

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-021826**Date Inspected:** 17-Mar-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:** Zho 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 Manoj Prabhune 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 randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

DCP:

Segment 12AW

This Quality Assurance (QA) Inspector witnessed final tension verification for T-rib clips at Panel Point (PP) 109 and PP 112.5 for Segment 12AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00627 Dated March 17, 2011.

Bolt sizes used were M16 x 45 DHGM220044 and final torque required was 180 N-m.

Bolt sizes used were M16 x 50 DHGM220096 and final torque required was 200 N-m.

Bolt sizes used were M16 x 65 DHGM240014 and final torque required was 180 N-m.

Bolt sizes used were M16 x 55 DHGM240009 and final torque required was 200 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-776.

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WELDING:

Segment 12AE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA6501-002; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding The Critical Welding Repair Report (CWRR) was B-CWR2860. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-4G (4F) FCM-Repair-1. See attached photo for further details.

Segment 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 046709 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3006T-035; located On Orthotropic Box Girder (OBG) Deck Plate to Edge Plate CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding The Welding Repair Report (WRR) was B-WR2860. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW-2G (2F) FCM-Repair-1. See attached photo for further details.

Segment 12CE

This QA Inspector observed ZPMC qualified welding personnel identified as 067752 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE12C-026; located On Orthotropic Box Girder (OBG) Edge Plate to Cantilever Bracket CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang . This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 12BE

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE12C-014; located On Orthotropic Box Girder (OBG) Edge Plate to Cantilever Bracket CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Li Yang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 12CW

This QA Inspector observed ZPMC qualified welding personnel identified as 044504 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE12C-30; located On Orthotropic Box Girder (OBG) Edge Plate to Cantilever Bracket CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Wang Zhu. This QA Inspector observed the base material appears to have been preheated by a torch prior to welding. ZPMC Quality Control (QC) Mr. Wang Zhu was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

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



Summary of Conversations:

No significant 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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
