

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-023489**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), Changxing Island **Location:** Shanghai, China**CWI Name:** 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:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune 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 randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

DCP:

BAY 19

This QA Inspector performed a Flatness inspection on the Center plate of Suspender Bracket No- SB108E. The inspection was performed using a 1000 mm Straight Edge for Checking global deformation and a 630 mm Straight Edge for checking local deformation. The results of the inspection were recorded in a separate document and submitted to the CT QA Lead Inspector for review and disposition.

WELDING:

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 066109 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013H-056; located On Orthotropic Box Girder (OBG) RS3441H

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to SP3102A CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20577. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 4G (4F) FCM-Repair-1. See attached photo for further details.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013K-162; located On Orthotropic Box Girder (OBG) Side Plate to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. The Welding Repair Report (WRR) was B-WR20577. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-345-SMAW 3G (3F) FCM-Repair-1. See attached photo for further details.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 047864 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013M-027; located On Orthotropic Box Girder (OBG) SA7510A to I-Rib Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-4113-2.

Segment 13AW

This QA Inspector observed ZPMC qualified welding personnel identified as 067947 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3013Q-261; located On Orthotropic Box Girder (OBG) FL3 to Stiffener Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Shi Lei was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2114-FCM-1

Unless otherwise noted, all work observed on this date appeared to generally comply with the 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 phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer