

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-012501**Date Inspected:** 28-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:** 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 20TR1-027 – 007. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yong Fu Zhi. 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 20TR1-034 – 003. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Liu Yang Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

BAY 2:

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Repair welding / build up of OBG component – Traveler Rail 10TR2-014 & 10TR1-008. Welder is identified as 045203. Welding process is identified as FCAW. ZPMC Quality Control (QC) is identified as Yang Qing Feng. The repair / build were carried out as per Critical Welding Repair (CWR) report no: B-CWR-1096 R-0. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G. Build was required to be done on these parts as these were found approx 15mm short of length as per what was required by drawing.

For Cross Beams (CB):

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.

CB15:

This QA Inspector observed this CB being shifted to BAY 1. This QA discussed with ZPMC CWI identified as Mr. Chen Xi, & it was understood that repair weld is to be carried out for weld nos CB202A-015-014 & CB202A-015-002. ZPMC had completed Ultrasonic Testing (UT) of these welds which revealed some indications not complying with the project requirement.

Proper care was observed to be taken while transportation of this CB.

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.

CB5 & CB6:

This QA Inspector observed these Cross Beams shifted to Bay 15.

No other 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------	-------------