

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019258**Date Inspected:** 29-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: 007549.

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) CA3016B-016, 017, 018, 038, 039, 041, 042.
- 2) CA3016C-113, 114, 123, 124, 143, 144, 135, 136, 016, 017, 018, 026, 027, 038, 039.

This QA Inspector observed the following work in progress:

OBG Seg 13CW:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The Flux Cored Arc Welding (FCAW) process on weld joint nos: SEG3015B-171, 175, 179 and 183 [I-rib stiffener to Floor Beam (FB), at Panel Point (PP) 124.5, complete joint penetration (CJP) weld]. The welder is identified as 201583 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-TC-U4b-F.

OBG Seg 13AW:

The FCAW process on weld joint no: SEG3013D-210 [FB to Longitudinal Diaphragm (LD), at PP119 + 1500, fillet weld]. The welder is identified as 201215 and was observed welding in the 3F position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB. This QA Inspector verified the welding parameters and were found to be complying with the above mentioned WPS.

The FCAW process on weld joint no: SEG3013F-008 (FB to LD, at PP119 - 1500, CJP weld). The welder is identified as 047866 and was observed welding in the 3G position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB. This QA Inspector verified the welding parameters and were found to be complying with the above mentioned WPS.

Repair welding of weld joint no: SEG3013K-001 [FB to Bottom Panel (BP), CJP weld, at PP119-1500]. The welder is identified as 045240 and was observed welding in the 1G position. Welding process was identified as FCAW. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-1G(1F)-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 17563 Rev-0.

OBG Seg 13BW:

Repair welding of weld joint no: SEG3014S-001 [Vertical Plate (VP3012) to VP3013] CJP weld. The welder is identified as 051348 and was observed welding in the 1G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-Repair. Repair welding was done as per WRR: B-WR 17318 Rev-0.

OBG Seg 14W:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3020*-009 [Deck Panel (DP)3175 to DP3176, CJP weld]. The welder is identified as 045265 and was observed welding in the 1G position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-B-L2c-S2.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	------------------	-------------