

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020525**Date Inspected:** 05-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 Flux Core Arc Welding (FCAW) of Fillet welds joining the T-Rib to side plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as SP560-001-037(11EE) & SP3002-001-030(12AE). The welder is identified as 040367. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2132-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-104 & PP-105). The weld is designated as SSD25-099-103. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-18301.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the bottom plate to side plate hold back weld joint located on 11EE+12AE at bike path side. The weld is designated as SEG3001A-014(12AE). The welder is identified as 067765. ZPMC QC Mr. ZHANG QIANG 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 Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-104 & PP-105). The weld is designated as SSD25-099-032. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-18307.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the bottom plate to side plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as SEG3001A-011(12AE). The welder is identified as 067765. ZPMC QC Mr. ZHANG QIANG 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 Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11BE+CB-15 at Panel Point between (PP-099 & PP-100). The weld is designated as SSD27-099-137. The welder is identified as 044515. ZPMC QC Mr. LI YANG 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 WR-18013.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-104 & PP-105). The weld is designated as SSD25-099-032. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-18307.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-104 & PP-105). The weld is designated as SSD25-099-103. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The weld repair report number is named as WR-18301.

2. NDT:

Magnetic Particle Testing (MT):

MT carried out as per the ZPMC submitted Notification No 07636.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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: DP721-001-020, DP708-001-020, CA092-005, SEG071A-049, DP695-001-021.

MT carried out as per the ZPMC submitted Notification No 07636 Item No 16.

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: EP141-002-021, 022, EP142-001-005, 006, DP694-001-017, 018 DP695-001-011, 012, SP685-002-057, 058, SP686-001-017, 018.

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
