

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-017120**Date Inspected:** 30-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 Seg 12AW (Green Tag DCP):

This QA Inspector, along with Mr. Manoj Prabhune; performed Green Tag DCP for OBG Seg 12AW from Panel Point (PP) 109 to PP112.5

The details are as mentioned below:

- Dimension measurements of corner assembly cope holes from PP109 and PP112.5 [at both Cross Beam (CB) side and Counter weight (CW) side].
- Plumbness and flatness measurement of Deck Panel (DP) to DP diaphragm at PP109 and PP112.5.
- Floor beam flatness at PP109 and PP112.5 (at both CB side and CW side).

The measured readings were noted on Dimension Control Forms and are submitted to the Task Leader for review.

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

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OBG Seg 11AE and Seg 11BE:

The Submerged Arc Welding (SAW) process on weld joint no: OBE11-003. The welders are identified as 0503060 and 050295 and were 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: B-T-223(2)1T-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBE11B-002. The welders are identified as 040465 and 052763 and were observed welding in the 3G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-223T.

OBG Seg 11AW and Seg 11BW:

The SAW process on weld joint no: OBW11-003. The welders are identified as 044560 and 202756 and were observed welding in the 1G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-1.

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
