

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-023175**Date Inspected:** 27-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. 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:** 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 Shielded Metal Arc Welding of Fillet welds joining the side plate to I-rib weld joint located on 13AE at Panel Point (PP-118.5). The weld is designated as SP3059-001-141 & 142. The welder is identified as 068097. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2114-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the floor beam to side plate stiffener weld joint located on 13AE at Panel Point (PP-119). The weld is designated as SEG3007H-067. The welder is identified as 216086. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

WPS-B-P-2213-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the side plate to bottom plate weld joint located on 13AE at cross beam side. The weld is designated as SEG3007AC-011. The welder is identified as 044504. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. The weld repair report number is named as WR-20841.

2. NDT:

Ultrasonic Testing (UT):

UT carried out for the ZPMC submitted Notification No 08955.

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 CJP joint between stiffeners to floor beam weld joint located on 13BE. This QA inspector generated a UT (TL-6027) report for this date. Weld identification numbers were

1. SEG3009F-067, 071, 075, 079, 083, 087, 091, 095, 099, 103, 107, 111, 115, 119, 123, 127, 131, 135.
2. SEG3009D-066, 071, 076, 081, 086, 091, 098, 103, 108, 113, 118, 123, 128, 133, 138, 143, 148, 153.
3. SEG3009S-004, 005, 028, 029.

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
