

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-021494**Date Inspected:** 04-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 Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013H-035 [Floor Beam (FB) 3187A to X4391 I-rib stiffener, fillet weld at PP119]. The welder is identified as 067996 and was observed welding in 4F 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-P-2114-TC-U4b-FCM-1.

The SMAW process on weld joint no: Seg3013F-035 (FB3191A to X4391 I-rib stiffener, fillet weld at PP119+1500). The welder is identified as 069896 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-B-U3b.

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The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013P-031 [X4369A to Edge Plate (EP) 3023A, complete joint penetration (CJP) weld at PP118]. Welding was observed to be done after back gouging. The welder is identified as 045143 and was observed welding in 3G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13BW:

The SMAW process on weld joint no: Seg3014B-001 [Deck Panel (DP) Diaphragm splice joint – DP3137A to DP3136A, CJP weld at PP122]. The welder is identified as 045143 and was observed welding in 3G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U3-FCM-1.

The SMAW process on weld joint no: Seg3014C-008 (DP3132A Diaphragm to DP connecting plate, CJP weld at PP122). The welder is identified as 045213 and was observed welding in 3G position. ZPMC QC was identified as Zhang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U3-FCM-1.

OBG Seg 14W:

The SMAW process on weld joint no: FB3329-001-014 (FB3329A to X4934C, fillet weld at PP127). The welder is identified as 051348 and was observed welding in 4F position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-TC-U4b-FCM-1.

The FCAW process on weld joint no: Seg3020BB-076 (Anchorage Plate to Bottom Panel, CJP weld). The welder is identified as 066695 and was observed welding in 2G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3020AJ-394 (I-rib to I-rib stiffener, on Bottom Panel, CJP weld). The welder is identified as 066239 and was observed welding in 3G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-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

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Reviewed By: Peterson, Art

QA Reviewer