

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012147**Date Inspected:** 16-Feb-2010**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:	NA	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 Inspector (QA) 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 observed and/or found the following:

Blast Shop 1:

This QA Inspector performed random visual inspection after grit blasting of OBG SEG 8CE. Inspection was done for U-Ribs, Floor Beam Flange, internal surfaces of Corner Assembly, Deck Panel & Deck Panel Diaphragm, between PP 70 & PP71. Areas requiring additional grinding were marked by this QA and were repaired by ZPMC personnel.

Outside Yard:**SEG 9BW:**

- This QA inspector performed in process Visual Inspection of the 50mm radii at the bottom end of Floor Beam Flange of X7 Flange Plate at PP74, PP75 & PP76.
- This QA observed that at least at two locations / Flange Plates, this 50mm radius, do not appear to comply with the Contract document & needs weld repair / rectification.
- These locations are identified as:

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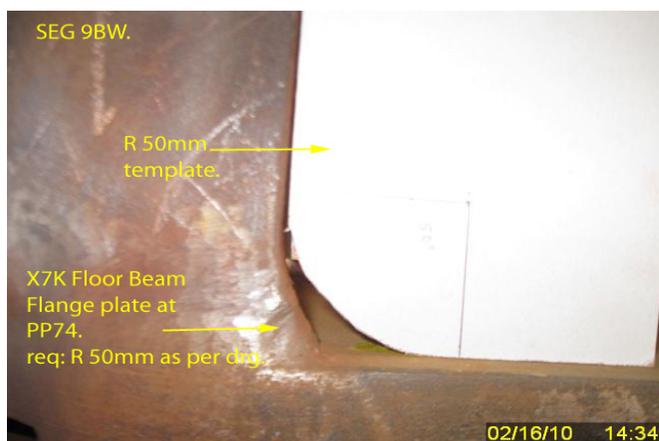
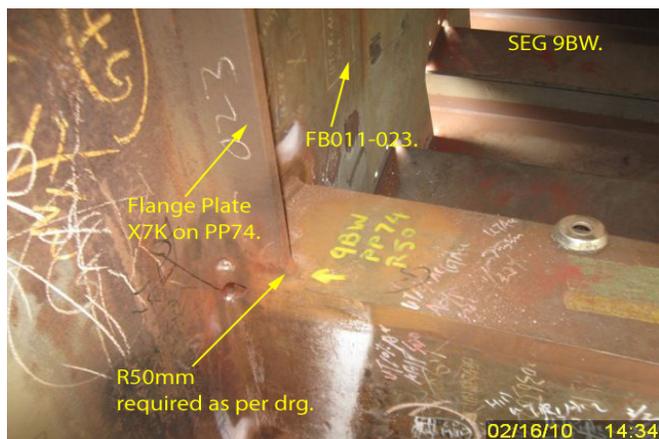
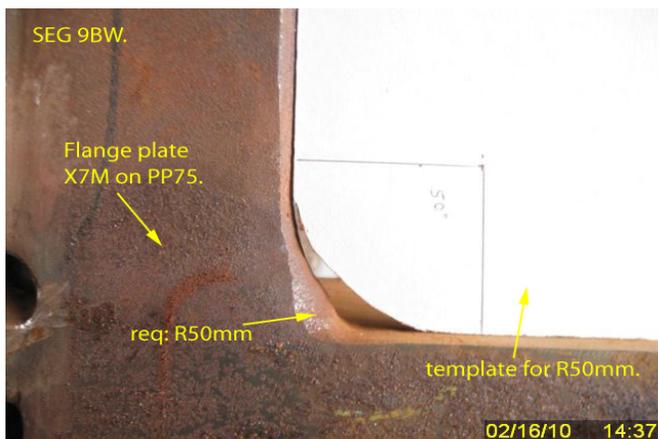
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- 1) Flange Plate X7K on PP74, Floor Beam – FB011-023 &
 - 2) Flange Plate X7M on PP75, Floor Beam – FB023-006.
- For details, refer attached photos.

SEG 9CW:

- This QA inspector performed in process Visual Inspection of the 50mm radii at the bottom end of Floor Beam Flange of X7 Flange Plate at PP77, PP78 & PP79.
- This QA observed that these 50mm radii on PP77, PP78 & PP79, appeared to comply with the contract documents.

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

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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:	Hall,Steven	QA Reviewer
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