

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-019257**Date Inspected:** 28-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:** Qiu Wen.**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: 007525.

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:

OBG Seg 13BW:

- 1) SEG3014H-039, 043, 047, 051, 055, 059, 071.
- 2) SEG3014F-035, 037, 041, 043, 045, 049.

OBG Seg 13CW:

- 1) SEG3015H-042, 046, 050, 058, 062.

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2) SEG3015D-070, 066, 062, 058, 054, 050, 045.

3) SEG3015E-035.

Notification no: 007528.

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. The weld designations reviewed are as follows:

OBG Seg 14W:

1) SEG3020AZ-018

2) SEG3020AY-005

OBG Seg 13AW:

1) SEG3013Q-039

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013U-102 [Longitudinal Diaphragm (LD) to Bottom Panel (BP), complete joint penetration (CJP) weld at Panel Point (PP) 117.5]. The welder is identified as 045221 and was observed welding in the 1G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS:

345-FCAW-1G(1F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 17698 Rev-0.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013L-095 [I-rib stiffener to Floor Beam (FB) CJP weld; on Side Panel (SP) CB side]. The welder is identified as 066326 and was observed welding in the 3G position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

OBG Seg 13CW:

The FCAW process on weld joint no: SEG3015J-062 (RS stiffener to FB CJP weld). The welder is identified as 045280 and was observed welding in the 3G position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4b-F.

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
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Reviewed By:	Patterson,Rodney	QA Reviewer
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