

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-018084**Date Inspected:** 11-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:

OBG Seg 11BW:

Notification no: 007308.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

1) SEG067*-045 and 046.

OBG Seg 11CE:

Notification no: 007309.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components.

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The weld designations reviewed are as follows:

- 1) SEG070C-024 and 006.
- 2) SEG070B-001 and 009.

This QA Inspector observed the following work in progress:

OBG Seg 11CE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: CA087-006 [Deck Panel (DP) to Edge panel (EP) – E5 side; hold back complete joint penetration (CJP) weld at Panel Point (PP) 104]. The welder is identified as 040320 and was 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: B-P-2214-TC-U4b-FCM-1.

OBG Seg 11DE:

The SMAW process on weld joint no: SEG072*-044 (DP to EP – E5 side; hold back CJP weld at PP104). The welder is identified as 040320 and was 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: B-P-2214-TC-U4b-FCM-1.

OBG Seg 11BW:

Repair welding of weld joint no: OBW11-025 (DP to counterweight connection plate – W2 side; CJP weld). The welder is identified as 037996 and was observed welding in the 1G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 16778 Rev-0. See attached photo for further details.

OBG Seg 11BW and Seg 11CW:

This QA Inspector observed one additional weld on weld joint no: OBW11-027 (DP to counterweight connection plate – W2 side; CJP weld). This QA Inspector discussed this issue with ZPMC CWI Zhu Zhong Hai. ZPMC personnel agreed that this additional weld will be incorporated in the drawing and will be UT tested. See attached photos for further details.

OBG Seg 11DE and Seg 11EE:

The SMAW process on weld joint no: EP173-013 (EP to EP – I ribs splice CJP weld at PP107). The welder is identified as 053871 and was 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: B-P-2214-B-U2-FCM-1.

OBG Seg 11DW:

The SMAW process on weld joint no: DP681-013 (DP to I-rib hold back fillet weld at PP107). The welder is

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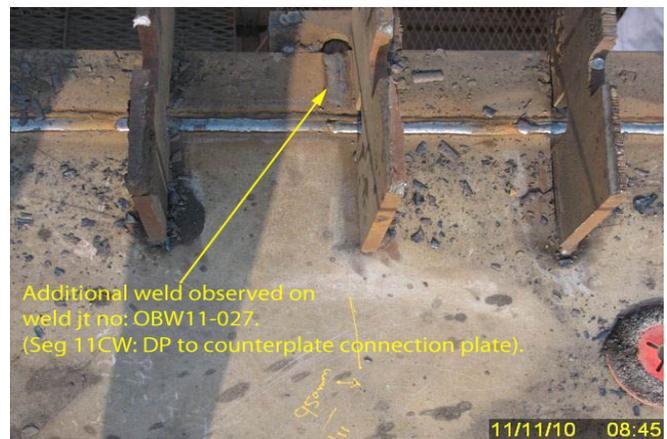
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identified as 062935 and was observed welding in the 4F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-4114.

OBG Seg 11EW:

The SMAW process on weld joint no: DP682-007 (DP to I-rib hold back fillet weld at PP107). The welder is identified as 062935 and was observed welding in the 4F position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-4114.

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.

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Dsouza,Christopher	QA Reviewer
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