

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-022860**Date Inspected:** 21-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:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: EP3023-013-033 [Edge Panel (EP) 3023A to 560mm EP, complete joint penetration (CJP) weld, at Panel Point (PP) 117.5]. The welder is identified as 048696 and was observed welding in 3G position. ZPMC Quality Control (QC) was identified as Zhou Peng. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-T-2233-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013-001 [560mm EP to Deck Panel (DP) SA7510A, CJP weld, at PP117.5]. The welder is identified as 070432 and was observed welding in 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

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Repair welding of weld joint nos: Seg3013K-048 [Floor Beam (FB) 3184A to X4411C I-rib stiffener on Side Panel (SP) 3102A, CJP weld at PP 119-1500]. The welder is identified as 020578 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Li. 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): 20578 Rev-1.

Repair welding of weld joint nos: Seg3013E-125 [RS stiffener (RS3428E) on SP3090E to FB3198E, CJP weld at PP 119.65]. The welder is identified as 067904 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Shi Li. 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: 20604 Rev-1.

The SMAW process on weld joint no: FB3178-001-167 (X4220D stiffener to X4219A plate, CJP weld at PP118). The welder is identified as 067609 and was observed welding in 2G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

OBG Seg 13BW:

The SMAW process on weld joint no: Seg3014B-012 (X4498B FB diaphragm to X4498F FB flange, CJP weld at PP122). The welder is identified as 066326 and was observed welding in 2G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-TC-U4b-FCM-1.

OBG Seg 13CW:

The SMAW process on weld joint no: Seg3015H-207 [I-rib stiffener on Bottom Panel (BP) 3069A to FB3224A, CJP weld at PP120.5]. The welder is identified as 066326 and was observed welding in 3G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-TC-U4b-FCM-1.

Grillage assembly on Seg 13AW:

ZPMC personnel performing Magnetic Particle Testing (MT) after completion of repair welding. Linear indications were again observed after MT was done. These were identified for repair welding. This QA Inspector informed ZPMC QC, identified as Sun Tian Liang to submit revised Critical Welding Repair Report (CWR) before performing repair welding. See attached photo for further details.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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