

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-019924**Date Inspected:** 01-Feb-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. LI YAN HUA**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 Bay-14 Area:

ZPMC welding personnel performing Flux Core 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. ZHONG YONG HONG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-223(2)1-ESAB-1.

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. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, current 280.2 Amps, Voltage 26.2 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB. Further weld detail

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mention in attached picture.

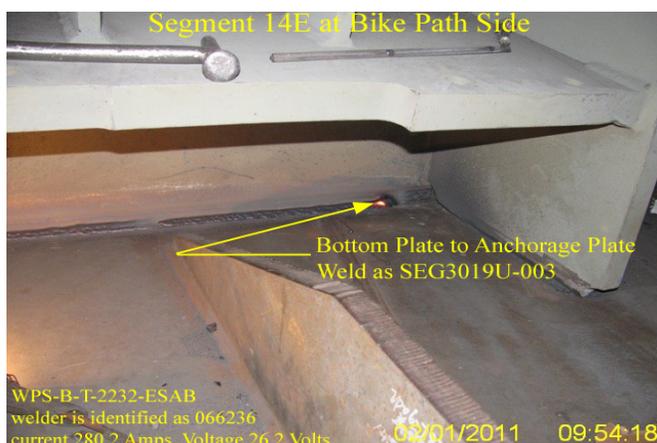
ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the vertical shear plate to anchorage plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-113. The welder is identified as 067079. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, current 265.4 Amps, Voltage 24.6 Volts. 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 vertical shear plate to anchorage plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-135. The welder is identified as 067877. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, current 272.2 Amps, Voltage 26.4 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB. Further weld detail mention in attached picture.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the vertical shear plate to anchorage plate weld joint located on 14E at bike path side. The weld is designated as SEG3019BB-157. The welder is identified as 066763. ZPMC QC Mr. GUO SHI HUI was onsite monitoring the welding variables. The welding variables were recorded at, current 259.2 Amps, Voltage 26.6 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

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 SEG3009-009.

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

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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.

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| Inspected By: | Pillai,Santosh | Quality Assurance Inspector |
| Reviewed By: | Miller,Mark | QA Reviewer |
