

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-023318**Date Inspected:** 03-May-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. ZHU ZHONG HAI**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 Complete Joint Penetration welds joining the deck plate to deck plate transverse splice weld joint located on 13AE+13BE. The weld is designated as OBE13-002. The welder is identified as 037743, 068097, 067183, 066416, 068924, 067656, 066163, 068917 & 043661. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2211-B-U2-FCM-1 & WPS-B-P-2211-B-U2a-FCM-1. Above 6mm root gap area of the weld the above said second Welding procedure is used for welding. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining

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the I-Rib to I-Rib weld joint for deck plate located on 12CW at counter weight side. The weld is designated as RS6001E-001-001. The welder is identified as 066479. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-T-3213-B-U3b.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the I-Rib to I-Rib weld joint for side plate located on 13AW at counter weight side. The weld is designated as SEG3013P-219. The welder is identified as 037779. ZPMC QC Mr. SHEN JIAN BO was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR20695.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the I-Rib to I-Rib weld joint for deck plate located on 12CW at cross beam side. The weld is designated as RS6001E-001-002. The welder is identified as 066479. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-T-3213-B-U3b.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the I-Rib to edge plate hold back weld joint located on 13CW at Panel Point (PP-123). The weld is designated as CA3016A-107. The welder is identified as 067588. ZPMC QC Mr. SUM TIAN LIANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

ZPMC Quality Control (QC) personnel performing Magnetic particle Testing (MT) for the edge plate to deck plate hold back weld joint located on 12CE at cross beam side.

ZPMC Quality Control (QC) personnel performing Magnetic particle Testing (MT) for the edge plate to deck plate hold back weld joint located on 13AE at cross beam side.

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 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
