

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-014519**Date Inspected:** 04-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:

Outside Yard:

Bay 1: CB15.

This QA Inspector observed that no significant work was being performed on the above mentioned 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 FB3057-053-049. Welder is identified as 040671. 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-B-U2-F.

CB11, CB12, CB13, CB14 & CB16:

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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.

Trial Assembly:

CB7:

This QA Inspector observed the following work in progress:

Repair welding of weld joint CB201A-007-018. Welder is identified as 048659. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-Repair-1 (CWR No: B-CWR 1596 Rev-0, Dt: 06/04/10 & UT report no: UT-CB7-006). Refer attached photo for reference.

CB8:

This QA Inspector observed the following work in progress:

Repair welding of weld joint CB202A-008-003 & 015. Welder is identified as 048659. Welding process was identified as SMAW. ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G(4F)-Repair-1 (WRR No: B-WR 13461 Dt: 06/04/10 & B-WR 13462 Dt: 06/04/10).

This QA Inspector also observed ABF personnel performing MT of the hold back welds of this CB.

CB9:

This QA Inspector observed the following work in progress:

SMAW of weld joints FB201-009-024 & FB203-009-010, 012, 014 & 016. Welder is identified as 037723. ZPMC QC is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114.

Notification No: 005889.

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. The member(s) are identified as OBG component – Bike Path. The weld designations reviewed are as follows:

- BK001-030-024 & 025.
- BK001-031-024 & 025.
- BK001-032-024 & 025.
- BK001-033-024 & 025.
- BK001-034-024 & 025.

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Bay 14:

No significant work was being performed in this Bay at the time when this QA Inspector 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.

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
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Reviewed By:	Hall,Steven	QA Reviewer
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