

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-020999**Date Inspected:** 25-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:

East Saddle Grillage - West line:

This QA Inspector observed ZPMC personnel performing fit-up of West Grillage to the Floor Beam and Vertical Plate. However, repair welding of 2 welds (weld joint nos: SA7512C-257 and 258) are still outstanding. The gouging / excavation operation was previously performed. Also the NDT; UT of the above mentioned 2 welds joints and MPT of all welds on the Grillage is still outstanding (by ZPMC / ABF). Also the cope holes on the Grillage assembly need to be profiled by welding and / or grinding for compliance with Contract specification. The Grillage assembly was not green tagged prior to being fit-up to the segment. See attached photo for further information.

Incident Report (IR) was generated for the above mentioned non-compliances.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC personnel performing fit-up of FB3171A with K-Plate KP3009A & KP3010A (at PP117.5), Floor Beam – X4369 (SPCM) with KP3009A (at PP118) and FB3179A with KP3009A (at PP118.35). ZPMC QC was identified as Liu Feng. See attached photo for further information.

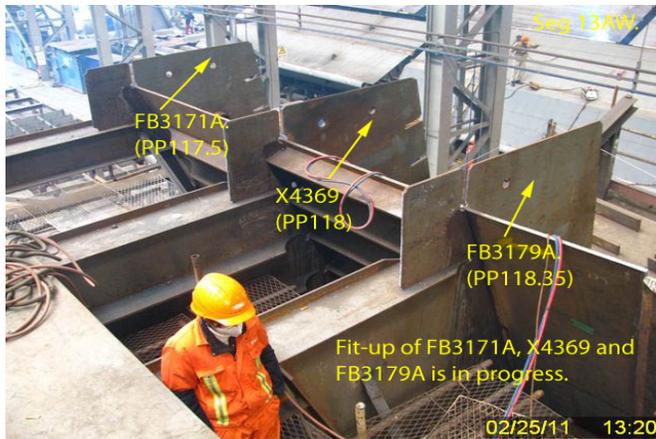
The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013F-025 [FB to Deck Panel (DP) diaphragm, CJP weld at PP119+1500]. The welder is identified as 045143 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

OBG Seg14W:

Repair welding of weld joint no: DP3173-284 (DP to DP diaphragm, CJP weld). The welder is identified as 067588 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Shi Lei. 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): 20289 Rev-0.

Repair welding of weld joint no: DP3174-034 (DP to DP diaphragm, CJP weld). The welder is identified as 066155 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: 20289 Rev-0.

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



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
---------------------	--------------	-------------