

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022583**Date Inspected:** 14-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 Huajie**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 Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy 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 observed the following work in progress:

Trial Assembly:-

Shielded Metal Arc (SMAW) welding of Weld Buildup for I Ribs at 12AW FL3 AREA (After separation of 12AW, CB#17 & 12AE and Inspection Cross Beam(CB)#17 inner stiffener hole distance, the hole distance was shorter than requirement and needs buildup as per approved Welding Repair Report(WR)B-WR20342), and Welder is identified as 040378; ZPMC Quality Control (QC) is identified as Mr. Li Yang, The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013AA-106(13AW Edge panel to Side panel weld), and Critical Welding Repair Report(CWR)B-CWR2904, Welder is identified as 067765; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo, The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013A-012(13AW Side panel to Bottom panel weld, CB

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Side), and Welding Repair Report(WR)B-WR20564 Welder is identified as 047864; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo, The welding variables appeared to comply with the Applicable WPS-345-SMAW-4G(4F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013J-046(13AW Stiffener to Edge panel weld,CB Side), and Welder is identified as 070432; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo, The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08819.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 12BE welds, the weld designations reviewed are as follows.

1. FB3014-003-003.

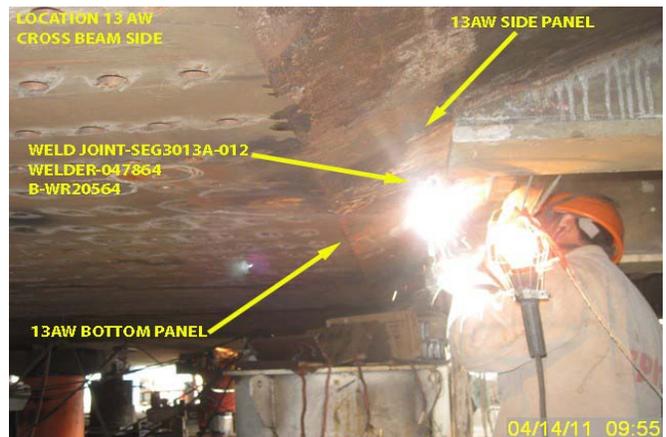
The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08821.

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as OBG 12AW welds, the weld designations reviewed are as follows.

1. SEG3004P-145

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the 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:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
