

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-014639**Date Inspected:** 08-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:** Wu Zhi Cheng**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:

Trial Assembly:

CB9:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joints DP203-009-017 to 020. Welder is identified as 037743. ZPMC Quality Control (QC) is identified as Li Jia. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114.

CB10:

This QA Inspector observed the following work in progress:

SMAW of weld joints DP201-010-009 to 016. Welder is identified as 047864. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114.

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SMAW of weld joints SP204-010-013, 015, 017, 019, 021 & 023. Welder is identified as 067829. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

Flux Cored Arc Welding (FCAW) of weld joints CB202A-010-004 & 006. Welder is identified as 045240. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Photo attached for reference.

Outside Yard:

CB11, CB12, CB13, 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.

OBG SEG 11DW:

This QA Inspector observed the following work in progress:

SMAW of weld joints SSD10A-PP104-232, 233, 252 & 253. Welder is identified as 067764. ZPMC QC is identified as Zhong Yang Gang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G(4F)-FCM-1.

Notification No: 005929.

This QA Inspector did random visual inspection of OBG components; Catwalk Railings (for Cross Beams) which were previously inspected and accepted by ZPMC QC. In all, 32 nos of railings were inspected. Visually, these railings were found to be complying with the Contract documents / drawings. ZPMC QC was identified as Zhou Cheng. ABF QA was identified as Hu Gui Hua.

Refer attached photo for details.

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