

**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-014429**Date Inspected:** 26-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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 joint no CB3001G-056-021 to 038. Welder is identified as 054459. ZPMC Quality Control (QC) is identified as Liu Cheng Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233.

FCAW of weld joint no CB3001G-054-021 to 038. Welder is identified as 054460. ZPMC QC is identified as Liu Cheng Guang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2233.

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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.

CB14:

This QA Inspector observed the following work in progress:

Repair welding of weld joint nos: FB205-044-035. Welder was identified as 055564. Welding process was identified as FCAW. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G(1F)-repair [welding repair report (WRR) no: B-WR13059 Rev-0].

Repair welding of weld joint nos: FB205-043-036. Welder was identified as 055564. Welding process was identified as FCAW. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-3G(3F)-repair [welding repair report (WRR) no: B-WR13053 Rev-0].

This QA Inspector also observed ZPMC personnel doing arc gouging of the following welds:

- 1) CB202G-044-087, 085, 077, 135 & 131.
- 2) CB202G-041-079, 073, 069, 067, 129, 125 & 107.
- 3) CB202G-042-085, 137, 135, 059 & 081.

The above mentioned welds were UT rejected by ZPMC QC (UT was done on 05/19/10) & needed to be repair welded.

Trial Assembly:

CB7, CB8, CB9 & CB10:

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.

### **Summary of Conversations:**

Only general conversation was held between QA and QC concerning this project.

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## 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.

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| <b>Inspected By:</b> | Wadkar,Sailesh | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Hall,Steven    | QA Reviewer                 |

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