

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-019267**Date Inspected:** 23-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:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

The Flux Cored arc Welding (FCAW) process on weld joint no: SEG3020V-075 [Longitudinal Diaphragm (LD) 3048A to Floor Beam (FB), complete joint penetration (CJP) weld, at PP125]. The welder is identified as 045276 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with welding procedure specification (WPS): B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020Q-058 (LD3049A to FB3320A, CJP weld, at PP126). The welder is identified as 067876 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020K-007 (LD3050A to SA3409A, CJP weld, at PP127.3). The

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

welder is identified as 066239 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020G-062 (LD3048A to FB3339A, CJP weld, at PP128). The welder is identified as 045246 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 13CW:

The SMAW process on weld joint no: SEG3015B-271 [Vertical Plate (VP) 3015A to Side Plate (SP) 3112A, CJP weld; in between PP122 to PP122.5]. The welder is identified as 066236 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

OBG Seg 13BW:

ZPMC personnel performing weld built-up on Edge Beam (EB) 3044A at PP122. EB3044A was needed to be removed and re-align with EB3040A to correct the mis-alignment after welding. Repair welding was done as per Critical Welding report (CWR): B-CWR-2293 Rev-0. The welder is identified as 201583. Welding process was identified as FCAW. See attached photo for details.

The FCAW process on weld joint no: SEG3014H-117 ['K'-plate (KP) 3017A FB3204A, CJP weld, at PP120.5). The welder is identified as 067610 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3014F-190. The welder is identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013L-005 (FB3192A to LD3031A, CJP weld at PP119 – 1500). The welder is identified as 066163 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19238 Rev-0.

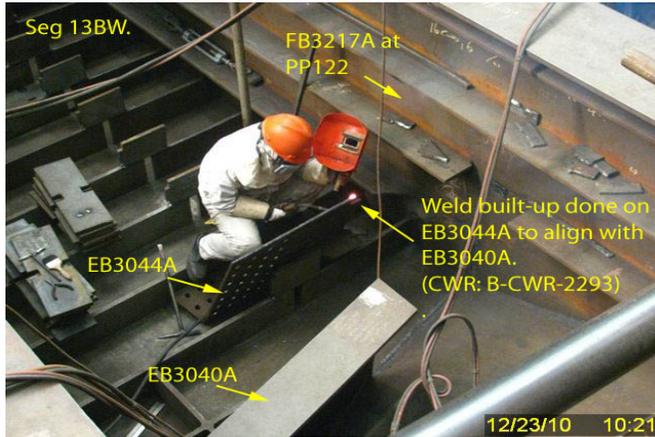
Repair welding of weld joint no: SEG3013F-002 (FB3192A to SA3168A, CJP weld at PP119 + 1500). The welder is identified as 066361 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19238 Rev-0.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
