

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 #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022074**Date Inspected:** 27-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**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**Summary of Items Observed:**

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

BAY 14, OBG ANCHOR PLATE (NWIT # 7952)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

AP3031-001-022~049, 003, 004, 274, 318~321, 331, 366~369, 379, 414~417, 427, 462~465, 475, 510~513, 523, 558~561, 571, 606~609, 619, 654~657, 667, 702~705, 715, 750~753, 763, 798, 799, 809, 844, 845, 855, 890, 891, 901, 936, 937, 947, 982, 983, 993, 1028, 1029

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020K-026 [Sub Assembly (SA) plate 3410A to Bottom Plate (BP) 3093A, CJP weld at panel point (PP) 127.3]. The welder is identified as 202122 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020G-034 [Floor Beam (FB) 3341A to Side Plate (SP) 3143B, Fillet weld at panel point (PP) 128]. The welder is identified as 201215 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020M-005 [Sub Assembly (SA) plate 3410A to Bottom Plate (BP) 3093A, CJP weld at panel point (PP) 127]. The welder is identified as 047866 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020A-009 [Side Plate (SP) 3142B to Bottom Plate (BP) 3094A, CJP weld in between panel points (PP) 125.5~126]. The welder is identified as 066734 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020A-009 [Side Plate (SP) 3142A to Bottom Plate (BP) 3094A, CJP weld in between panel points (PP) 126.5~127]. The welder is identified as 058245 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020W-116 [Stiffener of Floor Beam (FB) 3316A to Longitudinal Diaphragm (LD) 3048A, CJP weld at panel point (PP) 125]. The welder is identified as 067610 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2211-Tc-U4b-FCM-1.

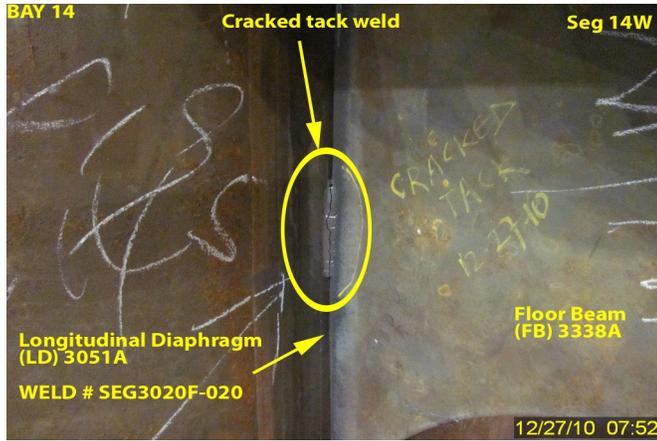
The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020D-219 [Stiffener X4951D of Floor Beam (FB) 3343A to Longitudinal Diaphragm (LD) 3050A, CJP weld at panel point (PP) 128.3]. The welder is identified as 066038 and was observed welding in the 1G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2211-Tc-U4b-FCM-1.

During random in process inspection of OBG member identified as segment 14W this QA observed a cracked tack weld on weld joint identified as SEG3020F-020 [Floor Beam (FB) 3338A to Longitudinal Diaphragm (LD) 3051A, fillet weld at panel points (PP) 128]. This QA marked the cracked tack and informed ZPMC Quality Control (QC) identified as Mr. Qiu Wen of this issue. Mr. Qiu Wen informed this QA that the cracked tack would be corrected in a manner compliant with the contract documents. Attached photograph provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with 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 : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
