

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-019260**Date Inspected:** 15-Dec-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:

Cross Beam 18 (CB18):

Notification no: 007782.

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 – CB18. The weld designations reviewed are as follows:

- 1) FB3169-001-015, 016.
- 2) FB3169-002-015, 016.
- 3) FB3169-003-015, 016.
- 4) FB3169-004-015, 016.
- 5) FB3168-001-015, 016.
- 6) FB3168-002-015, 016.
- 7) FB3168-003-015, 016.
- 8) FB3168-004-015, 016.

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- 9) SA3075-001-007, 023.
- 10) SA3075-002-007, 023.
- 11) SA3076-003-006, 022.
- 12) SA3076-004-006, 022.

This QA Inspector also performed the NDT (UT and MT) verification for the welds of this CB. It was noted that NDT on some of the welds is previously done by CT and are not recorded / documented. All such welds were identified and were recorded on the drawings / weld maps and were submitted to the Task Leader for review.

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013R-222 [Floor Beam (FB) to Edge Beam (EB), complete joint penetration (CJP) weld; at Panel Point (PP) 117.5]. The welder is identified as 066784 and was observed welding in the 3G position. ABF QA was identified as Liu Tao. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2233-ESAB. This QA verified the welding parameters and were found as per the above mentioned WPS.

The FCAW process on weld joint no: SEG3013AA-087 (EB to EB), CJP weld; at PP120. The welder is identified as 047866 and was observed welding in the 3G position. ABF QA was identified as Liu Tao. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB. This QA verified the welding parameters and were found as per the above mentioned WPS.

The FCAW process on weld joint no: SEG3013Q-235 [Floor Beam (FB) to I rib stiffener], fillet weld; at PP118. The welder is identified as 066421 and was observed welding in the 3F position. ZPMC QC was identified as Li Ping. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB.

OBG Seg 14W:

ZPMC NDE personnel performing UT of weld jt no: SEG3020*-009 and 010 [Deck Panel (DP) 3176 and DP3177]. UT repair was identified at one location on weld joint no: 010.

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

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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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