

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-025970**Date Inspected:** 07-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU 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:** 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 Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the vertical plate to I- Rib stiffener weld joint located on 13AE. The weld is designated as VP3007-001-062. The welder is identified as 043661. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-21158.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the subassembly to stiffener weld joint located on 13BE. The weld is designated as SEG3009C-203. The welder is

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identified as 058102. ZPMC QC Mr. ZHANG YANG YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1.

During Quality Assurance random Visual Inspection (VT) of side plate located on OBG Segment 14E at cross beam side, this Quality Assurance Inspector (QA) discovered the following issue. Base metal repair weld over the coated surface. This QA observed ZPMC welding personnel have performed base metal repair at temporary attachment removal sites prior to removing the paint. The repairs have been performed on side panels identified as SP3118 and SP3119. This QA observed this condition at four locations on the side panels located between panel points 128 to 128.7. The Side panels SP3118 and SP3119 are designated on the approved shop drawings as Seismic Performance Critical Members (SPCM). OBG Segment 14E is located at the Jetty-5. For further information please see the attached pictures below. This QA inspector generated a UT (TL-15) report on this date.

2. NDT:

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

UT carried out for the ABF submitted UT Report No UT-13E-053 R1.

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 butt joint between BP TO SP @ E13 located on 13CE. 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. SEG3011A-012.

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



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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
