

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-020278**Date Inspected:** 06-Feb-2011**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:

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

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: SEG3020D-052 [Bottom Plate (BP) 3092A to Floor beam (FB) 3343A, complete joint penetration (CJP) weld at panel point (PP) 128.3]. The welder is identified as 066038 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Wang Xiang Pin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2734 Rev-1.

Repair welding of weld joint no: SEG3020X-012 [Bottom Plate (BP) 3091A to Longitudinal Diaphragm (LD) 3049A, complete joint penetration (CJP) weld in between Panel Point (PP) 125.5~126]. The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc

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Welding (SMAW). AB/F QA was identified as Mr. Xiao Jun Peng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2659 Rev-2.

Repair welding of weld joint no: SEG3020X-010 [Bottom Plate (BP) 3091A to Longitudinal Diaphragm (LD) 3049A, complete joint penetration (CJP) weld in between Panel Point (PP) 124.5~125]. The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). AB/F QA was identified as Mr. Xiao Jun Peng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2659 Rev-2.

The FCAW process on weld joint no: SEG3020M-186 (Edge Beam (EB) 3056A to Floor Beam (FB) 3329A, CJP weld at PP127). The welder is identified as 066421 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

Repair welding of weld joint no: SEG3020X-011 [Bottom Plate (BP) 3091A to Longitudinal Diaphragm (LD) 3049A, complete joint penetration (CJP) weld in between Panel Point (PP) 125~125.5]. The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). AB/F QA was identified as Mr. Xiao Jun Peng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2659 Rev-2.

The FCAW process on weld joint no: SEG3020P-207 (Edge Beam (EB) 3056A to Floor Beam (FB) 3319A, CJP weld at PP126.5). The welder is identified as 066421 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

During random in process inspection this QA inspector observed that the weld joint SEG3020D-317, joining stiffener X8503A of Floor Beam (FB) 3343A to Longitudinal Diaphragm (LD) 3051A at Panel Point 128.3. This weld joint observed welded as a fillet weld. As per approved shop drawing this weld joint shown as Complete Joint Penetration (CJP) weld. This issue had been discussed with ZPMC CWI Mr. Qiu Wen, AB/F QA Mr. Xiao Jun Peng on 31st Jan 2011. This QA inspector observed that ZPMC personnel was performing carbon air arc gouging for excavation of fillet weld to change the weld joint as CJP. 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:	Peterson,Art	QA Reviewer
