

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-022144**Date Inspected:** 27-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:	Sun Tian Liang, 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: SEG3020V-048 [Floor Beam (FB) 3315C to Longitudinal Diaphragm (LD) 3049A, Complete Joint Penetration (CJP) weld at panel point (PP) 125]. The welder is identified as 067520 and was observed welding in the 3G 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-3G(3F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2858 Rev-0.

The FCAW process on weld joint no: SEG3020M-110 [Stiffener X4983H on FB 3329A to Edge Panel (EP) 3030C, CJP weld at PP127]. The welder is identified as 066239 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:

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B-T-2231-ESAB.

Repair welding of weld joint no: SEG3020V-073 [Floor Beam (FB) 3315C to Longitudinal Diaphragm (LD) 3049A, Complete Joint Penetration (CJP) weld at panel point (PP) 125]. The welder is identified as 067520 and was observed welding in the 3G 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-3G(3F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2858 Rev-0.

The FCAW process on weld joint no: SEG3020M-115 [Stiffener X4983J on FB 3329A to Edge Panel (EP) 3030C, CJP weld at PP127]. The welder is identified as 066239 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:
B-T-2231-ESAB.

The FCAW process on weld joint no: SEG3020AZ-020 [Edge Panel (EP) 3030E to Side Panel (SP) 3140F, CJP weld from PP128.3 to PP128.7]. The welder is identified as 045175 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-002 [Top anchorage plate (AP) 3013A to Vertical Shear Plate sub-assembly SA3442A, CJP weld in between panel point PP125 to PP126]. The welder is identified as 067765 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The FCAW process on weld joint no: SEG3020M-120 [Stiffener X4983K on FB 3329A to Edge Panel (EP) 3030C, CJP weld at PP127]. The welder is identified as 066239 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:
B-T-2231-ESAB.

The FCAW process on weld joint no: SEG3020BB-241 [Stiffener RS3514G to Bottom Plate (BP) 3089A, CJP weld at PP126]. The welder is identified as 045175 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:
B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AQ-025 [Top anchorage plate PL3519A to Side Plate (SP) 3144B, CJP weld in between panel point PP125 to PP127]. The welders are identified as 045246 and 069841 and were observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U5b-FCM-1.

The FCAW process on weld joint no: BP3090-091, 092 [Stiffener RS3514Y to Bottom Plate (BP) 3090A, Fillet weld at PP126]. The welder is identified as 045175 and was observed welding in 2F position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:
B-T-2132-ESAB.

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The FCAW process on weld joint no: SEG3020M-105 [Stiffener X4983G on FB 3329A to Edge Panel (EP) 3030C, CJP weld at PP127]. The welder is identified as 066239 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2231-ESAB.

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
Reviewed By:	Peterson,Art	QA Reviewer
