

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-022262**Date Inspected:** 31-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 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013C-204 [Stiffener X4503A on Floor Beam (FB) 3202A to Edge Panel (EP) 3020E, complete joint penetration (CJP) weld at panel point (PP) 120]. The welder is identified as 067764 and was observed welding in 4G position. ZPMC Quality Control (QC) was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2214-Tc-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013E-039 (FB3197A to RS Stiffener RS3464, CJP weld at PP119.65). The welder is identified as 048433 and was observed welding in 3G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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The SMAW process on weld joint no: Seg301Q-086 [Stiffener X4503K on FB3178A to Edge Panel (EP) 3020A, CJP weld at PP118]. The welder is identified as 069683 and was observed welding in 4G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

Repair welding of weld joint no: Seg3013AD-035 [Side Panel (SP) to FB3202A, CJP weld at PP120]. The welder is identified as 070432 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): 20534 Rev-0.

OBG Seg 13AE:

This QA Inspector observed ZPMC personnel performing fit-up checking of Architectural Housing with Side Panel of the Segment. See attached photo for details.

Grillage on Seg 13AW:

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) of the welds on the Grillage Assembly.

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.

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Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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