

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-016472**Date Inspected:** 27-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:** 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:

OBG Seg 10AE and Seg 10BE:

The Shielded Metal Arc Welding (SMAW) process on weld joint no's: OBE10-001 and 005. The welders are identified as 052493 and 040504 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBE10-002. The welder is identified as 047353 and was observed welding in the 1G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-T.

OBG Seg 10AW and Seg 10BW:

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The SMAW process on weld joint no: OBW10B-004. The welder is identified as 067829 and was observed welding in the 4G position. ZPMC QC was identified as Zhong Guo Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9DE:

The SMAW process on weld joint no's: OBE9B-011, 024, 025 and 034. The welder is identified as 049769 and was observed welding in the 4G position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no's: OBE9B-012, 013, 022 and 023. The welder is identified as 054467 and was observed welding in the 4F position. ZPMC QC was identified as Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

OBG Seg 9BE:

Notification no: 006493.

This QA inspector performed Magnetic Particle Testing (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 members are identified as OBG components – Seg 9BE (hold back welds). The weld designations reviewed are as follows:

- 1) FB020-PP74-012 to 017.
- 2) FB024-PP75-012 to 017.
- 3) FB026-PP76-012 to 017.
- 4) BP025-PP75-024, 025, 032 to 035, 042 and 043.
- 5) SEG052D-001-016, 017, 052 and 053.
- 6) SEG052E-001-045, 046.
- 7) SEG052E-002-167, 168.

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

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.

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Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer