

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-024887**Date Inspected:** 15-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 066675 perform welding by Shielded Metal Arc Welding (SMAW), on longitudinal diaphragm stiffener weld of OBG Segment 14W. Weld joint is identified as SEG3020Z-001, 002. 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 068097 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to longitudinal diaphragm weld of OBG Segment 14W. Weld joint is identified as SEG3020T-311. 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 066258 perform welding by Shielded Metal Arc Welding (SMAW), on longitudinal diaphragm stiffener weld of OBG Segment 14W. Weld joint is identified as SEG3020X-082. 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.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate I Rib stiffener to I Rib stiffener weld of OBG Segment 14W. Weld joint is identified as SEG3020AY-194. 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-2213-B-U2-FCM-1.

BAY 14, Segment 13 West Connection Brackets

This QA Inspector observed ZPMC qualified welding personnel identified as 037997 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137P-004-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137P-004-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 070140 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SA3137C-002-007 ; located On Orthotropic Box Girder (OBG) Splice Connection Plate Fillet Weld; ZPMC Quality Control (QC) is identified as Mr. Hu Mei Gang. This QA Inspector observed the base material appears to have been preheated by an electrical heating element prior to welding. ZPMC Quality Control (QC) Mr. Hu Mei Gang was onsite monitoring the welding variables. The welding variables recorded by QC appeared to comply with applicable WPS-B-P-2112-FCM-1.

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

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

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your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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