

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-019727**Date Inspected:** 07-Jan-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:** Qiu Wen.**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:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013D-191 [Floor Beam (FB) 3194A to Edge Beam (EB) 3946A, complete joint penetration (CJP) weld, at panel point (PP) 119.65]. The welder is identified as 045280 and was observed welding in the 1G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-1G(1F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19901 Rev-0.

Repair welding of weld joint no: SEG3013H-003 (FB to Bottom Panel, CJP weld, at PP119). The welder is identified as 066361 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC

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appeared to comply with WPS: 345-FCAW-1G(1F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19199 Rev-0.

The SMAW process on weld joint no: SEG3013AA-088 (Floor Beam to Vertical Plate, CJP weld, at PP120). The welder is identified as 066163 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The FCAW process on weld joint no: SEG3013K-026 (Side Panel to FB3184A, CJP weld, at PP119-1500). The welder is identified as 045143 and was observed welding in the 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

Repair welding of weld joint no: SEG3013G-001 [FB to BP, CJP weld]. The welder is identified as 045221 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 17562 Rev-0.

Repair welding of weld joint no: SEG3013AD-035 (FB to SP, CJP weld]. The welder is identified as 066163 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19613 Rev-0.

This QA Inspector observed that the Deck Panels; DP3133, DP3134 and DP3135 (for 13BW) and DP3146, DP3147 and DP3148 (for 13CW); were mounted on the segments. Fit-up is in progress.

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

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:	Patterson,Rodney	QA Reviewer
