

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-021316**Date Inspected:** 01-Mar-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:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013F-025 [Deck Panel Diaphragm (of DP3124A) to Floor Beam (FB) 3191A, complete joint penetration (CJP) weld at panel point (PP) 119+1500]. The welder is identified as 045143 and was observed welding in 2G position. ZPMC Quality Control (QC) was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with Welding Procedure Specification (WPS): B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013AA-116 [DP3116A to Edge Plate (EP) 3020B, fillet weld at PP118 to PP118.5]. The welder is identified as 067765 and was observed welding in 4F position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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The SMAW process on weld joint no: Seg3013P-061 [FB X4369A to K-Plate (KP) 3009A and KP3010A, fillet weld at PP118]. The welder is identified as 066179 and was observed welding in 3F position. ZPMC QC was identified as Liu Feng. 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: Seg3013M-035 (FB3179A to KP3009A and KP3010A, fillet weld at PP118.35). The welder is identified as 066179 and was observed welding in 3F position. ZPMC QC was identified as Liu Feng. 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: Seg3013R-026 (FB3171A to KP3009A and KP3010A, fillet weld at PP117.5). The welder is identified as 066179 and was observed welding in 3F position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

East Saddle Grillage – West line:

This QA Inspector observed ZPMC UT personnel performing UT of welds of West Grillage to Floor Beam at PP119, PP119+1500 and PP119-1500.

OBG Seg 14W:

The FCAW process on weld joint no: Seg3316-094 (X4833A on X4833B on FB3316A, CJP weld at PP125). The welder is identified as 066673 and was observed welding in 2F position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2132-ESAB.

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
Reviewed By:	Peterson,Art	QA Reviewer
