

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-022866**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:** An Qing Xiang**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad 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 observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 14

OBG Seg 14W:

Repair welding of weld joint no: SEG3020AG-002 [Edge Plate (EP) to Deck plate 3491A of Deck Panel (DP) 3083A, Complete Joint Penetration (CJP) weld in between panel point (PP) 125 to PP126]. The welder is identified as 066361 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20784 Rev-0.

The SMAW process on weld joint no: SEG3020V-022/023 [Stiffener on Side Plate (SP) to Floor Beam (FB), CJP weld at Panel Point (PP) 125]. The welder is identified as 045246 and was observed welding in 4F position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS:

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B-P-2114-FCM-1.

The Submerged Arc Welding (SAW) process on weld joint no: SEG3020*-011 [DP 3177A to DP 3183A, CJP weld]. The welder is identified as 045270 and was observed welding in 1G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-223(2)1T-ESAB-1.

The SMAW process on weld joint no: SEG3020BB-066 [Vertical Shear Plate extension plate to top Anchorage Plate (AP), CJP weld at Panel Point (PP) 126]. The welder is identified as 066261 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020BB-012 [Vertical Shear Plate extension plate to top AP, CJP weld at Panel Point (PP) 126]. The welder is identified as 037748 and was observed welding in 4G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020V-024 [FB diaphragm to top AP, CJP weld at PP125]. The welder is identified as 067949 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020L-028 [DP diaphragm of DP 3172A to Floor Beam (FB) 3327A, CJP weld at PP127]. The welder is identified as 066421 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020K-002 [DP diaphragm of DP 3172A to FB sub assembly SA 3409A, CJP weld at PP127.3]. The welder is identified as 066881 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020L-014 [DP diaphragm of DP 3168A to DP diaphragm of DP 3169A, CJP weld at PP127]. The welder is identified as 066239 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020W-009 [DP diaphragm of DP 3175A to DP diaphragm of DP 3176A, CJP weld at PP125]. The welder is identified as 045280 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Bike Path Cantilever Brackets Box

The FCAW process on weld joint no: BK16-001-003. The welder is identified as 040302 and was observed

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welding in 3G position. ZPMC QC was identified as Mr. Wang Li Yang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: BK17-001-019. The welder is identified as 040458 and was observed welding in 3G position. ZPMC QC was identified as Mr. Wang Li Yang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG U-rib Splice Plate Lift 12-13

The FCAW process on weld joint no: X3305K-002-001/002. The welder is identified as 201215 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: X3305K-004-001/002. The welder is identified as 067275 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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