

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-022507**Date Inspected:** 08-Apr-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 Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013F-100 [RS stiffener to Floor Beam (FB) 3191A, complete joint penetration (CJP) weld, at panel point (PP) 119+1500]. The welder is identified as 203871 and was observed welding in 3G 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-T-2233-ESAB.

Repair welding of weld joint no: Seg3013AD-067 [X4394B stiffener on FB3193A to Side panel (SP) 3092E, CJP weld at PP119+1500]. The welder is identified as 067572 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair

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welding was done as per Welding Repair Report (WRR): 20573 Rev-0.

The SMAW process on weld joint no: Seg3013AH-001 (FB3176A to I-rib stiffener, CJP weld at PP118). The welder is identified as 070432 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-T-4212-B-U2-2.

Repair welding of weld joint no: Seg3013AD-104 (X4114C stiffener to SP3091C, CJP weld at PP119-1500). The welder is identified as 069683 and was observed welding in the 4G 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-4G(4F)-FCM-Repair. Repair welding was done as per WRR: 20525 Rev-0.

The SMAW process on weld joint no: Seg3013-004 (SA7510A to DP3124A, CJP weld). The welder is identified as 067764 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-B-U2-FCM-1.

ZPMC personnel performing fit-up of Architectural Housing (AH) 3001A with Side Panel (SP) 3102A. See attached photo for further details.

Notification no: 008766.

OBG Seg 13AW (Grillage Assembly):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

1) SA7512-057 to 060 and 063 to 066.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable Contract documents.



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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
