

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-023512**Date Inspected:** 20-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:** Geng Wei**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 Structure**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manuel Teall 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:

The Submerged Arc Welding (SAW) process on weld joint no: SEG3020*-008 [DP 3174A to DP 3175A, 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 Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020S-054 [DP diaphragm X4814C of DP 3172A to DP diaphragm X4814B of DP 3173A, CJP weld at PP125.5]. The welder is identified as 066881 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The FCAW process on weld joint no: SEG3020T-318 [DP diaphragm X4814B of DP 3173A to DP diaphragm X4814A of DP 3174A, CJP weld at PP125.5]. 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.

The FCAW process on weld joint no: SEG3020L-031 [DP diaphragm X4817G of DP 3172A to DP diaphragm X4858B of DP 3173A, CJP weld at PP127]. The welder is identified as 067888 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

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant 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 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
