

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-021685**Date Inspected:** 12-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), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: SEG3020BB-114 [Vertical Shear Plate SA3448A to Anchor Plate (AP) 3032A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 045246 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20379 Rev-0.

Repair welding of weld joint no: SEG3020BB-113 [Vertical Shear Plate SA3447A to Anchor Plate (AP) 3032A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 051348 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW).

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ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20379 Rev-0.

Repair welding of weld joint no: SEG3020BB-115 [Vertical Shear Plate SA3449A to Anchor Plate (AP) 3032A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 045246 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20379 Rev-0.

Repair welding of weld joint no: SEG3020BB-116 [Vertical Shear Plate SA3450A to Anchor Plate (AP) 3032A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 051348 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20379 Rev-0.

Repair welding of weld joint no: SEG3020U-587 [Longitudinal Diaphragm (LD) 3049A to Anchor Plate (AP) 3032A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 067588 and was observed welding in the 3G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC CWI was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2854 Rev-0.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020L-176 (Stiffener X4886B to Floor Beam (FB) 3325A, Fillet weld at panel point PP 127). The welder is identified as 067572 and was observed welding in the 4F position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020L-119 (Stiffener RS8502B on Bottom Plate (BP) 3091A to Floor Beam (FB) 3327A, CJP weld at Panel Point PP127). The welder is identified as 066239 and was observed welding in the 3G position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020L-108 (Stiffener RS8502B to Bottom Plate (BP) 3091A, Fillet weld in between Panel Points PP127~127.3). The welder is identified as 066239 and was observed welding in the 2F position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020AB-040, 041 (Stiffener X4977D to Longitudinal Diaphragm (LD) 3050A, Fillet weld). The welder is identified as 066673 and was observed welding in the 3F position. ZPMC QC was identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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