

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024698**Date Inspected:** 17-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. SHI LIE**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 Bay-14:

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the floor beam to I rib weld joint located on 14W. The weld is designated as SEG3020H-162. The welder is identified as 067588. ZPMC QC Mr. ZHU LIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

Segment Tagging of 14E

2. NDT:

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Magnetic Particle Testing (MT):

MT carried out for the ZPMC submitted Notification No 09506.

This QA Inspector randomly witnessed and 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 fillet & complete joint penetration weld joint located on 14E at Bay-14. The weld designation numbers is as follows:

1. SEG3019D-2-184
2. SEG3019D-2-185
3. SEG3019D-2-192
4. SEG3019D-2-193
5. SEG3019D-2-200
6. SEG3019D-2-201
7. SEG3019D-2-204
8. SEG3019D-2-205
9. SEG3019D-2-188
10. SEG3019D-2-189
11. SEG3019D-2-196
12. SEG3019D-2-197
13. SEG3019D-2-208
14. SEG3019D-2-209
15. SEG3019D-2-212
16. SEG3019D-2-213
17. SEG3019D-2-216
18. SEG3019D-2-217
19. SEG3019AB-036
20. SEG3019E-2-184
21. SEG3019E-2-188
22. SEG3019E-2-192
23. SEG3019E-2-196
24. SEG3019E-2-200
25. SEG3019E-2-204
26. SEG3019E-2-208
27. SEG3019E-2-212
28. SEG3019E-2-216.

Ultrasonic Testing (UT):

UT carried out for the ZPMC submitted Notification No 09496.

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10 % of CJP welds that has been

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previously tested and accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The members are identified as TEE joint between vertical shear plate stiffener to anchorage plate weld joint located on 14E at bike path side. This QA inspector generated a UT (TL-6027) report for this date. Weld identification numbers were

1. SEG3019BB-129.

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out for the ABF submitted UT Report No UT-14W-030.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as corner joint between edge plate to side plate weld joint located on 14W at cross beam side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows:

1. SEG3020AZ-020.

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

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
