

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-021827**Date Inspected:** 16-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:

BAY 14

This QA Inspector observed that the segment 13AE has been moved out to the Orthotropic Bridge Girder (OBG) trial assembly from bay 14 for alignment with segment 12CE. See attached photographs for additional details.

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

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: SEG3020U-588 [Anchor Plate (AP) 3032A to Bottom Plate (BP) 3087A/3088A/3089A/3090A, Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welders are identified as 067588, 051348 & 045246 and were observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

was done as per Welding Repair Report (WRR): B-WR 20419 Rev-0. Attached photograph provide additional details.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020C-056 (Side Plate SP3141F/ SP3140F to Floor Beam (FB) 3348A, CJP weld at panel point PP 128.7). The welder is identified as 047866 and was observed welding in the 3G position. AB/F QA was identified as Mr. Shen Jian. The welding variables recorded by QA appeared to comply with WPS: B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AW-089 (Side Plate 3132A to Side Plate SP3145B, CJP weld). The welders are identified as 067520 & 037779 and were observed welding in the 2G position. AB/F QA was identified as Mr. Shen Jian. The welding variables recorded by QA appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020V-055 [Floor Beam (FB) 3315A to Floor Beam (FB) 3315B, CJP weld at panel point PP 125]. The welder is identified as 201215 and was observed welding in the 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AZ-050, 055 [I-rib stiffener (RS3526X) to I-rib stiffener (RS3526AA) on Side Panel (SP) 3142D, complete joint penetration (CJP) weld at PP127.5]. The welder is identified as 067765 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-B-U2-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AZ-051, 056 [I-rib stiffener (RS3526AA) on Side Panel (SP) 3142D to Floor Beam (FB) 3335A, complete joint penetration (CJP) weld at PP127.5]. The welder is identified as 067765 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AL-096, 101 [I-rib stiffener (RS3522X) to I-rib stiffener (RS3523C) on Side Panel (SP) 3142B, complete joint penetration (CJP) weld at PP125.5]. The welder is identified as 067609 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-B-U2-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AL-097, 102 [I-rib stiffener (RS3523C) on Side Panel (SP) 3142B to Floor Beam (FB) 3319A, complete joint penetration (CJP) weld at PP125.5]. The welder is identified as 067609 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AL-181, 186 [I-rib stiffener (RS3522X) to I-rib stiffener (RS3523C) on Side Panel (SP) 3142C, complete joint penetration (CJP) weld at

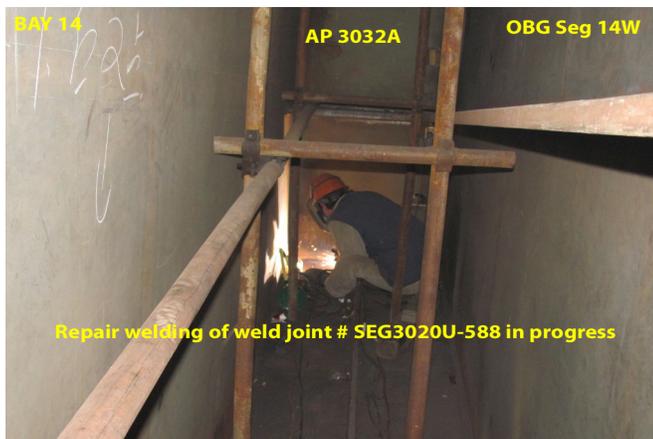
WELDING INSPECTION REPORT

(Continued Page 3 of 4)

PP126.5]. The welder is identified as 069896 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-B-U2-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AL-182, 186 [I-rib stiffener (RS3523C) on Side Panel (SP) 3142C to Floor Beam (FB) 3319A, complete joint penetration (CJP) weld at PP126.5]. The welder is identified as 069896 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Mr. Sun Tian Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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