

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-024090**Date Inspected:** 23-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 Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020U-584/586 [Complete Joint Penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 067949 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-2231-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020M-073/074 [CJP weld at PP127]. The welder is identified as 066459 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding of weld joint no: SEG3020AG-022[CJP weld at PP126]. The welder is identified as 050038 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. 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 Welding Repair Report (WRR): B-WR 21007 Rev-0.

Repair welding of weld joint no: SEG3020W-108/109[CJP weld at PP 125]. The welder is identified as 066261 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-CWR 20995 Rev-0.

The SMAW process on weld joint no: SEG3020P-114 [CJP weld at PP 126.5]. The welder is identified as 067572 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-B-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020M-068/069 [CJP weld at PP 126.5]. The welder is identified as 040655 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-B-U4b-FCM-1.

OBG Seg 14W:

This QA Inspector, along with Mr. Shailesh Wadkar; performed in process Visual Inspection of welds (Segment 14W) at Panel Points (PP) 126 to PP 127. Visual Inspection was performed on the welds between Longitudinal Diaphragm (LD) 3050A to LD 3051A (on the welds inside of the Segment). At two locations stiffener on LD to FB welds, this QA Inspector observed to have toe cracks. Details are as follows:

SEG3020AB-060, 081

This QA Inspector informed to ZPMC CWI, identified as Mr. An Qing Xiang. The weld locations were documented and forwarded to the CT Lead QA Inspector for further disposition. See attached photo for details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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