

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-023985**Date Inspected:** 06-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), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT

Outside Yard – OBG Trial Assembly

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 09044.

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 MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG3014B-021.

SEG3014D-227.

ZPMC submitted notification number 09040, for Magnetic Particle Testing (MT) of welds on Sub Assembly component SA6522 of OBG Segment 12E was cancelled by ZPMC QC identified as Zhu Zhong Hai. Mr. Zhu Zhong Hai informed this QA Inspector that the Component had been moved from OBG Trial Assembly Yard to

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Paint shop.

WELDING

This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

During random Visual Inspection of OBG Segment 14W, this QA Inspector observed Arc Strikes at six locations on Floor Beam 3345 at Panel Point 128.7. This QA Inspector informed ZPMC CWI identified as Mr. An Qing Xiang of the above issue. Mr. An Qing Xiang informed this QA Inspector that the Arc Strikes shall be repaired and subjected to NDT in a manner compliant with the contract documents. See attached pictures.

This QA Inspector observed ZPMC qualified welding personnel identified as 067949 perform welding by Flux Cored Arc Welding (FCAW), on Edge plate to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AH-004. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 066479 perform welding by Shielded Metal Arc Welding (SMAW), on Top Anchor plate I Rib stiffener weld at panel point PP125.5 of OBG Segment 14W. Weld joint is identified as SEG3020T-094. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 045246 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate Stiffener welds of OBG Segment 14W. Weld joint is identified as SEG3020AX-007, 012. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067572 perform welding by Shielded Metal Arc Welding (SMAW), on Top Anchor plate I Rib Stiffener weld at panel point PP126 of OBG Segment 14W. Weld joint is identified as SEG3020R-164. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066479 perform welding by Shielded Metal Arc Welding (SMAW), on Top Anchor plate I Rib Stiffener weld at panel point PP126 of OBG Segment 14W. Weld joint is identified as SEG3020R-192. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

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 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: Upadhye, Anand

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer