

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020522**Date Inspected:** 09-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU HUA JIE**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 Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for side plate located on 12AW+12BW at counter weight side. The weld is designated as SP3049-001-058. The welder is identified as 057333. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Fillet welds joining the T-Rib to side plate hold back weld joint located on 12AW+12BW at counter weight side. The weld is designated as SP3040-001-020(12AW) & SP3050-001-007(12BW). The welder is identified as 049220. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2131-ESAB.

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ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to deck plate hold back weld joint located on 12AW+12BW at counter weight side. The weld is designated as CA3007-006(12AW) & CA3008-002(12BW). The welder is identified as 044551. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Base Metal Repair weld (temporary attachment removal area) near the bottom plate to side plate hold back weld joint located on east side of 11EW at counter weight side. The welder is identified as 057333. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-1842.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Fillet welds joining the I-Rib to deck plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as DP708-001-013(11EE) & DP3001-001-012(12AE). The welder is identified as 040320. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-T-4114-1.

2. NDT:

Magnetic Particle Testing (MT):

MT carried out as per the ZPMC submitted Notification No 07696.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area that has been previously tested and accepted by ZPMC MT technicians. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

1. OBW11A-006
2. OBW11A-007
3. OBW11A-008
4. OBW11A-009
5. OBW11A-010.

MT not done for the ZPMC submitted Notification No 07699 Item number 1.

The Notification cancelled by ZPMC Quality Assurance (QA) due to Visual Testing (VT) not accepted. The weld number is identified as

1. SSD024-PP104.5-001 & 002,
2. SSD024-PP105.5-001 & 002,
3. SSD024-PP106.5-001 & 002,

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- 4. SSD024-PP107.5-003 & 004,
- 5. SSD024-PP108.5-003 & 004.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

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

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
