

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 #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023003**Date Inspected:** 24-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 Joint SEG3013AA-109(13AW weld, CW Side), and Welder is identified as 066002; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013AA-088(13AW weld, CW Side), and Welder is identified as 066019; ZPMC Quality Control (QC) is identified as Mr. Shen Jian Bo, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3014B-145(13BW, VP3013 to X449C weld), and Welder is identified as 045213; ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3014B-257(13BW,VP3013 to X4980 weld), and Welder is identified as 045213; ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang, The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3014H-159(13BW,VP3012A to X4512A weld), and Welder is identified as 067588; ZPMC Quality Control (QC) is identified as Mr. Sun Tian Liang, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08914.

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 12 EAST welds, the weld designations reviewed are as follows.

1. SA6521B-001-014
2. SA6520D-001-008
3. SA6520F-001-012

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08917.

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 12 EAST welds, the weld designations reviewed are as follows.

1. SEG3004H-056
2. SEG3004J-057
3. SEG3004D-056
4. SEG3004E-060
5. SEG3005E-150
6. SA6521E-001-018
7. SA6520F-001-012
8. SA6522A-001-008/021
9. SA6520A-001-002
10. SA6520B-001-004
11. SA6520C-001-006
12. SA6520D-001-008
13. SA6520E-001-010
14. SA6521A-001-009~012

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

- 15. SA6521B-001-014
- 16. SA6521C-001-017
- 17. SA6521D-001-020

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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 |
