

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-024882**Date Inspected:** 12-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**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:

OBG TA YARD**14 WEST**

This QA Inspector observed ZPMC qualified welding personnel identified as 066734, 067103 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld of OBG Segment 14W. Weld joint is identified as SEG3020E-001. 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-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 040611, 040610 perform welding by Shielded Metal Arc Welding (SMAW), on Sub Assembly part SA3412B to Sub Assembly part SA3416C weld of OBG Segment 14W. Weld joint is identified as SEG3020E-063. 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-2211-Tc U4b-FCM-1.

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This QA Inspector observed ZPMC qualified welding personnel identified as 066156 perform repair welding by Shielded Metal Arc Welding (SMAW), on Anchor plate T Rib stiffener to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020N-162. 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 welding repair report B-WR21173.

This QA Inspector observed ZPMC qualified welding personnel identified as 067520 perform repair welding by Shielded Metal Arc Welding (SMAW), on Anchor plate I Rib stiffener to Floor beam weld of OBG Segment 14W. Weld joint is identified as SEG3020N-166. 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 welding repair report B-WR21173.

14 EAST

This QA Inspector observed ZPMC qualified welding personnel identified as 044779 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019H-197. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 044779 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019H-194. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2213-B-U2-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037723 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as SEG3019AW-178, 179. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2211-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 501946 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as OBE14A-013. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 216086 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 14 East. Joint identified as OBE14A-014. ZPMC QC Identified as Zhu Yuan Yuan. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2114-FCM-1.

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

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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
