

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-020563**Date Inspected:** 09-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:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013AA-086 [I-rib stiffener on Edge Beam (EB) 3020F to Floor Beam (FB) 3202A, complete joint penetration (CJP) weld at Panel Point (PP) 120]. The welder is identified as 037748 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 20128 Rev-0.

Repair welding of weld joint no: SEG3013AA-045 (I-rib stiffener on EB3020F to FB3189A, CJP weld at PP119). The welder is identified as 037748 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to

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comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 20128 Rev-0.

OBG Seg 13BW:

The FCAW process on weld joint no: Seg3014H-235 (Diaphragm to FB, CJP weld at PP120.5). The welder is identified as 045227 and was observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3014F-086 (Diaphragm to FB, CJP weld at PP121). The welders are identified as 067888 and 201583 and were observed welding in the 2G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg 14W:

Repair welding of weld joint no: SEG3020E-044 [FB to Longitudinal Diaphragm (LD), CJP weld at PP119). The welder is identified as 066038 and was observed welding in the 3G position. Welding process was identified as SMAW. ABF QA was identified as Kim. The welding variables appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 2735 Rev-0.

The FCAW process on weld joint no: Seg3020AB-054 (LD3050A to FB3340A, CJP weld at PP128). The welder is identified as 067949 and was observed welding in the 2G position. ABF QA was identified as Kim. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The SMAW process on weld joint no: Seg3020D-068 (LD to FB, CJP weld). The welder is identified as 069683 and was observed welding in the 4G position. ABF QA was identified as Kim. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

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:	Peterson,Art	QA Reviewer
