

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-016873**Date Inspected:** 23-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 10CE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG064B-001. The welder is identified as 044504 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhang Xian Ming. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 10BE and Seg 10CE:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: SP696-001-032, 034 and 036. The welder is identified as 047353 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Xian Ming. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The SMAW process on weld joint no: DP702-001-039. The welder is identified as 040611 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Xian Ming. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

The SMAW process on weld joint no: DP715-001-021. The welder is identified as 044378 and was observed welding in the 3G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

OBG Seg 10CW:

The FCAW process on weld joint nos: SP662-001-021, 023 and 025. The welder is identified as 040609 and was observed welding in the 2F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The SMAW process on weld joint no: DP690-001-014. The welder is identified as 041713 and was observed welding in the 4F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

OBG Seg 11AW:

The FCAW process on weld joint nos: SP663-001-011, 013 and 015. The welder is identified as 040609 and was observed welding in the 2F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The SMAW process on weld joint no: DP691-001-008. The welder is identified as 041713 and was observed welding in the 4F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-T-4114-1.

OBG Seg 10BW and Seg 10CW:

Notification no: 006746.

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:

- SP777-001-035 and 036.
- SP778-001-023 and 024.
- SP499-001-035 and 036.
- SP500-001-021 and 022.
- SP678-001-028 and 029.
- SP677-001-023 and 024.
- SP737-001-029, 030, 035 and 036.
- SP738-001-023, 024, 029 and 030.
- EP133-001-009 and 010.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

- EP134-001-005 and 006.
- DP727-001-015 and 016.
- DP690-001-009 and 010.

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
Reviewed By:	Peterson,Art	QA Reviewer
