

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-023114**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:** 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 13BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3014B-145 [Floor Beam (FB) Flange (X4453B) to Vertical Plate (VP) 3012A, complete joint penetration (CJP) weld, at Panel Point (PP) 122]. The welder is identified as 045213 and was observed welding in 3G 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-2213-Tc-U4b-FCM-1.

OBG Seg 13AW:

Repair welding of weld joint no: DP3133A-001-020 [Deck Panel (DP) diaphragm (X4079H) to DP diaphragm (X4126B) CJP splice weld, at PP120.5]. The welder is identified as 045196 and was observed welding in the 3G

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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-1. Repair welding was done as per Critical Welding Repair Report (CWR): 2932 Rev-0.

The SMAW process on weld joint no: Seg3014H-159 [VP3012A to Web Plate X4512A, CJP weld at PP120.5]. The welder is identified as 067588 and was observed welding in 3G position. ZPMC QC was identified as Sun Tian Liang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3014B-257 [Web Plate X4425D to FB3217A, CJP weld at PP122]. The welder is identified as 045213 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.

Notification no: 008917.

OBG Seg 13AE:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) Seg3011A-001.
- 2) Seg3009M-001.

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
Reviewed By:	Peterson,Art	QA Reviewer
