

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-014302**Date Inspected:** 18-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:

CB11, CB12, CB13 & 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.

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CB14:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC personnel heat straightening the Bottom Panel; distorted due to welding. As per ZPMC Heat Straightening Record (HSR) No: HSR1(B)-8472 Rev-0, Dt: 05/12/10, the straightening of this bottom panel is to be done only by using oxy-acetylene torch.

However, it was observed that ZPMC personnel straightening the material using heat as well as a hand operated winch (come-along) attached to a weight placed under the crossbeam. The use of the come-along and weight or any other mechanical force is not mentioned in the HSR. Besides this, the deviation was mentioned in ZPMC HSR as 6mm. However, the deviation from flat as measured by this QA was observed as 16mm per 1000mm. Bottom Panel of Cross Beam is identified as Seismic Performance Critical Members (SPCM). This QA Inspector discussed this issue with ZPMC QC, identified as Mr. Wang Liang; that they did not appear to follow their heat straightening record and an incident report would be raised. ABF QA was identified as Mr. Yang Yu. Refer attached photos for reference.

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-PP63-103 & 104. Welder is identified as 066459. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-TC-U4b-F.

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