

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-017709**Date Inspected:** 04-Nov-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 Inspector observed and/or found the following:

OBG Trial Assembly Yard:

Notification no: 007223.

OBG Segment (Seg) 12AW:

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 MT inspected are as follows:

1) CA3012-162, 190, 163, 191.

Notification no: 007233.

OBG Seg 10AW:

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

1) Lifting lug in 10W PP88 (See attached photos for further details).

This QA Inspector observed the following work in progress:

OBG Seg 11DW and Seg 11EW:

This QA Inspector observed ABF personnel doing MT of root pass of weld joint no: OBW10C-008 [Deck Panel (DP) to DP – transverse splice weld]. See attached photo for further details.

OBG Seg 11DE and Seg 11EE:

The Submerged Arc Welding process on weld joint no: OBE11A-008 [DP to DP – transverse splice; complete joint penetration (CJP) weld]. The welders are identified as 050295 and 040460 and were observed welding in the 1G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-223(2)1T-1.

OBG Seg 11DE:

The Flux Cored Arc Welding (FCAW) process on weld joint no: BP135-001-035 [T-rib to Bottom Panel (BP) – hold back fillet weld, at PP104]. The welder is identified as 047353 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11CE:

The FCAW process on weld joint no: BP134-001-047 (T-rib to BP – hold back fillet weld, at PP104). The welder is identified as 047353 and was observed welding in the 2F position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 11CE and Seg 11DE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SP382-001-052 (T-rib stiffener; CJP weld). The welder is identified as 040484 and was observed welding in the 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

OBG Seg 11AE and Seg 11BE:

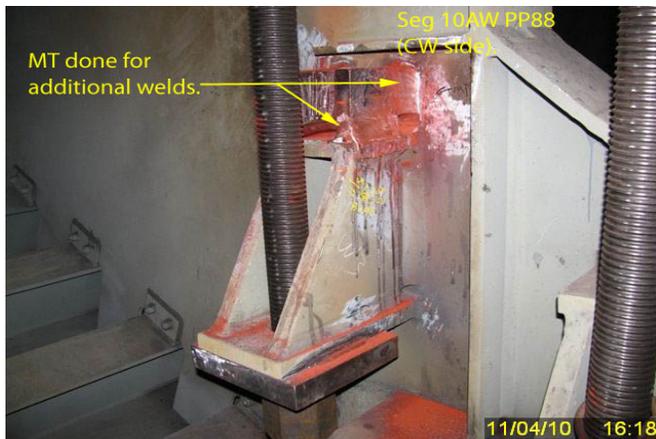
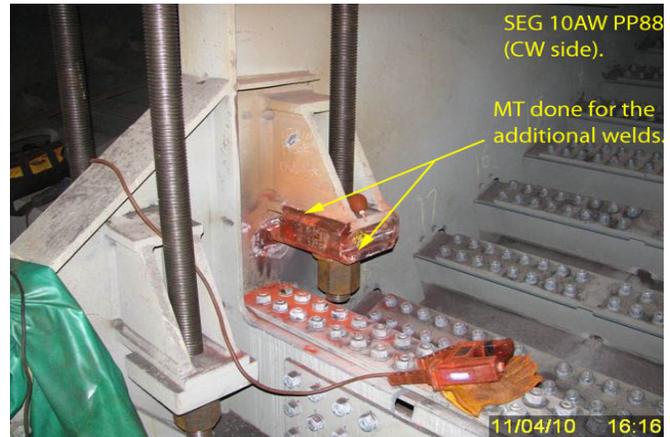
Repair welding of weld joint nos: OBE11B-001 and 002 [Side Panel (SP) to SP – transverse splice; CJP weld]. Welding process was identified as SMAW. The welders are identified as 044515 and 040504 and were observed welding in the 4G position. ZPMC QC was identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Repair Report (WRR): B-WR-16567 Rev-0.

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: Dsouza,Christopher

QA Reviewer