

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-019532**Date Inspected:** 26-Jan-2011**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:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint nos: SEG3015S-212 [Edge Beam (EB) 3030B to Floor Beam (FB) 3175A, complete joint penetration (CJP) weld at PP117.5]. The welder is identified as 066361 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per welding repair report (WRR): B-WR 19937 Rev-0.

Repair welding of weld joint nos: SEG3014D-330 [FB3212A to I-rib stiffener on Side Panel (SP) 3104A, CJP weld at PP121.5]. The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Sun Tian Liang. 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 20191 Rev-0.

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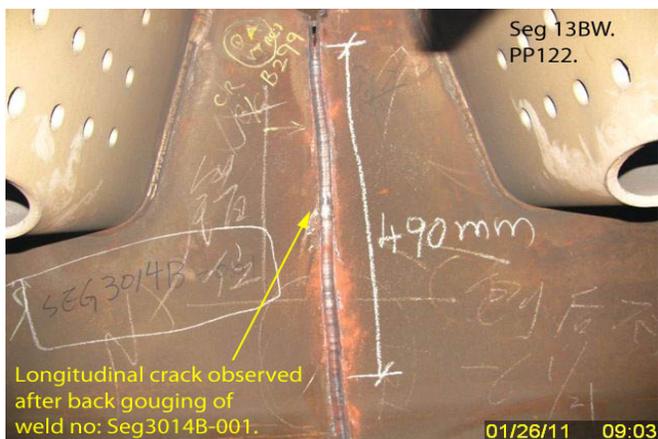
OBG Seg 13BW:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3014-009 [Deck Panel (DP) 3130A to Corner Assembly (CA) 3015A, CJP weld]. The welder is identified as 250050 and was observed welding in the 1G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

OBG Seg 13BW and Seg 13CW:

During random inprocess visual inspection of DP Diaphragm splice welds, this QA Inspector observed that some of the splice joints after back gouging were found to have cracks. This QA Inspector informed this to ZPMC CWI, identified as Li Ming Yang. ZPMC QC agreed that welding of these welds will be done after having approval of CWR. See attached photos for further information.

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:	Peterson,Art	QA Reviewer
