

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-017630**Date Inspected:** 28-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:

This QA Inspector observed the following work in progress:

OBG Seg 11AW and Seg 11BW:

Base metal repair welding on Side panel at weld joint no: OBW11B-002. The welding process was identified as Shielded Metal Arc Welding (SMAW). The welder is identified as 202316 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1.

OBG Seg 11BW and Seg 11CW:

The Flux Cored Arc Welding process on weld joint no: SEG067B-007. The welder is identified as 040609 and was observed welding in the 2G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-1.

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The SMAW process on weld joint no: SP682-001-071. The welder is identified as 040611 and was observed welding in the 3G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

OBG Seg 11BE and Seg 11CE:

Base metal repair welding after removal of temporary attachments on Side panel at weld joint no: OBE11B-009. The welding process was identified as SMAW. The welder is identified as 050289 and was observed welding in the 4G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. See attached photo for further details.

Heat straightening of weld joint no: OBE11B-010. ZPMC QC was identified as Wang Li Yang. Heat straightening was done as per Heat Straightening Report (HSR): HSR(1)-B-9723. See attached photo for further details.

Blast Shop 1:

Cross Beam 13 (CB13):

This QA Inspector performed random visual inspection of CB13 after grit blasting. Inspection was done only for the internal surfaces of Bottom panel, Deck panel, East side panel, Intermediate panel and the West side panel of this CB. Areas identified for any grinding and / or welding were marked and informed to ZPMC personnel. Also the same were recorded on the drawings / weld maps and was submitted to the Task Leader for review.

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



Summary of Conversations:

No significant conversations were reported on this date.

Comments

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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:	Dsouza,Christopher	QA Reviewer
