

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-020657**Date Inspected:** 16-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: SEG3013AH-117 [I-rib on K-Plate 3012A to Floor Beam (FB) 3187A, complete joint penetration (CJP) weld at Panel Point (PP) 119]. The welder is identified as 066361 and was observed welding in the 1G 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-1G(1F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR 2799 Rev-0.

Repair welding of weld joint no: SEG3013AH-104 (I-rib on K-Plate 3012A to FB3184A, CJP weld at PP119-1500). The welder is identified as 066361 and was observed welding in the 1G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC

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appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair. Repair welding was done as per CWR: CWR 2799 Rev-0.

The SMAW process on weld joint no: Seg3013F-088 [RS stiffener (RS3480A) on Side Panel (SP) 3100A to FB3191A, CJP weld at PP119+1500]. The welder is identified as 066261 and was observed welding in 4G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

OBG Seg 13BW:

The SMAW process on weld joint no: Seg3014G-146 [FB3211A to Corner Assembly (CA) 3015A, CJP weld at PP121]. The welder is identified as 045196 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3014J-164 (FB3207A to CA3015A, CJP weld at PP120.5). The welder is identified as 037966 and was observed welding in the 3G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

OBG Seg 13CW:

The FCAW process on weld joint no: Seg3015A-014 (SP3097A to CA3016A, CJP weld). The welder is identified as 067734 and was observed welding in the 1G position. ZPMC QC was identified as Zhang Ling. The welding variables recorded by QC appeared to comply with WPS: B-T-2231T-ESAB-1. Welding was observed to be done with ceramic backing.

OBG Seg 14W:

The SMAW process on weld joint no: DP3172-019 [X4882E diaphragm to Deck Panel (DP) 3172, CJP weld]. The welder is identified as 067520 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables appeared to comply with WPS: B-P-2212-Tc-U4b-FCM.

The SMAW process on weld joint no: DP3173-020 (X4881D diaphragm to DP3173, CJP weld). The welder is identified as 066443 and was observed welding in the 2G position. ABF QA was identified as Shen Jian. The welding variables appeared to comply with WPS: B-P-2212-Tc-U4b-FCM.

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

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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
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Reviewed By:	Peterson,Art	QA Reviewer
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