

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-014517**Date Inspected:** 05-Jun-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 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 8: CB17.

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint CB3001A-017-002. Welder is identified as 040671 & 054459. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Trial Assembly:

CB7:

Notification No: 005874.

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.

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The member(s) are identified as OBG component – Cross Beam 7 (CB7). The weld designations reviewed are as follows:

- 1) CB201A-007-001, 003, 004, 006, 007, 009, 010, 012, 021, 022, 023, 024, 013, 015, 016 & 018.
- 2) DP202A-007-019 to 022 & 033 to 036.
- 3) DP201A-007-013 to 016 & 021 to 024.
- 4) BP202A-007-009, 010, 015 & 016.
- 5) BP206A-007-007, 008, 013 & 014.
- 6) FB202A-007-007, 008, 013 & 014.
- 7) FB201A-007-033, 034, 045 & 046.
- 8) FB203A-007-011 to 014 & 019 to 022.
- 9) SP202A-007-018, 019, 024 & 025.
- 10) SP201A-007-023, 024, 035 & 036.
- 11) SP203A-007-042 to 045 & 050 to 053.
- 12) SP207A-007-123, 124, 135 & 136.
- 13) SP208A-007-018, 019, 024 & 025.
- 14) SP209B-007-020 to 023 & 028 to 031.

Notification No: 005903.

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 member(s) are identified as OBG SEG 7DW. The weld designations reviewed are as follows:

- 1) SSD10A-PP56-260, 261 & 262.

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
