

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-020921**Date Inspected:** 23-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:

West Grillage:

Repair welding of weld joint nos: SA712C-257, complete joint penetration (CJP) weld. The welder is identified as 047864 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 Shen Jian Bo. 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 2629 Rev-4.

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013R-006 (Deck Panel Diaphragm to Floor Beam (FB3172A), CJP weld at PP117.5). The welders are identified as 045143 and 201583 and were observed

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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.

OBG Seg 13CW:

Repair welding of weld joint no: Seg3014D-340 [FB3194A to I-rib (RS stiffeners) on Side Panel (SP3101A), CJP weld at panel point (PP) 121.5]. The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhang Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per welding repair report (WRR): 20261 Rev-0.

The SMAW process on weld joint no: Seg3015C-013 [DP diaphragm (of DP3143A) to Corner Assembly (CA) 3016A, CJP weld, at PP124.5]. The welder is identified as 037840 and was observed welding in 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: Seg3015C-146 (FB3235A to CA3016A, CJP weld, at PP124.5). The welder is identified as 037840 and was observed welding in 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: Seg3015L-013 [DP diaphragm (of DP3143A) to CA 3016A, CJP weld, at PP122.5]. The welder is identified as 045196 and was observed welding in 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: Seg3015C-146 (FB3223A to CA3016A, CJP weld, at PP124.5). The welder is identified as 045196 and was observed welding in 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 14W:

The SMAW process on weld joint no: DP3172-020 (DP to DP diaphragm, CJP weld]. The welder is identified as 037779 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: DP3172-019 (DP to DP diaphragm, CJP weld). The welder is identified as 067588 and was observed welding in 2G position. ABF QA was identified as Shen Jian. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

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

Summary of Conversations:

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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
