

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-017673**Date Inspected:** 01-Nov-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 Inspector observed and/or found the following:

OBG Trial Assembly Yard:

Notification no: 007196.

OBG Segment (Seg) 11AW and Seg 11BW:

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

- 1) OBW11B-001.
- 2) OBW11-001, 002.

This QA Inspector observed the following work in progress:

OBG Seg 11CW and Seg 11DW:

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The Submerged Arc Welding (SAW) process on weld joint no: OBW11A-003 [Deck panel (DP) to DP]. The welders are identified as 044560 and 042195 and were observed welding in the 1G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-1. See attached photo for further details.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW11C-002 [Side Panel (SP) to SP]. The welders are identified as 040609 and 040759 and were 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-2231-B-U2-FCM-1.

OBG Seg 11CE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG070A-011 [Bottom Panel (BP) to SP]. The welder is identified as 500363 and was observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 11DE:

The SMAW process on weld joint no: SEG072A-021 (BP to SP). The welder is identified as 500363 and was observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 11CW:

The SMAW process on weld joint no: SEG069B-007 [Floor Beam (FB) to Longitudinal Diaphragm (LD)]. The welder is identified as 046704 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-P-2212-TC-U4b-FCM-1.

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 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:	Dsouza,Christopher	QA Reviewer
