

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-012506**Date Inspected:** 22-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 20TR1-023 – 003 & 005.

Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

For Cross Beams (CB):

Blast Shop 2: CB4.

During random inprocess visual inspection of this Cross Beam, this QA Inspector observed:

- One porosity (of Ø approx 4mm x 7mm deep) on Side Panel – SP 208A (16mm plate thickness).
- This needs to be weld repaired. Material is identified as Seismic Performance Critical Member (SPCM).
- This QA Inspector discussed this issue with ZPMC CWI Mr. Xu Xian Ping and it was understood that ZPMC had already submitted a Critical Weld Repair Report (CWR), No: CWR 1220 Dt: 02/21.10, for approval.

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- Primer application is already completed on this CB.

- Refer attached photos for further information.

No other significant work was being performed on this CB at the time when this QA was present.

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:

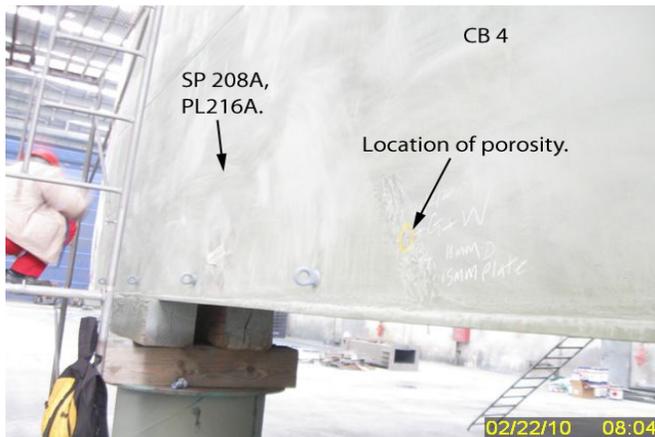
CB8, CB13, CB10, CB11, CB15, CB16, CB12 & CB14:

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: CB5.

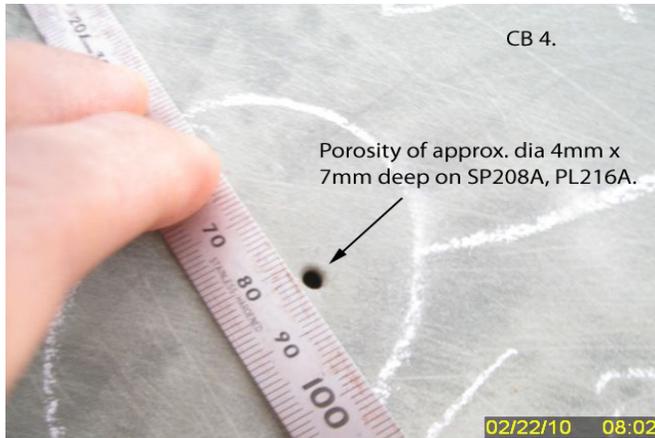
This QA Inspector observed ABF Magnetic Particle Testing (MT) personnel, identified as Mr. He Zhi Shun, performing MT on hold back joints on Side Panel, Intermediate Panel & Deck Panel of CB5. This QA performed random inprocess visual inspection of these joints and found them to be complying with the contract documents. 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.



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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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