

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-022378**Date Inspected:** 02-Apr-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) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. ZHU 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:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

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 of Complete Joint Penetration welds joining the floor beam plate to edge plate weld joint located on 13AW at counter weight side. The weld is designated as SEG3013P-042. The welder is identified as 048696. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

2. NDT:

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Ultrasonic Testing (UT):

UT carried out as per the ZPMC submitted Notification No 08710.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10 % of CJP welds that has been previously tested and accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The members are identified as butt & Tee joint located on 13AE at bike path side, Panel Point (PP-119-1500). This QA inspector generated a UT (TL-6027) report for this date. Weld identification numbers were SEG3007L-108, 111, 050, 053, 054, 057, 058, 061, 062, 065, 066, 069, 070, 073, 074, 078, 081, 082, 085, 086, 089, 093 & 077.

Note: VT repair found by this QA on SEG3007L-090, UT not done.

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted UT Report No UT-13E-017 R1.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as butt joint between DP3085A to DP3086A located on 13AE at cross beam side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: SEG3009-001.

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
