

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-014182**Date Inspected:** 21-May-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:** Li Jia.**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: CB17:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB3001G-053-001 to 020. Welder is identified as 040671. ZPMC Quality Control (QC) is identified as Yuan Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

Outside Yard:

CB11, CB12, CB13, CB14 & CB16:

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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.

Trial Assembly:

CB7, CB9, CB10:

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

CB8:

Notification No: 005791 (for punch list item no: 391).

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. MT was done on welds of two (2) corner diaphragm assemblies on floor beam CB202G-017 where earlier heat straightening was done to correct the 10mm out of squareness of this CB. The weld designations MT tested are as follows:

- 1) CB202G-017-180/181, 182/183, 147/165, 148/166.
- 2) FB204-017-061/062.
- 3) FB205-017-033/034.

Bay 6:

Notification No: 005785.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components: Traveler Brackets. The weld designations reviewed are as follows:

- 1) TR5B-PP71-003.
- 2) TR5B-PP61-003.
- 3) TR5D-PP69-008.
- 4) TR5D-PP63-008.
- 5) TR6C-PP64-006.
- 6) TR6B-PP66-004.
- 7) TR6A-PP48-001.
- 8) TR5C-PP65-006.
- 9) TR5C-PP67-006.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG components: Traveler Brackets. The weld designations reviewed are as follows:

- 1) TR5B-PP71-003.
- 2) TR5B-PP61-003.

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3) TR6A-PP48-001.

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
