

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-019409**Date Inspected:** 29-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 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: KP3009-001 [K-Plate to Floor Beam (FB) 3180A, complete joint penetration (CJP) weld, at PP118.35]. The welder is identified as 067183 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-P-2213-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3013K-066 (FB3184A to I-rib stiffener, CJP weld, at PP119-1500). The welder is identified as 045143 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

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Repair welding of weld joint no: SEG3013F-003 [FB3191A to Bottom Panel (BP), CJP weld at PP119+1500]. The welder is identified as 066163 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Qiu Wen. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19195 Rev-0.

Repair welding of weld joint no: SEG3013K-003 (FB3184A to BP, CJP weld at PP119-1500). The welder is identified as 045221 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Qiu Wen. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as WRR: B-WR 19197 Rev-0.

The SMAW process on weld joint no: SEG3013B-053 (RS3463A stiffener on BP to FB3200A, CJP weld, at PP120). The welder is identified as 066481 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

OBG Seg 14W:

Repair welding of weld joint nos: LD3043-001-039 and 062. 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 Sun Tian Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as WRR: B-WR 19581 Rev-0 and B-WR 19582 Rev-0 for the respective welds.

The FCAW process on weld joint nos: SEG3020K-009 and 021 (SA3409A to LD3051A, CJP weld, at PP127.3). The welder is identified as 045227 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020K-025, CJP weld, at PP127.3). The welders are identified as 202122 and 047866 and were 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-T-2232-ESAB.

During random inprocess visual inspection, this QA inspector observed a cracked tack weld (FB3338A to LD3051A, at PP128). This is informed to ZPMC QC, identified as Zhu Lin. See attached photos for reference.

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