

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-024483**Date Inspected:** 01-Jun-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 Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 058245 perform repair welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam weld at panel point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020D-038. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Critical welding repair report B-CWR2997. See attached pictures.

This QA Inspector observed ZPMC qualified welding personnel identified as 066675 perform repair welding by Shielded Metal Arc Welding (SMAW), on Sub Assembly part SA3416C to Floor beam weld at panel point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020AV-011. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-1G-FCM-Repair-1, which is used as per Welding repair report B-WR21133.

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This QA Inspector observed ZPMC qualified welding personnel identified as 067572 perform repair welding by Shielded Metal Arc Welding (SMAW), on Sub Assembly part SA3416A to Floor beam weld at panel point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020AV-006. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-1G-FCM-Repair-1, which is used as per Welding repair report B-WR21133.

This QA Inspector observed ZPMC qualified welding personnel identified as 066459 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam diaphragm to Sub Assembly part SA3416C weld at panel point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020E-027. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068924 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam diaphragm weld at panel point 128.3 of OBG Segment 14W. Weld joint is identified as SEG3020D-317. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1, which is used as per Welding repair report B-WR21178.

This QA Inspector observed ZPMC qualified welding personnel identified as 067610 perform welding by Shielded Metal Arc Welding (SMAW), on Floor Beam I Rib stiffener to Floor Beam weld of OBG Segment 14W. Weld joint is identified as FB3336-001-050, 057. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068493 perform welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib stiffener to Floor beam weld at panel point 126.5 of OBG Segment 14W. Weld joint is identified as SEG3020N-166, 168. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067036 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate I Rib stiffener to Vertical Anchor plate weld of OBG Segment 14W. Weld joint is identified as SEG3020U-574. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 perform repair welding by Shielded Metal Arc Welding (SMAW), on Side plate I Rib stiffener to Floor beam weld at panel point 127.5 of OBG Segment 14W. Weld joint is identified as SEG3020AZ-091, 096. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1, which is used as per

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Welding repair report B-WR21153.

This QA Inspector observed ZPMC qualified welding personnel identified as 045175 perform welding by Flux Cored Arc Welding (FCAW), on Bottom plate I Rib stiffener to Floor beam weld at panel point 127.5 of OBG Segment 14W. Weld joint is identified as SEG3020J-066, 071. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

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.

Inspected By: Upadhye, Anand

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer