

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-022255**Date Inspected:** 29-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:

The FCAW process on weld joint no: SEG3020AV-007 [Block out Bottom Plate Sub assembly SA3416A to Block out Bottom Plate Sub assembly SA3416C, CJP weld from Panel Point PP128.3 to PP128.7]. The welder is identified as 066236 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 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.

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The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-029 [Top anchorage plate (AP) 3014A to Vertical Shear Plate sub-assembly SA3446A, CJP weld in between panel point PP125 to PP126]. The welders are identified as 067904 and 67572 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-U4b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-047 [Top anchorage plate (AP) 3015A to Vertical Shear Plate sub-assembly SA3448A, CJP weld in between panel point PP125 to PP126]. The welders are identified as 069841 and 66261 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-U4b-FCM-1.

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 welder is identified as 045246 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-U5b-FCM-1.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020BB-056 [Top anchorage plate (AP) 3015A to Vertical Shear Plate sub-assembly SA3449A, CJP weld in between panel point PP125 to PP126]. The welder is identified as 045246 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 SMAW process on weld joint no: SEG3020L-018 [Top anchorage Plate (AP) 3015A to Floor Beam (FB) 3325A, Fillet weld at PP127]. The welder is identified as 068969 and was observed welding in 4F position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

The FCAW process on weld joint no: SEG3020D-317 [Web plate X4912A to Web Plate X4912A, CJP weld at Panel Point PP128.3]. The welder is identified as 066236 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.

During random in process inspection this QA inspector observed the installation of Deck Panels DP 3172A/DP3173A/DP3174A from PP125 to PP128.3 of OBG segment 14W. Attached photograph provide additional details.

During random in process inspection this QA inspector observed that a ZPMC QC personnel Mr. Zhu Lin was performing the flatness inspection of top anchorage plate AP3013A/AP3014A/AP3015A/AP3016A by using 1M straight edge. During inspection the measurements were carried out and recorded on the data sheet by ZPMC QC personnel. Attached photograph provide additional details.

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

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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