

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-012503**Date Inspected:** 25-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 20TR1-025 – 003, 005 & 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 20TR1-033 – 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.

FCAW of weld no 2 of OBG component – Support Brackets for Cross Beam; 13TB1- 141, 158, 161 & 168. 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-U4B-F.

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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, CB15, 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.

Trial Assembly:

CB6.

During random inprocess visual inspection this QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG component – Cross Beam – CB6; hold back weld, CB202-006-001.

Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Zhang Hai Tao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2212-TC-U4B-FCM-1.

Material is identified as Seismic Performance Critical Member (SPCM). This QA Inspector verified pre-heating of this joint before welding & also it was verified that the other side of this joint (i.e. from inside of CB), is dry and comply with the project requirements.

Attached are the photos intended to capture the workmanship being performed on this component.

CB5:

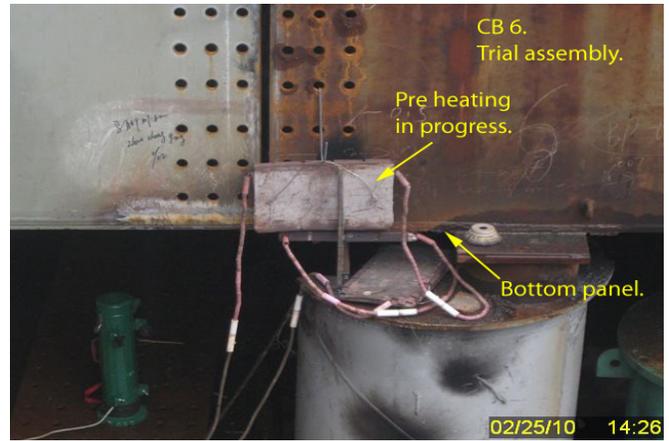
During random inprocess visual inspection this QA Inspector observed ZPMC personnel performing the dis-assembly of this CB from OBG SEG 5AW & 5AE. Proper measures were appeared to be taken to avoid any damage to this component while it was dis-assembled.

Refer attached photos for reference.

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

Reviewed By: Hall,Steven

QA Reviewer