

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-022391**Date Inspected:** 30-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:** An Qing Xiang**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 13BW (NWIT # 08673)

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.

SEG3014P- 043, 059, 060, 063, 065, 058, 099, 100

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

Bay 14

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-011 [Top anchorage plate (AP) 3013A to Vertical Shear Plate sub-assembly SA3444A, CJP weld in between panel point PP125 to PP126]. The

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welder is identified as 067904 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-020 [Top anchorage plate (AP) 3014A to Vertical Shear Plate sub-assembly SA3445A, CJP weld in between panel point PP125 to PP126]. The welder is identified as 045246 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020L-018 [Top anchorage Plate (AP) 3015A to Floor Beam (FB) 3325A, Fillet weld at PP127]. The welder is identified as 069896 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-056 [Top anchorage plate (AP) 3015A to Vertical Shear Plate sub-assembly SA3449A, CJP weld in between panel point PP125 to PP126]. The welders are identified as 069841 and 66261 and were observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-074 [Top anchorage plate (AP) 3014A to Vertical Shear Plate sub-assembly SA3451A, CJP weld in between panel point PP125 to PP126]. The welder is identified as 067765 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020L-019 [Top anchorage Plate (AP) 3015A to Floor Beam (FB) 3325A, Fillet weld at PP127]. The welder is identified as 069896 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

During random in process visual inspection this QA Inspector observed that longitudinal shear plate X4994D on Longitudinal Diaphragm (LD) 3048A in between PP127.5 to PP128 was bent at the top for a length of approx. 200mm during installation of deck panels of segment 14W. This issue was discussed with ZPMC CWI Mr. An Qing Xiang and CT Lead QA Inspector. Mr. An Qing Xiang informed this QA that this issue would be resolved compliant to the contract documents. Attached photograph provide additional details.

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

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
