

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-017284**Date Inspected:** 10-Oct-2010**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:** Zhu Zhong Hai.**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 components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar 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:

OBG Trial Assembly Yard:

Notification no: 006904.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG062-PP91-300 and 301.
- 2) FB010-031-001 and 002.

Notification no: 006912.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1) OBW10A-016 and 017.

Notification no: 006913.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG059-307 and 308.
- 2) SEG061-303 and 304.
- 3) FB015-038-001 and 002.
- 4) FB019-005-092 and 093.

This QA Inspector observed the following work in progress:

OBG Seg 11AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW11L-003. The welders are identified as 040611 and 041713 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 11AW and Seg 11BW:

Base metal repair welding after removal of temporary attachments at weld joint nos: OBW11B-004 and 005. Welding process was identified as SMAW. The welders were identified as 062935 and 044551 and were observed welding in the 4G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR-1842 Rev-0. See attached photo for further details.

OBG Seg 10BE and Seg 10CE:

Repair welding of weld joint nos: DP715-001-019 and DP715-001-021. Welding process was identified as SMAW. The welder was identified as 500363 and was observed welding in the 3G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 485-SMAW-3G(3F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15803 Rev-0 and B-WR-15804 Rev-0 for the respective welds.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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 Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer