

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-024350**Date Inspected:** 08-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:** 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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TA YARD, OBG 14E (NWIT # 09394)

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SA7034-001-025, 026, 001, 002, 017, 018

TA YARD, OBG 14W (NWIT # 09398)

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3020R-143~146

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This Quality Assurance (QA) Inspector observed the following work in progress:

TA YARD

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020V-034 [Complete Joint Penetration (CJP) weld at panel point (PP) 125]. The welders are identified as 066479 & 066261 and were observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

Repair welding of weld joint no: SEG3020AL-001 [CJP weld at PP125]. The welder is identified as 067764 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 21196 Rev-0.

The SMAW process on weld joint no: SEG3020V-031 [CJP weld at panel point (PP) 125]. The welder is identified as 066156 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020F-114, 115 and 116 [Fillet weld at panel point (PP) 128]. The welder is identified as 067588 and was observed welding in 3F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2113-FCM-1.

The SMAW process on weld joint no: SEG3020V-029 [CJP weld at panel point (PP) 125]. The welder is identified as 066002 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020R-215, 220 and 225 [Fillet weld at panel point (PP) 126]. The welder is identified as 069118 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

The SMAW process on weld joint no: SEG3020V-027 [CJP weld at panel point (PP) 125]. The welders are identified as 067520 & 066019 and were observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020M-107, 112 and 117 [Fillet weld at panel point (PP) 127]. The welder is identified as 069683 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-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:

Only general conversation was held between QA and QC concerning this project.

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 : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
