

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-011974**Date Inspected:** 08-Feb-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:	NA	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:

Outside Yard:

SEG 9BW:

- This QA inspector performed in process visual Inspection of the below mentioned fillet welds between Floor Beam and Floor Beam Flange.

1) PP74-FB003-136 - 005.

2) PP75-FB011-026 - 003.

- The above mentioned welds were previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel. As per contract documents, ZPMC QC is required to perform 25% MT of these welds.

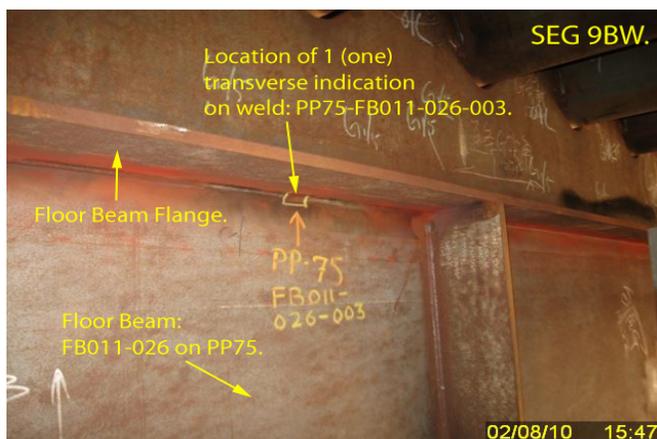
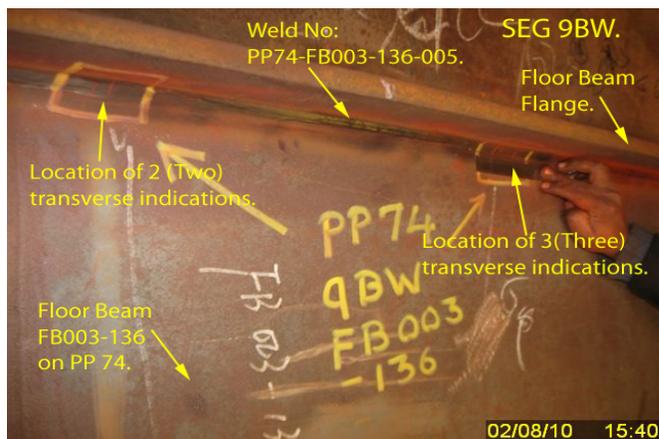
- Visually, both these welds do not appeared to comply with the contract documents due to the below mentioned points:

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- For PP74-FB003-136 – 005:
 - During inprocess visual inspection of the above mentioned weld, this QA observed Five (5) transverse indications.
- For PP75-FB011-026 - 003:
 - During inprocess visual inspection of the above mentioned weld, this QA observed One (1) transverse indication.
- The above mentioned indications were confirmed with MT and the lengths of these cracks were observed as approximately 8mm to 15mm.
- These welds were previously Magnetic Particle Testing (MT) tested and accepted by ZPMC Quality Control (QC) personnel.
- The member(s) are identified as OBG components – Floor Beam & Floor Beam Flange on PP74 & PP75.
- This QA Inspector has generated MT report for this date.
- This QA Inspector had informed ZPMC QA identified as Mr. Zhong Wei, of this issue and that an incident report would be generated.
- For further information, please see the attached photos.

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



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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; phone: 15000422372, who represents the Office of Structural Materials for your project.

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