

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022584**Date Inspected:** 14-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) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. TU DONG PING**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 Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Bay-10:

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the bike path weld joint located on BK014A6. The weld is designated as BK014A6-001-150. The welder is identified as 040365. ZPMC QC Mr. TANG TIHENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2114. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the bike path weld joint located on BK014A8. The weld is designated as BK014A8-001-003. The welder is identified as 500363. ZPMC QC Mr. TANG TIHENG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2113.

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ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as traveler rail located on 31TR2-001-021. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. TANG TIHENG was present to monitor the heat straightening process. The heat straightening appears to comply with Heat Straightening Report number is HSRI (B)-10292.

Orthotropic Box Girder (OBG) at Bay-11:

ZPMC welding personnel performing Shielded Metal Arc Welding of Partial Joint Penetration welds joining the tower shaft weld joint located on LIFT-6. The weld is designated as ESD1-FGSA6-2-29. The welder is identified as 057220. ZPMC QC Mr. MAO BIN BIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2313-TC-P4. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Partial Joint Penetration welds joining the tower shaft weld joint located on LIFT-6. The weld is designated as ESD1-FGSA6-2-27. The welder is identified as 040582. ZPMC QC Mr. MAO BIN BIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2313-TC-P4.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the tower shaft weld joint located on LIFT-6. The weld is designated as ESD1-TBSA7-5-007. The welder is identified as 041713. ZPMC QC Mr. MAO BIN BIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112.

ZPMC welding personnel performing Shielded Metal Arc Welding of Fillet welds joining the tower shaft weld joint located on LIFT-6. The weld is designated as ESD1-TBSA7-5-031. The welder is identified as 046704. ZPMC QC Mr. MAO BIN BIN was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-B-P-2112.

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 relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
