

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019947**Date Inspected:** 07-Sep-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:** Orthotropic Box Girder (OBG)**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:

SEGMENT # 10W:

Shielded Metal Arc Welding (SMAW) welding of welds joint OBW10C-002,003(10BW+10CW, BP-BP,SP-SP), and Welder is identified as 067656,066361,068917,067752. ZPMC Quality Control (QC) is identified as Mr. zhu Peng . The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of welds joint CA073-006/CA077-002 (10BW+10CW), and Welder is identified as 037713. ZPMC Quality Control (QC) is identified as Mr. zhu Peng . The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-F-1.

SMAW welding of welds joint SEG059-35/CA074-006(10AW+10BW), and Welding Repair Report(WR) B-WR14934, And Welder is identified as 047356. ZPMC Quality Control (QC) is identified as Mr. zhu Peng . The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair.

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Flux Cored Arc (FCAW) welding of weld joint SEG063C-014/SEG061C-030(10BW+10CW,CB Side), and Welder is identified as 040604. ZPMC Quality Control (QC) is identified as Mr. Zhu Peng. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of weld joint SEG063B-011(10BW+10CW), and Welder is identified as 040609. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U4b-F.

SEGMENT 10E

Shielded Metal Arc Welding (SMAW) welding of welds joint SEG060B-001-006,036, (10AE,PP88), and Welder is identified as 044504. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of welds joint OBE10B-003(10AE+10BE), and Welding Repair Report(WR) B-WR14945, Welder is identified as 040320. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM.

Flux Cored Arc (FCAW) welding of weld joint OBE10B-005(10AE+10BE), and Welding Repair Report (WR) B-WR14937, Welder is identified as 047353. ZPMC Quality Control (QC) is identified as Mr. Liu Huajie. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

SEGMENT 9W & 9E:

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06598

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as 9E & 9W MEPS weld. The weld designations reviewed are as follows.

SEGMENT 9BW & 9DW:

- 1.DP684-001-032,036(9BW)
- 2.DP671-001-032,036(9BW)
- 3.DP686-001-024,028(9DW)

SEGMENT 9BE & 9DE:

- 1.DP710-001-022,028(9BE)
- 2.DP710-001-024,028(9DE)

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06607

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Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as 9E DRIP PLATE weld. The weld designations reviewed are as follows.

1.OBE9G-010.011,023,024

2.OBE9F-011,022,024,025

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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