

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-021822**Date Inspected:** 15-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 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020AJ-016 [I-rib stiffener (RS3516) on Bottom Panel (BP) 3088A to Floor Beam (FB) 3315A, complete joint penetration (CJP) weld at PP125]. The welder is identified as 066239 and was observed welding in 3G position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2233-ESAB.

The FCAW process on weld joint no: Seg3020AJ-015 [I-rib stiffener (RS3516) to I-rib stiffener (RS3512D) on BP3088A, CJP weld at PP125]. The welder is identified as 066239 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding of weld joint nos: Seg3020BB-110 [Anchor Plate (AP) 3032A to Vertical Shear Plate Sub-Assembly (VSP), CJP weld]. The welder is identified as 051348 and was observed welding in the 3G position.

Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS:

345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20409 Rev-0.

The SMAW process on weld joint no: FB3316-001-095 [X4833A to X4833B (of FB3316A), fillet weld at PP125].

The welders are identified as 067572 and 067609 and were observed welding in 4F position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS:

B-P-2114-FCM-1.

The SMAW process on weld joint no: Seg3020C-056 [FB3348 to Side Panel (SP) 3143C, CJP weld, at PP128.

7-160]. The welder is identified as 047866 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS:

B-P-2214-TC-U4b-FCM-1.

The SMAW process on weld joint no: Seg3020AW-089 (SP3131A to SP3145B, CJP weld). The welders are

identified as 037779 and 067520 and were observed welding in 2G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

The SMAW process on weld joint no: Seg3020AW-092 (SP3132A to SP3144B and SP3145B, CJP weld). The

welders are identified as 067942 and 067765 and were 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-2214-TC-U4b-FCM-1.

OBG Seg 13W:

This QA Inspector observed this Segment been shifted from Bay14 to Trial Assembly.

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