

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-012465**Date Inspected:** 04-Mar-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**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 1:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of OBG component – Traveler Rail; weld joint 20TR1-019 – 001 & 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-030 – 001, 003 & 007. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-035 – 005. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

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FCAW of OBG component – Traveler Rail; weld joint 20TR2-025 – 009 & 011. Welder is identified as 251246. ZPMC Quality Control (QC) is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

CB15:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 5:

This QA Inspector observed the following work in progress:

Repair welding / build up of OBG component – Traveler Rail 10TR4-003. Welder is identified as 215248. Welding process is identified as FCAW. ZPMC Quality Control (QC) is identified as Shen Jian Guo. The repair / build were carried out as per Critical Welding Repair (CWR) report no: B-CWR-1102 R-0. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-1G (1F)-Repair. Build-up was required to be done on this part as it was found approx 15-20mm short of length as per what was required by drawing.

Bay6: CB9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB8, CB13, CB10, CB11, CB16, CB12 & CB14:

This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Bay 15:

CB5:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC performing gouging of the below mentioned welds:

- CB202G-009 – 043 [Welding Repair Report (WRR) No: B-WR-10721 R-0].
- CB202G-010-043 (WRR No: B-WR-10722 R-0).
- CB202G-011-043 (WRR No: B-WR-10723 R-0).
- CB202G-012-043 (WRR No: B-WR-10724 R-0).
- CB202G-009-053 (WRR No: B-WR-10725 R-0).
- CB202G-010-053 (WRR No: B-WR-10726 R-0).
- CB202G-011-053 (WRR No: B-WR-10727 R-0).

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- CB202G-012-053 (WRR No: B-WR-10728 R-0).

This QA Inspector also verified ZPMC UT report no: UT-B787-11243, for the above mentioned welds.

CB6:

During random inprocess inspection of this CB, this QA Inspector observed ZPMC personnel performing grinding on the areas where base metal repair was done. No significant work was being performed on this CB at the time when this QA was present.

Trial Assembly:

CB7:

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

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

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