

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-019251**Date Inspected:** 22-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:** Li Yan Hua.**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:

Bay 14:

Notification no: 007447.

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) SEG3014L-191 to 196
- 2) SEG3015N-269 to 275.
- 3) SEG3013G-004 and 006.

This QA Inspector observed the following work in progress:

OBG Seg 13BW:

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The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3014D-200 [I-rib stiffener splice joint, complete joint penetration (CJP) weld at Panel Point (PP) 121.5, on Bottom Panel (BP)]. The welder is identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2233-B-U2-F.

The FCAW process on weld joint no: SEG3014D-199 [I-rib stiffener to Floor Beam (FB), CJP weld at PP121.5]. The welder is identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4b-F.

The FCAW process on weld joint no: SEG3014F-066 and 067 (I-rib stiffener to BP, fillet weld at PP121). The welder is identified as 201583 and was observed welding in the 2F position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 13CW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013H-038 (FB to extension piece, CJP weld at PP119). The welder is identified as 045246 and was observed welding in the 2G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2212-B-U3b.

The SMAW process on weld joint no: SEG3013K-047 (FB to extension piece, CJP weld at PP119-1500). The welder is identified as 051348 and was observed welding in the 2G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2212-B-U3b.

OBG Seg 13AW:

The FCAW process on weld joint no: DP3120-001-010 [Deck Panel (DP) to X4125H plate, CJP weld]. The welder is identified as 070217 and was observed welding in the 2G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F.

OBG Seg 13BW and Seg 13CW:

This QA Inspector observed ZPMC personnel doing arc gouging for R25 cope hole on the floor beams; from PP120.5 to 124.5. Welding and NDT (UT) of FB to longitudinal diaphragm (LD) CJP weld from PP120.5 to 124.5 is completed. See attached photos for further details.

Corner Assembly for OBG Seg 13CW:

ABF NDE personnel performing UT of weld jt no: CA3016-100 [Edge Panel (EP) to DP – after repair welding]. UT repair was identified at 4nos of locations on this weld

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

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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:	Patterson,Rodney	QA Reviewer
