

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-016988**Date Inspected:** 27-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:** Zhu Zhong Hai.**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 10BE and Seg 10CE:

Repair welding of weld joint no: OBE10A-003. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 040320 and was observed welding in the 1G position. ZPMC Quality Control (QC) was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-15250 Rev-0.

OBG Seg 11AW and Seg 11BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW11-003. The welders are identified as 040759 and 053316 and were observed welding in the 1G position. ZPMC QC was identified as Shi Lei. The

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welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-2.

OBG Seg 10CE:

The SMAW process on weld joint no: SEG064-035. The welder is identified as 044504 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

The FCAW process on weld joint nos: SP633-049 and 050. The welder is identified as 052763 and was observed welding in the 2F position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint nos: BP185-037 and 038. The welder is identified as 040458 and was observed welding in the 2F position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11AE:

The SMAW process on weld joint no: CA081-002. The welder is identified as 044504 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1. See attached photo for further details.

The FCAW process on weld joint nos: SP634-007 and 008. The welder is identified as 052763 and was observed welding in the 2F position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

Cross Beam 13 (CB13):

The SMAW process on weld joint no: SSD25-PP87-100. The welder is identified as 040656 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-B-U2-FCM-1.

The SMAW process on weld joint no: SSD25-PP87-223. The welder is identified as 040611 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 10BE and Seg 10CE:

Notification no: 006780.

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:

1) BP076-001-053 and 054.

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- 2) BP077-001-035 and 036.
- 3) BP184-001-049, 050, 053, 054.
- 4) BP185-001-031, 032, 035, 036.
- 5) BP130-001-049 and 050.
- 6) BP131-001-031 and 032.

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
