

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-023636**Date Inspected:** 15-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 13AW:

ZPMC personnel performing drilling of 24mm dia holes on Architectural WT splice sub-assembly (X3869A) with Side Panel (SP) 3102A and Architectural Housing (AH) 3001A. See attached photo for details.

OBG Seg 13CE and Seg 14E:

ZPMC personnel performing fit-up of Deck Panel (DP) to DP splice joint (for Seg 13CE and Seg 14E). Photo attached for details.

OBG Seg 13AE and Cross Beam 18 (CB18):

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ZPMC personnel performing match drilling of 27mm dia holes of X3727A splice plate with DP of Seg 13AE and CB18. Photo attached for details.

OBG Seg 13AE:

Repair welding of weld joint no: DP3078-001-244 [DP to Longitudinal Diaphragm (LD), complete joint penetration (CJP) weld at Panel Point (PP) 120]. The welder is identified as 044772 and was observed welding in the 4G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by this QC appeared to comply with welding procedure specification (WPS): 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): 20982 Rev-0.

OBG Seg 14W:

Repair welding of weld joint no: LD3020X-007 [LD to Anchor Plate (AP), CJP weld at PP126.5 to 127]. The welder is identified as 045196 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per WRR: 20845 Rev-0.

The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3020P-139 [I-rib stiffener to Floor Beam at CJP weld at PP126]. The welder is identified as 045175 and was observed welding in 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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