

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-015663**Date Inspected:** 17-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**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) Mr. 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:

OBG Trial Assembly Yard:

OBG Seg 9DE to Seg 9EE:

This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: OBE9A-008. The welder was identified as 067947 and was observed welding in the 1G position. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)-1T-2.

OBG Seg 9BW:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SSD25-PP75-059 and 060. The welder was identified as 205098 and was observed welding in the 2F position. ZPMC QC was identified as Jin Long. The

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welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 9DE:

This QA Inspector observed the following work in progress:

The FCAW process on weld joint no's: SSD27-PP81-009 and 010. The welder was identified as 068493 and was observed welding in the 3F position. ZPMC QC was identified as Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2133.

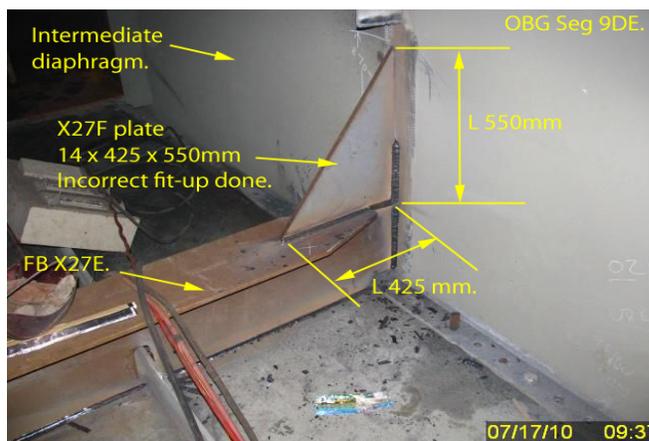
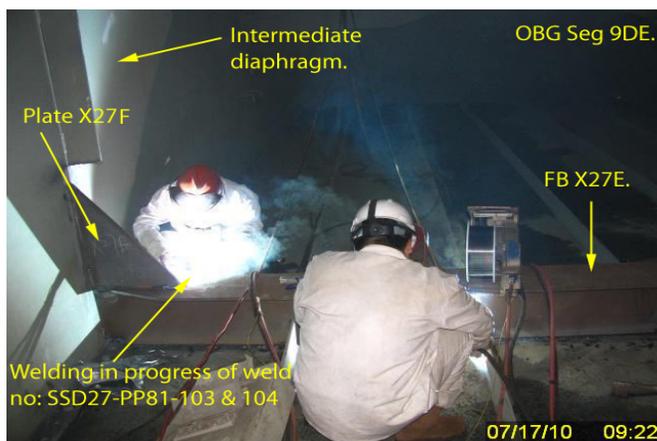
The FCAW process on weld joint no: SSD27-PP81-047. The welder was identified as 067942 and was observed welding in the 1G position. ZPMC QC was identified as Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-B-U2-F.

The FCAW process on weld joint no: SSD27-PP81-048. The welder was identified as 067942 and was observed welding in the 3G position. ZPMC QC was identified as Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

The FCAW process on weld joint no: SSD27-PP81-103 and 104. The welder was identified as 068493 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2232-TC-U2-F.

However, for the above mentioned welds, this QA observed that in-correct fit-up was done of X27F plate with floor beam X27E. As per drawing, the longer side (L550mm) of X27F plate was to be welded on floor beam. Instead, it was observed that the side with L425mm was being welded with floor beam. This QA Inspector discussed this issue with ZPMC CWI, Mr. Zhu Zhang Hai. ZPMC QC agreed that the weld will be removed and the X27F plate will be re fitted with floor beam. ZPMC QC will notify CT QA before the weld is removed.

Photos attached for reference.



Summary of Conversations:

No significant conversations were reported on this date.

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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.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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