

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-022143**Date Inspected:** 27-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:** Liu Hua Jie.**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:

Trial Assembly:

This QA Inspector observed the following work in progress:

OBG Seg 13AE:

Repair welding of weld joint no: Seg3007AB-095 [Deck Panel (DP) 3072C to Edge Panel (EP) 3013C, complete joint penetration (CJP) weld]. The welder is identified as 037743 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20486 Rev-0. See attached photo for further information.

Repair welding of weld joint no: DP3078-001-011 [X3499P to X3325J DP Diaphragm, CJP weld at panel point (PP) 117.5]. The welder is identified as 066416 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC

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appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: 20509 Rev-0.

The SMAW process on weld joint no: Seg3007AH-093 [I-rib stiffener (X3751) on K-Plate (KP) 3001A to Grillage Assembly), CJP weld at PP119-1500]. The welder is identified as 067183 and was observed welding in 4G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

Repair welding of weld joint no: Seg3007L-003 (DP Diaphragm CJP splice joint at PP119-1500). The welder is identified as 200113 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: 20507 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3007Q-040 [Floor Beam (FB) X3490A to Edge Plate (EP) 3016A, CJP weld at PP118]. The welder is identified as 066236 and was observed welding in 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13AE:

ZPMC personnel performing Ultrasonic Testing (UT) on weld joint no: Seg3013AA-118 (DP to EP, CJP weld). Approximately 40 locations are identified on this weld for repair.

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

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Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer