

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-020762**Date Inspected:** 19-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**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 14W:

Repair welding of weld joint no: Seg3020BB-073 [Sub Assembly Vertical Shear Plate (VSP) to Bottom Panel (BP), complete joint penetration CJP weld]. The welder is identified as 045246 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Zhu Lin. 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 critical welding repair report (CWR): 2752.

Repair welding of weld joint no: Seg3020BB-019 [VSP to BP, CJP weld]. The welder is identified as 049864 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:

WELDING INSPECTION REPORT

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345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: 2752.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020BB-117 (Anchor Plate to VSP, CJP weld). The welder is identified as 067888 and was observed welding in 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3020BB-110 (Anchor Plate to VSP, CJP weld). The welder is identified as 201215 and was observed welding in 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13BW:

Repair welding of weld joint no: Seg3014S-054 [K-Plate to Side Panel, CJP weld]. The welder is identified as 045213 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per welding repair report (WRR): B-WR 20254 Rev-0.

OBG Seg 13AW:

The FCAW process on weld joint no: Seg3013K-018 [Deck panel Diaphragm to Floor Beam, CJP weld, at Panel Point (PP) 119-1500]. The welder is identified as 069469 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The Submerged Arc Welding (SAW) process on weld joint no: Seg3013-009 [DP to DP, CJP splice weld]. The welder is identified as 045270 and was observed welding in 1G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2221-B-L2c-S2.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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