

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020523**Date Inspected:** 07-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU HUA JIE**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 Trial Assembly Area:

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Complete Joint Penetration (CJP) welds joining the edge plate to side plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as CA093-005(11EE) & SEG3001AA-002(12AE). The welder is identified as 047353. ZPMC QC Mr. LIU HUA JIE was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2231-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Fillet welds joining the intermediate panel point stiffener to corner assembly located on 11DE at bike path side. The weld is designated as SSD023-PP106.5-001. The welder is identified as 067765. ZPMC QC Mr. ZHANG QIANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2114, WPS-B-P-2113 & WPS-B-P-2112.

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ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the T-Rib web to web weld joint for bottom plate located on 12AW+12BW. The weld is designated as BP3019-001-042. The welder is identified as 044551. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the T-Rib web to web weld joint for side plate located on 12AW+12BW at cross beam side. The weld is designated as SP3037-001-159. The welder is identified as 040656. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to deck plate hold back weld joint located on 11EE+12AE at cross beam side. The weld is designated as CA093-006(11EE) & SEG3001AA-001(12AE). The welder is identified as 040320. ZPMC QC Mr. AN QING XING was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2212-TC-U4b-FCM-1.

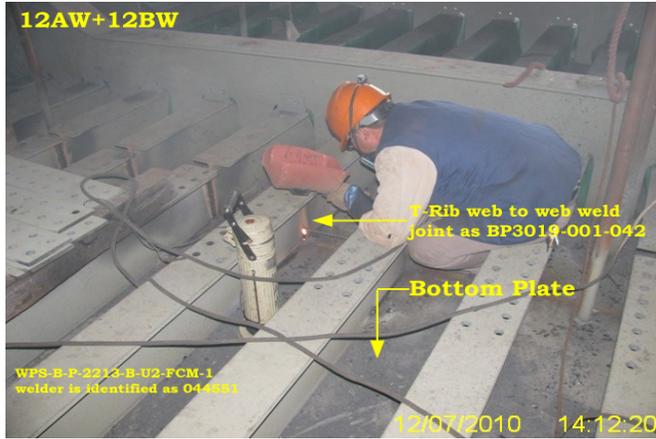
ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-105 & 106). The weld is designated as SSD025-PP105-137. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-18304.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the partial diaphragm weld joint located on 11DW+CB-16 at Panel Point between (PP-105 & 106). The weld is designated as SSD025-PP105-117. The welder is identified as 046709. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as WR-18305.

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

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Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

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