

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-019271**Date Inspected:** 27-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: SEG3020X-013 [Longitudinal Diaphragm (LD) 3049A to Bottom Panel (BP), complete joint penetration (CJP) weld, at PP126 to PP126.3]. The welder is identified as 045276 and was observed welding in the 2G position. ZPMC Quality Control (QC) was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020H-027 [Floor Beam (FB) 3330A to Side Panel (SP) SP3133A, fillet weld, at PP127.5]. The welder is identified as 045276 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.

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The FCAW process on weld joint no: SEG3020A-009 (SP to BP, CJP weld, at PP125 to PP127). The welders are identified as 066421, 066734 and 058245 and were 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-2231-ESAB.

The FCAW process on weld joint no: SEG3020X-012 (LD3049B to BP, CJP weld, at PP127). The welder is identified as 066236 and was observed welding in the 2G position. ZPMC QC was identified as Sun Tian Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg 13CW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3015B-200 (X4463D stiffener on FB3236A to FB3224A, CJP weld, at PP123). The welder is identified as 045196 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-P-2212-B-U3b.

The FCAW process on weld joint no: SEG3015K-264 [FB to Vertical Plate (VP), CJP weld, at PP122.5]. The welder is identified as 201583 and was observed welding in the 1G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-ESAB.

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013Q-040 (LD to FB, CJP weld at PP118). The welder is identified as 045221 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 2523 Rev-0.

The FCAW process on weld joint no: SEG3013U-036, 042 (LD3031A to X4310C I-rib stiffener, fillet weld, at PP117.5). The welder is identified as 068494 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-2132-ESAB.

The SMAW process on weld joint no: SEG3013AH-021 (FB3184A to KP3010A, CJP weld, at PP119-1500). The welder is identified as 067183 and was observed welding in the 4G position. ZPMC QC was identified as Qiu Wen. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

Repair welding of weld joint no: LD3048-001-039, CJP weld (on lifting bracket at PP125). The welder is identified as 045268 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19581 Rev-0.

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
