

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-020289**Date Inspected:** 08-Jan-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:** 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:

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY**OBG Segment 12AE+12BE Repair Welding**

This QA Inspector observed ZPMC qualified welding personnel identified as 040378 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AE+12BE Edge plate to Edge plate joint VT repair. Joint identified as OBE12-001. ZPMC QC Identified as Liu Hua Jie with. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F) FCM-Repair-1. For more information see below attached picture number 1.

OBG Segment 12BW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BW Bottom plate to Side plate joint Cross beam side. Joint identified as SEG3005M-90. ZPMC QC Identified as Shi Lei with temporary welding repair report WRR-B-WR20086. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) FCM-Repair-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Segment 12BE+12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 044515, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BE+12CE Side plate T Rib hold back. Joint identified as SP3018-001-026. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1. For more information see below attached picture number 2.

OBG Segment 12BE+12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 050289, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12BE+12CE Side plate T Rib hold back. Joint identified as SP3017-001-027. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112-FCM-1.

OBG Segment 12AW+12BW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW+12BW Side plate to Bottom plate joint. Joint identified as SEG3004A-001 and SEG3005A-003. ZPMC QC Identified as Shi Lei with Critical welding repair report CWR-B-CWR2725. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG Segment 12AW+12BW Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 046709, Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW+12BW Bottom plate to Bottom plate joint. Joint identified as OBW12B-001. ZPMC QC Identified as Liu Hua Jie with Critical welding repair report CWR-B-CWR2679. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1.

OBG Segment 12BE+12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 040458, Perform Flux Core Arc Welding (FCAW) on OBG segment 12BE+12CE Bottom plate to Bottom plate joint. Joint identified as OBE12C-001. ZPMC QC Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231(T)-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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