

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-016790**Date Inspected:** 19-Sep-2010**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:** Liu Hua Jie.**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 components.**Summary of Items Observed:**

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

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 10CW:

Repair welding on weld joint no: SEG063C-011. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 046709 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair. Repair welding was done as per Welding Repair Report WRR: B-WR-15113 Rev-0.

OBG Seg 10BE and Seg 10CE:

The SMAW process on weld joint no's: OBE10C-004 and 005. The welders are identified as 044504 and 046960 and were observed welding in the 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

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OBG Seg 10CW:

The SMAW process on weld joint no: SEG063A-030. The welder is identified as 044551 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 11AW:

The SMAW process on weld joint no: CA080-005. The welder is identified as 044551 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 10AE and Seg 10BE:

Notification no: 006719.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- SEG060B-006, 026, 027 and 028.
- SEG062B-007 and 008.

Blasting inspection:

OBG Seg 11CW.

This QA Inspector performed random visual inspection of OBG Seg 11CW after grit blasting. Inspection was done for the external surfaces of Bottom panel, Side Panels and Deck panel. Areas identified for any grinding and were marked and were informed to ZPMC personnel.

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

Summary of Conversations:

No significant 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; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

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Reviewed By: Peterson, Art

QA Reviewer