

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-023492**Date Inspected:** 09-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:** 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:

TA YARD

OBG Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AH-002 [Side Panel (SP) 3144B to Edge Panel (EP) 3029A, Complete Joint Penetration (CJP) weld at panel point (PP) 125 to PP 127]. The welder is identified as 037932 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020P-107 [WT stiffener on Top anchorage plate (AP) 3020A to Floor Beam (FB) 3319A, CJP weld at PP126]. The welder is identified as 066261 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

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The SMAW process on weld joint no: SEG3020S-132 and 134 [I-rib stiffener on Top AP 3017A to Floor Beam (FB) 3318C, CJP weld at PP125.5]. The welder is identified as 066479 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-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020S-120 [I-rib stiffener on SP 3131A to FB diaphragm plate X8533E, Fillet weld at PP125.5]. 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: B-P-2114-FCM-1.

The SMAW process on weld joint no: SEG3020V-105 and 106 [I-rib stiffener on Top AP 3017A to FB 3318A, CJP weld at PP125]. The welder is identified as 066825 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-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020BB-039 [Vertical shear plate extension plate of SA3447A to Anchor Plate (AP) 3032A, CJP weld at PP126]. The welder is identified as 066361 and was observed welding in 4G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-FCM-1.

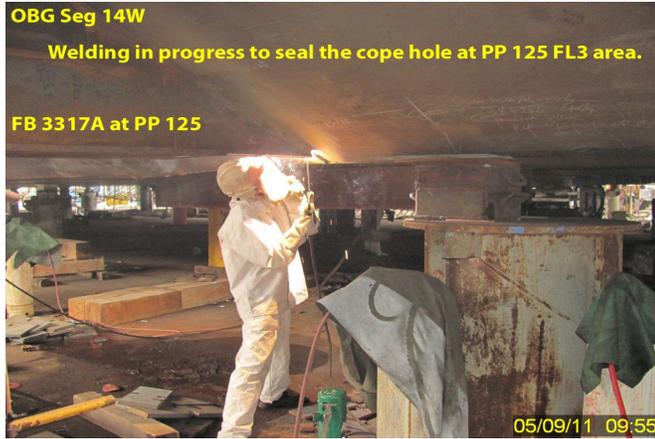
During random in process visual inspection this QA Inspector performed verification of weld joints (joining EB 3053A and EB 3051B to FB 3271A, FB 3274A and FB 3280A respectively at PP 127 to PP 128 of segment 14E) according to weld map, approved drawings and weld details provided by CT Lead QA. The related information regarding these weld joints has been submitted to CT lead QA.

During random in process visual inspection this QA Inspector observed that ZPMC personnel seal welded the cope hole at the intersection of SP to BP at PP 125, PP 126 and PP 127 FL3 area of segment 14W. This issue was discussed with ZPMC CWI Mr. Sha Jie and the CT Lead QA. ZPMC CWI Mr. Sha Jie informed this QA Inspector that he will discuss this issue with ZPMC's Technical Engineer and will inform CT for clarification of the non-conforming issue. See attached photographs for further 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
