

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-019720**Date Inspected:** 02-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:

Bay 14:

Notification no: 008016.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) SEG3013AU-036, 037, 033, 054, 032, 059, 038, 053, 060.
- 2) SEG3013AT-016, 018.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

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The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013K-028 [Floor Beam (FB) 3191A to K-Plate KP3014A, complete joint penetration (CJP) weld, at PP119+1500]. The welder is identified as 067588 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

The SMAW process on weld joint no: SEG3013AH-017 (FB3180A to KP3009A, CJP weld, at PP118.35). The welder is identified as 037748 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. 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: SEG3013F-093 (I-rib to FB3191A at PP119+1500, CJP weld). The welder is identified as 068494 and was observed welding in the 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

Repair welding of weld joint no: SEG3013AD-017 [FB3193A to Side panel (SP) 3092E, CJP weld at PP119+1500]. The welder is identified as 066361 and was observed welding in the 4G 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-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19611 Rev-0.

Repair welding of weld joint no: SEG3013AD-022 (FB3202A to SP3092F, CJP weld at PP120). The welder is identified as 066361 and was observed welding in the 4G 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-4G(4F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19614 Rev-0.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020V-075 [FB3316A to Longitudinal Diaphragm (LD) 3049A, CJP weld at PP125]. The welder is identified as 066038 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 Critical Welding Repair Report (CWR): B-CWR 2622 Rev-0.

Repair welding of weld joint no: SEG3020Q-058 (FB3320A to LD3049A, CJP weld at PP126). The welder is identified as 047864 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 CWR: B-CWR 2620 Rev-0.

Repair welding of weld joint no: SEG3020R-033 (FB3320A to LD3048A, CJP weld at PP126). The welder is identified as 051348 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 CWR: B-CWR 2621 Rev-0.

The FCAW process on weld joint no: SEG3013F-029 (FB3336A to LD3049A, fillet weld at PP128). The welder is

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identified as 045276 and was observed welding in the 3F position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2133-ESAB.

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