

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-023265**Date Inspected:** 05-May-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 13AE and Seg 13BE:

The Submerged Arc Welding (SAW) process on weld joint no: OBE13-002 [Deck Panel (DP) to DP, complete joint penetration (CJP) splice weld]. The welder is identified as 207288 and was observed welding in 1G position. ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBE13B-001 [Bottom Panel (BP) to BP, CJP splice weld]. The welder is identified as 066746 and was observed welding in 1G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2231-ESAB.

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The FCAW process on weld joint no: OBE13E-003 [Side Panel (SP) to SP, CJP splice weld]. The welder is identified as 066041 and was observed welding in 3G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

OBG Seg 13AW and Seg 13BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW13B-003 [Bottom Panel (BP) to BP, CJP splice weld]. The welder is identified as 066421 and was observed welding in 1G position. ZPMC QC was identified as Shen Jian Bo. The welding variables recorded by this QC appeared to comply with WPS: B-T-2231T-ESAB-1.

OBG Seg 13CW:

ZPMC personnel performing fit-up of X4074 Flange plate with I-ribs on Bottom Panel [at Panel Point (PP) 123 - PP123.5]. See attached photo for details.

OBG Seg 14W:

Repair welding of weld joint no: Seg3020U-571 [Top Anchorage Plate (AP) to Anchor Plate, CJP weld at 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 An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): 2943 Rev-0.

The SMAW process on weld joint no: Seg3020T-100 [I-rib stiffener to Floor Beam (FB), CJP weld at PP125.5]. The welder is identified as 066479 and was observed welding in 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

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
Reviewed By:	Peterson,Art	QA Reviewer
