

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-021656**Date Inspected:** 08-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:** An Qing Xiang.**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: Seg3013B-253 [Deck Panel (DP) Diaphragm complete joint penetration (CJP), splice joint (DP3125A to DP3124A), at panel point (PP) 120]. The welder is identified as 045196 and was observed welding in 3G 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-2213-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013C-140 [DP Diaphragm CJP, splice joint (DP3119A to DP3118A), at PP120]. The welder is identified as 045196 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.

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OBG Seg 14W:

This QA Inspector observed ZPMC personnel performing heat straightening on LD3049A (at weld joint no: Seg3020X-008). Heat straightening was done as per heat straightening report (HSR) no: HSR1-(B)-10171. However, it was observed that the Ultrasonic Testing of weld joint no: Seg3020X-008 [Longitudinal diaphragm (LD) 3049A to Floor Beam (FB) 3325A], CJP weld, is previously completed (on 05/03/11) by ZPMC and Caltrans QA. This QA informed about this issue to ZPMC CWI Mr. An Qing Xiang. ZPMC QC agreed that they will re-notify for NDT of this weld after completion of heat straightening. See attached photo for further information.

The SMAW process on weld joint no: EP3030-001-108 (Edge Plate to Edge Plate, CJP splice joint at PP 125). The welder is identified as 051348 and was observed welding in 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-B-U3b.

This QA Inspector observed ZPMC personnel performing UT on weld joint no: Seg3020AP-002. Around 3 locations were identified for repair.

This QA Inspector verified the percentage of NDT completion of welds on Seg 13AW, Seg13BW and Seg13CW. Roughly, NDT completion was observed as mentioned below.

- For 13AW: 35% completed.
- For 13BW: 40% completed.
- For 13CW: 40% completed.

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

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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
