

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-022973**Date Inspected:** 25-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:** Li Yan Hua**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:

During random in process visual inspection this QA Inspector observed that ZPMC personnel were performing preparation for the shifting of OBG segment 14W from bay 14 to OBG Trial Assembly Yard. Because of safety reason there were no welding related work activities was noted inside segment 14W. Attached photograph provide additional details.

OBG U-rib Splice Plate Lift 12-13

The Flux Cored Arc Welding (FCAW) process on weld joint no: X3305K-013-001/002. The welder is identified as 067949 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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The FCAW process on weld joint no: X3305K-022-001/002. The welder is identified as 067275 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: X3305K-020-001/002. The welder is identified as 067103 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

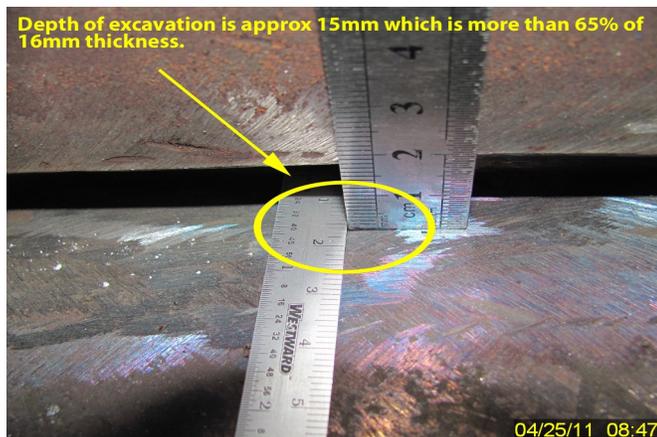
The FCAW process on weld joint no: X3305K-025-001/002. The welder is identified as 066239 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: X3305K-021-001/002. The welder is identified as 045175 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhang Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB. Attached photograph provide additional details.

OBG Traveler Rail

During random in process visual inspection this QA Inspector observed that ZPMC personnel performing repair welding on the weld joint TR3027TR2-001-011 of traveler rail TR3027. The welders were identified as 045246 and 066361 and were observed welding in 2G position. During inspection burn through was observed at one location and depth of repair excavations were noted more than 65% of thickness at five locations. This was not in compliance with Welding Repair Report (WRR) B-WR 20755. This issue was discussed with ZPMC CWI Mr. Li Yan Hua and after discussion Mr. Li Yan Hua stopped the repair welding operation and informed this QA Inspector that ZPMC will prepare Critical Welding Repair (CWR) report for this weld joint. Attached photograph provide additional 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:

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

Reviewed By: Peterson,Art

QA Reviewer