

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-017526**Date Inspected:** 22-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei.**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:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14E:

Repair welding of weld joint nos: SEG3019A-002 and 006. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welders were identified as 044772 and 054013 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Geng Wei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR-16035 Rev-0 and B-WR-16058 Rev-0.

Heat straightening of weld joint nos: VP3017A-001-004, 005 and 006. ZPMC QC was identified as Zhong Guo Hai. Heat straightening was done as per Heat Straightening Report (HSR): 9663. Heat straightening was needed to be done to rectify the distortion of the Vertical plate after welding. See attached photo for further details.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG Seg 13CE:

Repair welding of weld joint no: SEG3011A-011. Welding process was identified as SMAW. The welder was identified as 049339 and was observed welding in the 4G position. ZPMC QC was identified as Geng Wei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR-15928 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: VP3007-001-058. The welder is identified as 067520 and was observed welding in the 2G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

OBG Seg 13AE:

Repair welding of weld joint no: KP3004-001-002. Welding process was identified as SMAW. The welder was identified as 201087 and was observed welding in the 2G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR-16039 Rev-0.

OBG Seg 14W:

Heat straightening of weld joint no: SEG3020AQ-027. ABF QA was identified as Shao Jian Yuan. Heat straightening was done as per HSR: 9697. Heat straightening was needed to be done to rectify the distortion of the Anchor Plates after welding. See attached photo for further details.

The Submerged Arc Welding (SAW) process on weld joint no: SEG3020AP-005. The welder is identified as 045265 and was observed welding in the 1G position. ABF QA was identified as Shao Jian Yuan. The welding variables appeared to comply with WPS: B-T-2221-B-L2c-S-2.

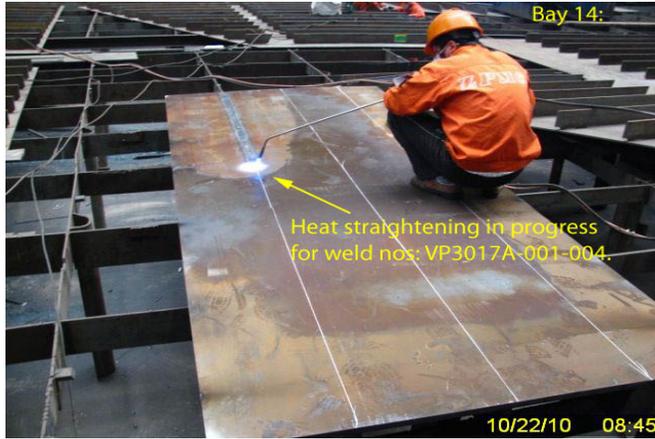
OBG Seg 13CW:

The SAW process on weld joint no: SA-3232-001-004. The welder is identified as 045270 and was observed welding in the 1G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-B-L2c-S-2.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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