

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013029**Date Inspected:** 12-Apr-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:** Chen Xi**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:

Bay 1: CB15:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8:

This QA Inspector observed the following work in progress for CB17:

Flux Cored Arc Welding (FCAW) of weld joint CB3001G-055 – 073/074 & 140/158. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133 & WPS-B-T-2132 respectively.

FCAW of weld joint CB3001G-056 – 071/072, 093 to 110. Welder is identified as 500479. ZPMC Quality Control (QC) is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

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FCAW of weld joint CB3001G-053 – 144/162. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

FCAW of weld joint CB3001G-054 – 093 to 110. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Sun Yan Fei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

Outside Yard:

CB10:

This QA Inspector observed the following work in progress:
ZPMC personnel doing grinding of weld profiles of the welds of this CB. ZPMC QC was identified as Mr. Chen Xi & ABF QA was identified as Cao Hui Zhao. This QA Inspector did random visual inspection of the welds after grinding. This QA Inspector observed that some of the cope holes do not comply with the contract documents and had marked such locations in question to the Contractors QC to inspect and evaluate. Refer attached photos for reference.

CB8:

Notification No: 005512 (for punch list item 395).

This QA inspector performed Magnetic Particle Testing (MT) of base metal repaired area on side panel and bottom panel (identified as Seismic Performance Critical Member – SPCM material) of CB8. The areas being repaired were damaged while removing temporary lifting lugs. The affected panels are identified as side panel SP202A & bottom panel BP204A. This repaired area is 100% MT tested by ZPMC Quality Control (QC) personnel. Refer attached photos for details.

CB9, CB11, CB12, CB13, CB14 & CB16:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

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; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer