

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-023707**Date Inspected:** 17-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. 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 Complete Joint Penetration welds joining the bottom plate to side plate hold back weld joint located on 13AW at counter weight side. The weld is designated as SEG3013A-001. The welder is identified as 044541. ZPMC QC Mr. WANG ZHU 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 welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the bottom plate to side plate hold back weld joint located on 13BW at counter weight side. The weld is designated as SEG3014A-009. The welder is identified as 044541. ZPMC QC Mr. WANG ZHU was onsite monitoring the

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welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the bottom plate to side plate hold back weld joint located on 13BW at cross beam side. The weld is designated as SEG3014A-007. The welder is identified as 067764. ZPMC QC Mr. WANG ZHU 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 welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the bottom plate to side plate hold back weld joint located on 13AW at cross beam side. The weld is designated as SEG3013A-009. The welder is identified as 067764. ZPMC QC Mr. WANG ZHU 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.

During the random visual inspection of welds located on Segment 13BW at panel point 122, this Quality Assurance Inspector (QA) observed that temporary attachment removal area not removed properly. The ZPMC QC is identified as Mr. Li Ming Yang. QA inform to ZPMC QC that prior to the repair welding, to prepare proper document and ensure with VT and MT. See the attached picture.

2. NDT:

Magnetic Particle Testing (MT):

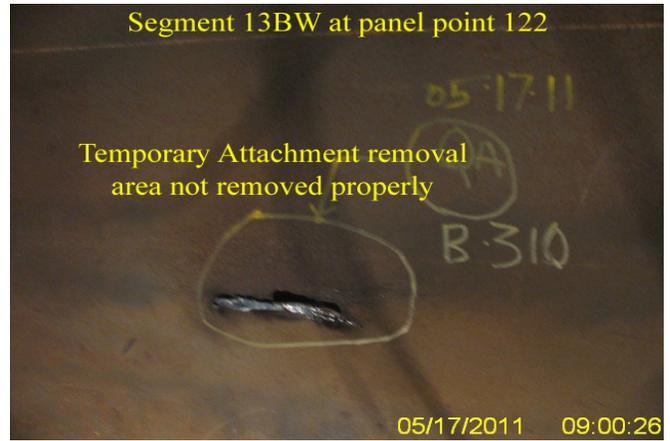
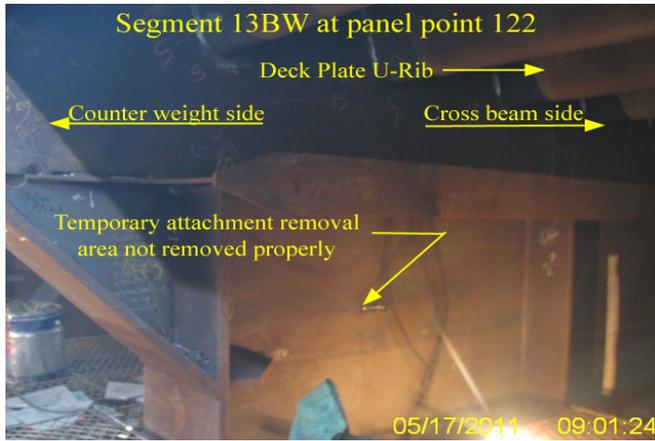
MT carried out for the ZPMC submitted Notification No 09156.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area that has been previously tested and accepted by ZPMC MT technicians. This QA Inspector generated a TL-6028 MT report on this date. The members are identified as complete penetration joint between deck panel diaphragm web to flange weld located on 13AW at counter weight side, Panel Point (PP-118). The weld designation numbers is as follows: SEG3013P-009.

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