

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-019732**Date Inspected:** 13-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:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

Repair welding of weld joint no: SEG3020X-013 [Longitudinal Diaphragm (LD) to Bottom panel (BP), complete joint penetration (CJP) weld, at panel point (PP) 126 to 126.5]. The welder is identified as 066695 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-ESAB. Repair welding was done as per Critical Welding Repair Report (CWR): 2662 Rev-0.

Repair welding of weld joint no: SEG3020X-014 (LD to BP, CJP weld, at PP126.5 to 127). The welder is identified as 067949 and was observed welding in the 2G position. Welding process was identified as FCAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:

WELDING INSPECTION REPORT

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345-FCAW-2G(2F)-FCM-Repair-ESAB. Repair welding was done as per CWR: 2662 Rev-0.

Repair welding of weld joint no: SEG3020D-052 [Floor Beam (FB) 3343A to Bottom panel (BP) 3092A, CJP weld, at PP128.3]. The welder is identified as 067520 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: 2734 Rev-0.

The FCAW process on weld joint no: SEG3020V-073 (FB3315A to LD3049A, CJP weld, at PP125). The welder is identified as 045175 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

The SMAW process on weld joint no: SEG3020AG-064 [Side Panel (SP) 3140C to Edge Plate (EP) 3020P, CJP weld, at PP126 to PP127]. The welder is identified as 067942 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM.

The SMAW process on weld joint no: SEG3020AL-029 (FB3329A to SP3140E, CJP weld, at PP127). The welder is identified as 066038 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM.

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013V-167 (SP3090E to SA3159A, CJP weld, at PP119.65 to PP119+1500). The welder is identified as 066781 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. 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): 20129 Rev-0.

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
