

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-013322**Date Inspected:** 19-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:** Guo Yan Fei.**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 5:

This QA Inspector observed the following work in progress:

Repair welding of OBG component – Traveler Rail 11TR2-001-014. Welder is identified as 204342. Welding process is identified as Flux Cored Arc Welding (FCAW). ZPMC Quality Control (QC) is identified as Shen Jian Guo. The repair was carried out as per Welding Repair Report (WRR) no: B-WR-11739 R-0 (& UT report no: B787-UT-12186). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1.

Bay 6:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of OBG component – West Jacking Frame; weld joint nos: WJF-0 – 094, 152 & 153. Welders are identified as 049769 & 066261. ZPMC Quality Control (QC) is identified as Zhao Jian

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Hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3313-TC-P5.

SMAW of OBG component – West Jacking Frame; weld joint nos: WJF-0-318. Welder is identified as 048800. ZPMC Quality Control (QC) is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-3312-TC-P4.

Bay 7:

This QA Inspector observed the following work in progress:

Repair welding of OBG component – Traveler Rail 10TR3-004 – 014. Welder is identified as 051246. Welding process is identified as FCAW. ZPMC Quality Control (QC) is identified as Cui Jun Jie. The repair was carried out as per WRR: B-WR-12053 R-0 (& UT report no: UT-11793 R-1). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G (2F)-Repair-1.

Repair welding of OBG component – Traveler Rail 10TR1-005–014. Welder is identified as 051246. Welding process is identified as FCAW. ZPMC Quality Control (QC) is identified as Cui Jun Jie. The repair was carried out as per WRR: B-WR-12048 R-0 (& UT report no: UT-10798 R-1). The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-Repair-1.

Bay 8:

This QA Inspector observed the following work in progress:

FCAW of OBG component – Bike Path; weld joint nos: BK004A7-058 – 033/034 & 170/171. Welder is identified as 040785. 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-2132.

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; 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
