

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-021576**Date Inspected:** 01-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:** Mr. Xu Le Feng.**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:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10:

Repair welding, FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040434, Perform Flux Core Arc Welding (FCAW) on OBG Traveler rail joint. Joint identified as 20TR2-030-015. ZPMC QC Identified as Xu Jie with temporary welding repair report WRR-B-WR20216. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) ESAB-Repair. For more information see attached picture number 1.

Bay 14, Segment 14W

FCAW process:

FCAW in the 2G position for the OBG Segment 14W, weld No.DP3169-001-018. The welder is identified as #067888. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 270, volts 25.2. The In-process FCAW appears to be progressing in compliance with approved contract documents.

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FCAW in the 2G position for the OBG Segment 13BW, weld No.SEG3014H. The welder is identified as #201583. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 267, volts 24.6 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

FCAW in the 2G position for the OBG Segment 14W, weld No.DP3169-001-266. The welder is identified as #203781. ABF QC is identified as Mr. Shao Jian Yuan. The welding variables recorded by QC appear to comply with WPS-B-T-2232-ESAB. The welding variables were recorded at, Amperage 280, volts 24.6 .The In-process FCAW appears to be progressing in compliance with approved contract documents.

Repair Welding, SMAW process:

SMAW in the 2G position for the OBG Segment 14W, UT repair weld No.SEG3020D-052. The welder is identified as #066398. ABF QC is identified as Mr. Wang Jian Hua. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G (2F)-FCM-REPAIR-1. The weld repair report is identified as CWR2734. The welding variables were recorded at, Amperage 234, volts 23.6 .The In-process SMAW appears to be progressing in compliance with approved contract documents.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer