

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020835**Date Inspected:** 25-Jul-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. An Qing Xing**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) / TOWER ASS**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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:

SEGMENT # 9W:

Shielded Metal Arc Welding (SMAW) welding of Base Metal Repair for SP to SP (9BW+9CW), And Critical Welding Repair Report (CWR) B-CWR-1674, and Welder is identified as 067571. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-REPAIR-1.

Flux Cored Arc Welding (FCAW) welding of welds joint OBW9C-004(9CW+9DW, SP-SP), Welder is identified as 066734,070140,046706. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2233T.

FCAW welding of welds joint OBW9C-002(9CW+9DW, SP-SP), Welder is identified as 066746,067550,067752. ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. The welding variables appeared to comply with the Applicable WPS: WPS-B-P-2233T.

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SEGMENT # 9E:

Shielded Metal Arc Welding (SMAW) welding of Weld Joint SEG054C-001(FB to LD, PP79) Welding Repair Report (WR) B-WR-14103 Rev0, Welder is identified as 048659. ZPMC Quality Control (QC) is identified as Mr. Xu Jin Lang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G (4F)-FCM-REPAIR-1.

Heavy Dock Jetty

This QA Inspector, Raghavendra Reddy (B308), performed, Lift 2 & 3, External alignment and measurements which includes, Top, Bottom and side Gap between Splice and Tower Skins, Horizontal and Vertical Flatness near Splice plates, Distance between Splice plate and Tower Skin Edges of all corners, Lift 2 & 3 misalignment in all corners. These measurements carried out along with QA Inspector Mr. Baskar Govindarajan (B 204) North and South tower on Skin A, B, C, D and E. All the reading has been handed over to Task Leader. (Photo attached)

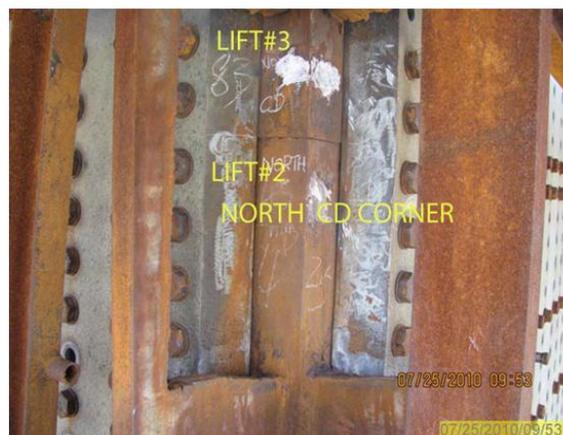
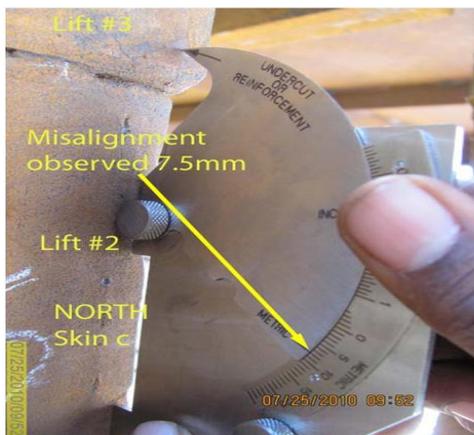
The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06281

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG Splice weld (9AE+9BE). The weld designations reviewed are as follows.

1. OBE9-001,002,003,004,005.

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 Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
