

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-020463**Date Inspected:** 08-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), 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: 008318.

OBG Seg 13W:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) SEG3013F-140, 128.
- 2) SEG3013R-222.
- 3) SEG3013P-275, 277, 278.
- 4) SEG3013K-123.

For weld no Seg3013K-123.

[Edge Beam (EB) 3048B to Floor Beam (FB) 3184A at Panel Point (PP) 119-1500]:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

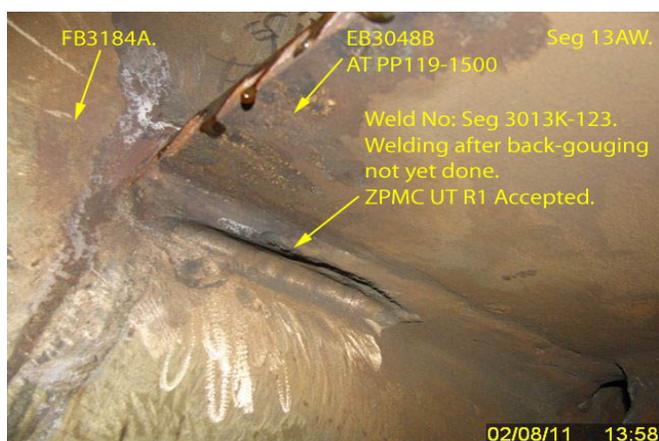
- For the above mentioned weld, as per drawing, complete joint penetration (CJP) + 8mm fillet weld is required.
- It was observed that welding after back gouging is not yet done.
- Weld is 100% UT tested and accepted by ZPMC personnel.
- Material thickness is 25mm.
- Weld is identified as Fracture Critical Weld (FCW).
- The Notice of Witness Inspection Number (NWIT) is 08318.
- As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this welds.
- This QA informed about this to ZPMC QA; identified as Qiu Wen and ABF QA; identified as Kasi Wang; and that an incident report would be generated.
- See attached photos for further information.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AH-041 [K-Plate 3010A to Side Panel (SP) 3101A, complete joint penetration (CJP) weld at PP118.35]. The welder is identified as 066002 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20173 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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:	Peterson,Art	QA Reviewer
