

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014184**Date Inspected:** 06-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:** 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: CB17:

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

Outside Yard:

CB10:

This QA Inspector observed this CB being shifted to Trial Assembly. No other significant work was performed on this CB at the time when this QA was present.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

CB14:

During random inprocess visual inspection of this Cross Beam, this QA Inspector observed ZPMC personnel performing repair welding at various locations of the fillet welds joining the Floor beam to the Side panel. Welder was identified as 048047. Welding process was identified as SMAW, WPS-345-3G(3F)-repair-1. ZPMC QC personnel was identified as Chen Xi.

CB11, CB12 & 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.

CB13:

Repair welding of weld joint nos: CB202A-013 – 014. Welder was identified as 051324. Welding process was identified as SMAW. ZPMC Quality Control (QC) is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-repair (welding repair report (WRR) no: B-WR12522 Rev-0 Dt: 04/27/10).

Trial Assembly:

CB7:

This QA Inspector observed ZPMC personnel performing gas cutting of weld joint no: CB202A-007-016 (hold back weld). Cutting of this weld is done to adjust the misalignment (hi-lo) of the bottom panel of CB7 with the bottom panel of the FL3 of SEG 7BE. This misalignment was observed as 4mm. However, after the cutting of this weld, root opening was measured and was observed as 14mm. This QA Inspector discussed this with ZPMC CWI, identified as Wu Zhi Cheng. ZPMC QC informed that they will submit CWR before this joint is re-welded. Refer attached photos for reference.

CB8 & CB 9:

This QA Inspector observed that no significant work was being performed on this CB 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

For CB7, this QA Inspector discussed with ZPMC CWI, identified as Wu Zhi Cheng, to submit CWR for weld joint no: CB202A-007-016 (hold back weld), before it is rewelded.

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