

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-023630**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:** 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:

OGB Seg 13AE and Seg 13BE:

ABF personnel performing Magnetic Particle Testing (MT) after removal of temporary attachments at weld jt no: OBE13-002 [Deck Panel (DP) to DP complete joint penetration (CJP) splice weld. See attached photo for details.

OGB Seg 13AW and Seg 13BW:

ZPMC personnel performing fit-up of Side Panel (SP) to SP; (North side). Photo attached for details.

OGB Seg 14W:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3020AH-002 [Side Panel (SP) 3144B to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Edge Panel (EP) 3029A, CJP weld at Panel Point (PP) 125 to PP127]. The welder is identified as 037932 and was observed welding in 2G position. ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): B-P-2212-Tc-U4b-FCM-1.

The SMAW process on weld joint no: Seg3020S-132 and 134 [I-rib stiffener on Top Anchorage Plate (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 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 An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-Tc-U4b-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 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.



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer