

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019648**Date Inspected:** 31-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. SHAO JIAN YUAN**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 Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the floor beam to longitudinal diaphragm weld joint located on 14E. The weld is designated as SEG3019D-001-178. The welder is identified as 050969. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1. The critical weld repair report number is named as CWR-2745. Further weld detail mention in attached picture.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchorage plate to vertical shear plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-047. The welder is identified as 066763. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

welding variables. The welding variables were recorded at, Amperage 270.2, Volts 26.5. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchorage plate to vertical shear plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-069. The welder is identified as 067099. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, Amperage 265.4, Volts 24.6. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchorage plate to vertical shear plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-091. The welder is identified as 067087. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, Amperage 267.0, Volts 25.2. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to vertical shear plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-169. The welder is identified as 215553. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2737.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the bottom plate to anchorage plate weld joint located on 14E at bike path side. The weld is designated as SEG3019U-003. The welder is identified as 066236. ZPMC QC Mr. CHENG XI was onsite monitoring the welding variables. The welding variables were recorded at, Amperage 278.4, Volts 26.1. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13CE. The weld is designated as SEG3011B-006. The welder is identified as 066041. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, Amperage 275.6, Volts 25.2. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13CE. The weld is designated as SEG3011D-006. The welder is identified as 214945. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, Amperage 295.4, Volts 24.2. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

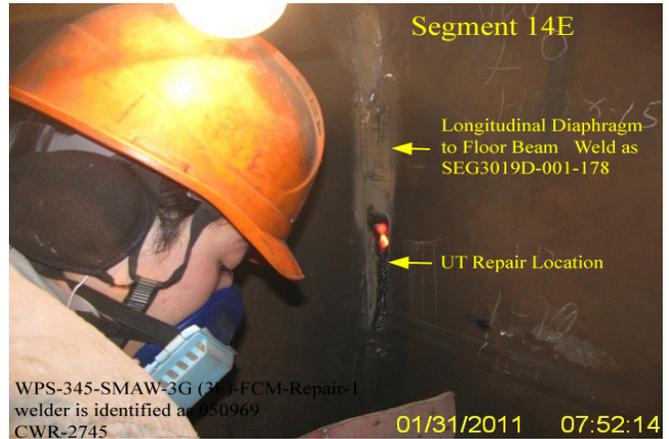
ZPMC welding personnel performing Submerge Arc Welding of Complete Joint Penetration welds joining the deck plate to deck plate transverse splice weld joint located on 13BE+13CE. The weld is designated as OBE13A-009. The welder is identified as 215993. ZPMC QC Mr. LU LI QING was onsite monitoring the welding variables. The inprocess Submerge Arc Welding appears to be progressing in compliance with WPS-B-T-223(2)1T-ESAB-1.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

ABF Quality Assurance (QA) personnel performing Ultrasonic Testing (UT) for the deck plate to deck plate splice weld joint located on 13BE. The weld is designated as SEG3009-004.

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



Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer