

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-022863**Date Inspected:** 22-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 Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013D-144 [RS stiffener (RS3441A) to X4213A Web Plate, complete joint penetration (CJP) weld, at panel Point (PP) 119.65]. The welder is identified as 047864 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.

Repair welding of weld joint nos: Seg3013H-053 [X4411A Web Plate to RS stiffener (RS3441C) on Side Panel (SP) 3102A, CJP weld at PP119]. The welder is identified as 048696 and was observed welding in the 3G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-3G(3F)-FCM-Repair.

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Repair welding was done as per Welding Repair Report (WRR): 20577 Rev-0.

Repair welding of weld joint nos: Seg3013N-226 [RS stiffener on SP3090B to Floor Beam (FB) 3183A, CJP weld at PP118.35]. The welder is identified as 066179 and was observed welding in the 3G 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-3G(3F)-FCM-Repair. Repair welding was done as per WRR: 20693 Rev-0.

The FCAW process on weld joint no: Seg3013P-134 [RS stiffener (RS3432D) to X4369A Web Plate on SP3102A, CJP weld at PP118). The welder is identified as 048696 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.

OBG Seg 13CW:

The SMAW process on weld joint nos: Seg3015K-266 and 267 [I-rib stiffener (X4450H) to stiffener X4450D and I-rib stiffener (X3859B) to stiffener X4450D, respective CJP welds at PP122.5]. The welder is identified as 067588 and was observed welding in 2G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-B-U2-FCM-1.

The SMAW process on weld joint no: Seg3015K-268 (stiffener X4450D to FB3220A, CJP weld at PP122.5). The welder is identified as 067588 and was observed welding in 2G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

Repair welding of weld joint nos: DP3148-001-249 [FB diaphragm (X4090D) to FB diaphragm X4090F, CJP weld at PP123.5]. The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per Critical Welding repair report (CWR): 2931 Rev-0.

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.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

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Reviewed By: Peterson, Art

QA Reviewer