

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-019748**Date Inspected:** 13-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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

SEGMENT 13AW

Welding by SMAW process of weld joint SEG3013G-018 joining Floor Beam (FB) 3192A to Floor Beam (FB) 3193A at Panel Point (PP) 119+1500 of segment 13AW. Welder is identified as 070432. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2a-FCM-1.

Welding by FCAW process of weld joint SEG3013S-006, 007 joining Floor Beam (FB) 3175A to Longitudinal Diaphragm (LD) 3031A at Panel Point (PP) 117.5 of segment 13AW. Welder is identified as 046421. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

Welding by SMAW process of weld joint SEG3013P-006 joining Floor Beam (FB) 3176A to Floor Beam (FB) 3177A at Panel Point (PP) 118 of segment 13AW. Welder is identified as 067942. ZPMC QC is identified as Mr.

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Li Ping. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-U2a-FCM-1.

Repair welding by FCAW process of weld joint SEG3013K-007 (B-WR18682) joining Floor Beam (FB) 3184A to Longitudinal Diaphragm (LD) 3034A at Panel Point (PP) 119-1500 of segment 13AW. Welder is identified as 045280. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-REPAIR.

SEGMENT 13CW

Repair welding by FCAW process of weld joint SEG3015B-203 (B-WR18836) joining I-rib stiffener to Floor Beam (FB) 3233A at Panel Point (PP) 124.5 of segment 13CW. Welder is identified as 201583. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-REPAIR.

Repair welding by SMAW process of weld joint FB3343-001-348 (B-WR18658) of segment 13CW. Welder is identified as 047864. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR.

Repair welding by FCAW process of weld joint SEG3015B-187 (B-WR18830) joining I-rib stiffener to Floor Beam (FB) 3233A at Panel Point (PP) 124.5 of segment 13CW. Welder is identified as 201583. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-REPAIR.

Welding by SMAW process of weld joint SEG3015D-312 joining I-rib stiffener to I-rib stiffener at Panel Point (PP) 124 of segment 13CW. Welder is identified as 067610. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2a-FCM-1.

During random in process inspection this QA inspector observed that fit up of Floor Beam (FB) 3236A to Floor Beam (FB) 3224A at Panel Point (PP) 123 of segment 13CW has been done. The rat hole was observed to be offset from original position. Additional photograph provide additional detail.

SEGMENT 14W

Repair welding by SMAW process of weld joint LD3049-001-423 (B-CWR2466, Rev 0) joining Longitudinal Diaphragm (LD) 3049A to Longitudinal Diaphragm (LD) 3049B at Panel Point (PP) 126 of segment 14W. Welder is identified as 045246. ZPMC QC is identified as Mr. Sun Tian Liang. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR.

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

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
