr. Qiu Wen. Attached photograph provide additional details.

SEGMENT 13AW

Welding by SMAW process of weld joint SEG3013D-219 of segment 13AW. Welder is identified as 066163. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2a-FCM-1.

Welding by SMAW process of weld joint SEG3013H-020 of segment 13AW. Welder is identified as 045221. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2a-FCM-1.

Welding by SMAW process of weld joint SEG3013P-006 of segment 13AW. Welder is identified as 070432. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2a-FCM-1.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Gaikwad,Umesh Quality Assurance Inspector

Reviewed By: Patterson,Rodney QA Reviewer