

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-020242**Date Inspected:** 29-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:** Mr. Zhu Zhong Hai.**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 Shailesh 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:

NDT

OBG TRAL ASSEMBLY

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Segment 12 AE~ 12BE. The weld designations reviewed are as follows.

BP3001-001-026, 030

BP3002-001-030

SP3013-001-076

SP3014-001-084, 088

SP3002-001-195

SP3003-001-240, 243

NDT Notification No-07974

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This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

OBG Segment 12AE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040270, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE Deck plate Bevel edge base metal repair. ZPMC CWI Identified as An Qing Xiang with Critical welding repair report CWR-B-CWR2129. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G, 3G (2F, 3F) FCM-Repair-1.

OBG Segment 12AE~12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 040611 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW~12BW Side plate to Side plate joint VT repair, cross beam side . ZPMC QC Identified as Zhou Peng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG Segment 12AE~12BE Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 044515, 050289 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE~12BE Deck plate to Deck plate joint from inside. ZPMC QC Identified as Wang Li Yang with Temporary welding repair report WRR-B-WR19643. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. For more information see below attached picture number 1.

OBG Segment 12AW~12BW

This QA Inspector observed ZPMC qualified welding personnel identified as 041713 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW~12BW Side plate to Side plate I Ribs joint, counter weight side . Joint identified as SP3049-001-054~062. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Ultrasonic Testing:

This QA Inspector observed AB/F Ultrasonic Testing Inspector, performed UT "D" scan on OBG Segment 12AW~12BW Bottom plate to Bottom plate joint. Joint identified as OBW12B-001. For more information see below attached picture number 2.

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 phone :150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
