

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-020661**Date Inspected:** 17-Feb-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 14W:

Repair welding of weld joint no: SEG3020BB-019 [Sub Assembly Vertical Shear Plate (VSP) to Bottom Panel (BP), complete joint penetration (CJP) weld]. The welder is identified as 066398 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR 2752 Rev-1.

Repair welding of weld joint no: SEG3020BB-064 (VSP to BP, CJP weld). The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:

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345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: 2793 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020BB-109, 111, 112 and 114 (VSP to Anchorage Plate, CJP weld). The welders are identified as 067949, 066421, 067876 and 066695 and were observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3020U-587 (Anchorage Plate to Longitudinal Diaphragm, CJP weld). The welder is identified as 067888 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The SMAW process on weld joint no: Seg3020U-588 (Anchorage Plate to Bottom Panel, CJP weld). The welders are identified as 067904, 067583 and 067707 and were observed welding in 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint nos: Seg3020P-003, 004, 009 and 010 (Anchorage Plate to Floor Beam, fillet weld). The welder is identified as 069683 and was observed welding in 4F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

The SMAW process on weld joint nos: Seg3020M-001 and 010 (Anchorage Plate to Floor Beam, fillet weld). The welder is identified as 067609 and was observed welding in 4F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

OBG Seg 13AW:

Repair welding of weld joint no: Seg3013AH-031 [K-Plate to Side Panel, CJP weld]. The welder is identified as 066361 and was observed welding in the 1G 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-1G(1F)-FCM-Repair. Repair welding was done as per CWR: 2800 Rev-0.

OBG Seg 13BW:

Repair welding of weld joint no: Seg301S-058 [K-Plate to Side Panel, CJP weld]. The welder is identified as 066443 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 Welding Repair Report (WRR): B-WR 20254 Rev-0.

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

Summary of Conversations:

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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
