

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021204**Date Inspected:** 01-Mar-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) Chanxing Island**Location:** Shanghai, China

CWI Name: Mr. LI YANG
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the partial diaphragm to partial diaphragm weld joint located on 12AE at floor beam extension. The weld is designated as SEG3001AG-047. The welder is identified as 044504. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2211-B-U2-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the floor beam to I-stiffener weld joint located on 12AW+CB-17 at Panel Point (PP-111). The weld is designated as FB3048-001-014(CB-17). The welder is identified as 068764. ZPMC QC Mr. LI YANG was onsite monitoring

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2114-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the side plate to I-stiffener weld joint located on 12AW+CB-17 at Panel Point (PP-110). The weld is designated as SP3027-001-021(CB-17). The welder is identified as 040270. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2114-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the floor beam to bottom plate weld joint located on ` . The weld is designated as FB3054-001-128(12AW). The welder is identified as 040320. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding of Complete Joint Penetration welds joining the bottom plate to side plate hold back weld joint located on CB-17+12AE at Panel Point (PP-110). The weld is designated as CB3001-017-018(CB-17). The welder is identified as 040320. ZPMC QC Mr. LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2212- TC-U4b-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Air Carbon Arc Gouging on (back gouging) weld for the partial diaphragm to partial diaphragm weld joint located on 12AW+CB-17 at Panel Point (PP-111 to PP-112). The weld is designated as CB3001-017-018. ZPMC QC Mr. LI YANG was onsite monitoring the gouging variables.

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the side plate to side plate transverse splice weld joint located on 12BE+12CE at cross beam side. The weld is designated as OBE12E-001 & 002.

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 relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
