

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016064**Date Inspected:** 06-Aug-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:** Chen Xi..**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:

Bay 3:

Notification no: 006342.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

1) FB3138-001-041 to 056, 004, 010, 061, 062, 087, 088, 075, 076, 068 and 080.

Bay 6:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: WJF-0-029. The welder is identified as

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215083 and was observed welding in the 2G position. ZPMC QC was identified as Huang Min. The welding variables recorded by QC appeared to comply with WPS: B-T-3312-TC-P5. See attached photo for further details.

Notification no: 006342.

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 components. The weld designations reviewed are as follows:

1) DP3095-001- 125, 126, 128, 129, 053, 054, 063, 064, 118, 119, 123, 057, 067, 019, 011, 022, 014, 006, 001, 025, 017, 009 and 004.

Bay 7:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: DP3111-001-001 to 004. The welders were identified as 217185 and 053609 and were observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

Bay 8:

This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: BK004A1-064-009. The welder is identified as 040831 and was observed welding in the 1G position. ZPMC QC was identified as Liu Fa Wen. The welding variables recorded by QC appeared to comply with WPS: B-T-2221-L2c-S-2. See attached photo for further 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:

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
