

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-015923**Date Inspected:** 29-Jul-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 components.**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:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: BK001-PP083-005 and 007. The welder was identified as 051246 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-TC-U4c-F.

OBG Seg 9DW to Seg 9EW:

The FCAW process on weld joint no: OBW9A-008. The welders were identified as 066746 and 068858 and were observed welding in the 1G position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2231(T)-1.

OBG Seg 9AE to Seg 9BE:

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Repair welding on weld joint no: Seg 052A-039. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 048659 and was observed welding in the 4G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR 1738 Rev-0.

OBG Seg 9BE and Seg 9DE:

Base metal repair welding on FL3 area; after removal of temporary attachments. Welding process was identified as SMAW. The welder was identified as 068091 and was observed welding in the 3G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-13193 Rev-0. See attached photo for further details.

Cross Beam 12 (CB12):

The FCAW process on weld joint no's: CB201A-012-004, 016 and 018. The welders were identified as 222396 and 220066 and were observed welding in the 2G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-TC-U4b-F-2. See attached photo for further details.

Cross Beam 11 (CB11):

The FCAW process on weld joint no's: SP205-011-018, 020 and 022. The welder was identified as 045143 and was observed welding in the 2F position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

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:	Peterson,Art	QA Reviewer
