

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-017595**Date Inspected:** 23-Oct-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:** 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:

Notification no: 007071.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (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) SEG3015A-012.
- 2) SEG3014A-007.

This QA Inspector observed the following work in progress:

OBG Seg 14AW:

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Heat straightening of weld joint no: SEG 3020AP-003. ABF QA was identified as Shao Jian Yuan. Heat straightening was done as per Heat Straightening Report (HSR): 9697. Heat straightening was needed to be done to rectify the distortion after welding.

OBG Seg 13AE:

Repair welding of weld joint no: KP3001A-001-001. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder is identified as 201087 and was observed welding in the 2G position. ZPMC Quality Control (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 Welding Repair Report (WRR): B-WR-2089 Rev-0.

OBG Seg 13BE:

Repair welding of weld joint no: VP3004-001-027. Welding process was identified as SMAW. The welder is identified as 054013 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-2085 Rev-0.

OBG Seg 14E:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3019AP-001. The welder is identified as 044771 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.

The SAW process on weld joint no: SEG3019AZ-019. The welder is identified as 044771 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.

OBG Seg 14W:

The SAW process on weld joint no: SEG3020AL-023. 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.

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

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Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer