

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-011351**Date Inspected:** 10-Jan-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:** 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) 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 19:

NDT Notification No: 005033.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1) BP026-015 – 001 & 002.

Bay 14:

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) of weld joint SEG3004A - 007 & 001 (for OBG Seg 12AW). Welder is identified as 048686. ZPMC Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-B-L2C-S-2.

Shielded Metal Arc Welding (SMAW) of weld joint SEG3005A - 003 & 004 (for OBG Seg 12BW). Welders are

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identified as 047864 & 058242. ZPMC Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-B-U2-FCM-1.

Bay 13:

This QA Inspector observed the following work in progress:

SMAW of weld joint SSD14-PP101 - 252 & 222 (for OBG Seg 11CW). Welder is identified as 067656. ZPMC Quality Control (QC) is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-U4B-FCM-1.

SMAW of weld joint SSD20A-PP101 - 253 (for OBG Seg 11CW). Welder is identified as 044772. ZPMC Quality Control (QC) is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2214-U4B-FCM-1.

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

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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 - 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
