

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-014301**Date Inspected:** 16-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:	Liming Yang.	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:

During random inprocess inspection of this CB, this QA Inspector observed the following fillet weld joint root opening did not appear to comply with the Contract documents. Root openings were in excess of 5mm:

- 1) CB3001G-053-051, 047 : 6mm
- 2) CB3001G-053-053, 055 : 8mm
- 3) CB3001G-053-057, 059, 061 : 11mm
- 4) CB3001G-054-045, 051 : 8mm
- 5) CB3001G-054-053, 059 : 6mm
- 6) CB3001G-054-061 : 11mm

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

- 7) CB3001G-055-045 : 9mm
- 8) CB3001G-055-061 : 7mm
- 9) CB3001G-056-061 : 8mm
- 10) CB3001G-056-045, 047 : 9mm
- 11) CB3001G-056-051 : 10mm.

Outside Yard:

CB11, CB12, 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.

CB13:

This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: CB202A-013-014. Welder was identified as 037932. Welding process was identified as Shielded Metal Arc welding (SMAW). ZPMC QC is identified as Wang Liang. 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-WR12931Rev-0, Dt:05/01/10, UT report no: B787-UT-12590R1.

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:

This QA Inspector observed the following work in progress:

SMAW of weld joints SSD25-PP63-149/150. Welder is identified as 067079. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------	-------------