

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-020728**Date Inspected:** 14-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. ZHU ZHONG HAI**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 Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to bottom plate transverse splice weld joint located on 12BE+12CE. The weld is designated as OBE12C-001. The welder is identified as 044515. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-1G (1F)-FCM-Repair-1. The weld repair report number is named as WR-20190. Further weld detail mention in attached picture.

ZPMC welding personnel performing Air Carbon Arc Gouging on UT Repair weld for the side plate to side plate transverse splice weld joint located on 12BE+12CE at bike path side. The weld is designated as OBW12E-003. ZPMC QC Mr. WANG LI YANG was onsite monitoring the gouging variables. Further weld detail mention in

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attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Base Metal Repair weld (temporary attachment removal area) near the bottom plate to bottom plate transverse splice weld joint located on 12BW+12CW. The location near the weld is designated as OBW12C-001. The welder is identified as 040611. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-2126.

Orthotropic Box Girder (OBG) at Bay-14 Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to vertical shear plate weld joint located on 14W at counter weight side. The weld is designated as SEG3020BB-019. The welder is identified as 066038. ZPMC QC Mr. ZHU LIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2752.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to vertical shear plate weld joint located on 14W at counter weight side. The weld is designated as SEG3020BB-073. The welder is identified as 067942. ZPMC QC Mr. ZHU LIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2794.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the anchor plate to vertical shear plate located on 14W at counter weight side. The weld is designated as SEG3020BE-113. The welder is identified as 067764. ZPMC QC Mr. Zhu Lin was onsite monitoring the welding variables. 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 anchor plate to vertical shear plate located on 14W at counter weight side. The weld is designated as SEG3020BE-117. The welder is identified as 067888. ZPMC QC Mr. Zhu Lin was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB.

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