

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-024676**Date Inspected:** 16-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 QinXiang
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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:

BAY - 14

NDT:

Segment 14 West

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

SEG3020X-004, 005, 012

SEG3020X-088

SEG3020X-021, 028, 029, 034, 035, 052, 053, 059, 060, 066, 067, 073, 074

SEG3020X-041, 047

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SEG3020Z- 005, 150

DCP:

Bay 10 (Bike Path)

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom plate for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Path.

BK11A-001.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge across the longitudinal butt weld.

Observed flatness 4.5mm to 5mm using 600mm long straight edge allowable tolerance.

The results of the inspection were informed to Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

Bay -14

WELDING:

Segment 13 West

This QA Inspector observed ZPMC qualified welding personnel identified as 037997 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137P-004-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. 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. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 13 West

This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137P-004-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. 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. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Segment 13 West

This QA Inspector observed ZPMC qualified welding personnel identified as 070140 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137C-002-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. 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. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract

WELDING INSPECTION REPORT

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documents.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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