

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-025491**Date Inspected:** 05-Jul-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:** Mr. Lu Hua Jie**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 Shailesh Gaikwad 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 Chang xing Island in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly

This QA Inspector performed randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as OBG Segment 13EAST. The weld designations reviewed are as follows.

SEG3007Y-001, 002, 003, 051, 070, 096, 097, 113, 114, 115, 116,
SEG3007X-267, 269, 437,

NDT Notification No-09640

OBG Trial Assembly

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6027 (UT) report for this date. The member is identified as OBG Segment 13 East. The weld designations reviewed are as follows.

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SEG3007Q-081

NDT Notification No-09640

This QA Inspector randomly observed the following work in progress.

OBG 13EAST

Repair Welding SMAW process:

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 021686 performing the Shielded Metal Arc Welding process on weld 010 located at PCMK SEG3011-011. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)- Repair. Weld repair report identified as B-WR21302.

Repair Welding SMAW process:

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037779 performing the Shielded Metal Arc Welding process on OBG Segment 13 East Top panel I rib cross beam side, weld repair buttering on I rib edge. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G (3F) - Repair. Weld repair report identified as B-WR21303. For more information see below attached picture number 1.

Repair Welding SMAW process:

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067764 performing the Shielded Metal Arc Welding process on OBG Segment 13 East Top panel I rib Bike path side, weld repair buttering on I rib edge. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-485-SMAW-3G (3F) - Repair. Weld repair report identified as B-WR21303.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

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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,Shailesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
