

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-024183**Date Inspected:** 03-Jun-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:** 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:** 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**Segment 13AE~13BE**

This QA Inspector performed Ultrasonic Testing (UT) Verification inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations verified are as follows.

VP3002-001-001, 004

Nondestructive testing (NDT) notification No. 09351

WELDING:

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Segment 13BW ~ 13CW

This QA Inspector observed ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP3133-001-030 ; located On Orthotropic Box Girder (OBG) Deck Plate to Longitudinal Diaphragm 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-WR21033.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 14 West

This QA Inspector observed ZPMC qualified welding personnel identified as 045175 perform Flux Cored Arc Welding (FCAW), weld joint identified as SEG3020AF-047; located On Orthotropic Box Girder (OBG) Deck Plate to Deck Plate Stiffener Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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. Zhu Lin was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-T-2132-ESAB. See attached photo for further details.

Segment 14 West

This QA Inspector observed ZPMC qualified welding personnel identified as 069095 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3020E-016; located On Orthotropic Box Girder (OBG) SA3416C to FB3344A Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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. Zhu Lin was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2114-FCM-1.

Segment 14 West

This QA Inspector observed ZPMC qualified welding personnel identified as 067610 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3020Y-018; located On Orthotropic Box Girder (OBG) X4882K to SA3416A CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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. Zhu Lin was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2114-FCM-1.

Segment 14 West

This QA Inspector observed ZPMC qualified welding personnel identified as 069896 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG3020Y-047; located On Orthotropic Box Girder (OBG) I-Rib to I-Rib CJP Weld; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. 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. Zhu Lin 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 James Devey - 15000026784, who represents the Office of Structural Materials for your project.

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer