

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-022519**Date Inspected:** 13-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), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu hua jie**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:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly open yard.

This QA Inspector randomly observed the following work in progress:

Segment: 13AW

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3013AA-012. Welder is identified as 047864. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR20564.

SMAW repair welding of weld joint identified as SEG3013A-004. Welder is identified as 067764. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR20563.

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SMAW repair welding of weld joint identified as SEG3013W-072. Welder is identified as 205098. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per Critical Welding Repair Report (CWR) No: B-CWR2875.

SMAW welding of weld joint identified as SEG3013-001. Welder is identified as 066398. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013AA-016. Welder is identified as 047864. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013AA-052. Welder is identified as 070432. ZPMC Quality Control (QC) is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2213-TC-U4b-FCM-1.

AB/F QA Inspector performing UT for the splice weld joint identified as SEG3013-009 on deck panel. See attached photos for further information.

Segment:13CW

ZPMC personnel removing temporary attachments on side plate by air-carbon arc gouging at cross beam side. See attached photos for further information.

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



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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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
