

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-016451**Date Inspected:** 23-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:** Zhu Zhong Hai.**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:

OBG Seg 9CW:

Repair welding on weld joint no: SEG053B-024. Welding process was identified as Flux Cored Arc Welding (FCAW). The welder was identified as 202384 and was observed welding in the 3G position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-3G(3F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14568 Rev-0.

OBG Seg 9BW:

Repair welding on weld joint no: SEG051A-045. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 047864 and was observed welding in the 4G position. ZPMC QC was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14700 Rev-0.

The SMAW process on weld joint no: SSD25-PP75-032. The welder is identified as 045204 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-2212-B-U2-FCM-1.

OBG Seg 10 BW:

The SMAW process on weld joint no's: SEG061A-013 and 014. The welders are identified as 067829 and 067752 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The SMAW process on weld joint no's: OBW10B-002 and 003. The welders are identified as 067589 and 067752 and were observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9BE:

Repair welding on weld joint no: SSD17-PP75-166. Welding process was identified as SMAW. The welder was identified as 045246 and was observed welding in the 4G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14717 Rev-0.

OBG Seg 9DW and Seg 9EW:

Repair welding on weld joint no: EP114-001-014. Welding process was identified as SMAW. The welder was identified as 044551 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14693 Rev-0.

Repair welding on weld joint no: EP129-001-027. Welding process was identified as SMAW. The welder was identified as 041713 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14680 Rev-0.

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

Summary of Conversations:

No significant conversations were reported on this date.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
