

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-012785**Date Inspected:** 19-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:	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 CB 8	

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:

CB8:

Notification No: 005368.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

- 1) CB202A-008 – 005, 011, 020 & 017.
- 2) CB202G-017 – 063, 064, 083 to 086, 180, 181, 147, 165, 049, 050, 153, 154, 109 to 112, 182, 183, 057 to 060, 148, 166, 003 to 006, 141, 159, 023 to 026, 142, 143, 161, 093 & 094.
- 3) CB202G-018 – 063, 064, 083 to 086, 180, 181, 147, 165, 049, 050, 153, 154, 109 to 112, 182, 183, 057 to 060, 148, 166, 003 to 006, 141, 159, 023 to 026, 142, 143, 160, 161, 093 & 094.
- 4) CB202G-019 – 063, 064, 083 to 086, 180, 181, 147, 165, 049, 050, 153, 154, 109 to 112, 182, 183, 057 to 060,

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148, 166, 003 to 006, 141, 023 to 026, 142, 143, 160, 161, 093 & 094.

5) CB202G-020 – 063, 064, 083 to 086, 180, 181, 147, 165, 049, 050, 153, 154, 109 to 112, 182, 183, 057 to 060, 148, 166, 003 to 006, 141, 159, 023 to 026, 142, 143, 160, 161, 093 & 094.

The following welds did not appear to comply with the applicable contract documents:

1) CB202G-019-159.

Two (2) transverse linear indications were discovered measuring approximately 6mm & 10mm in length.

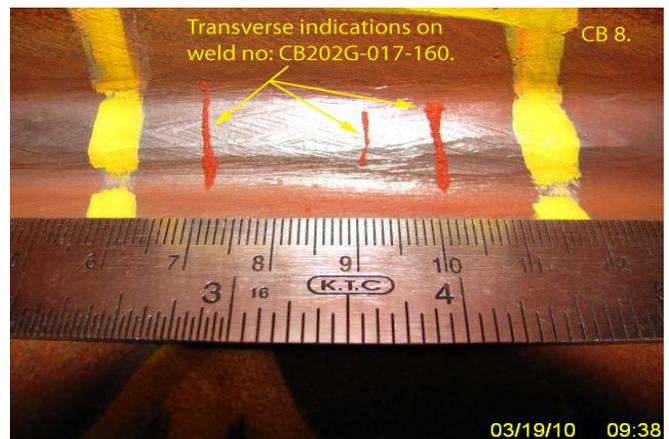
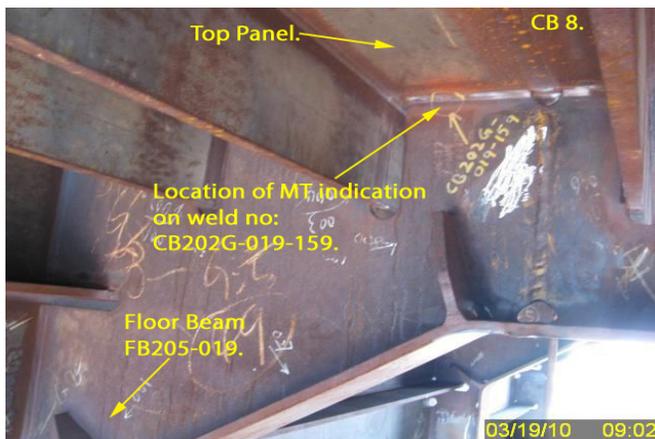
2) CB202G-017-160.

Three (3) transverse linear indications were discovered measuring approximately 8mm & 15mm in length.

For the above Two (2) welds, the members are identified as Floor Beam fillet welded with Top Panel. The indications are located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA informed ZPMC Quality Control (QC) identified as Mr. Zhong Wei and American Bridge Fluor (ABF) QA identified as Mr. Cao Hui Zhao of this issue and that an incident report would be generated.

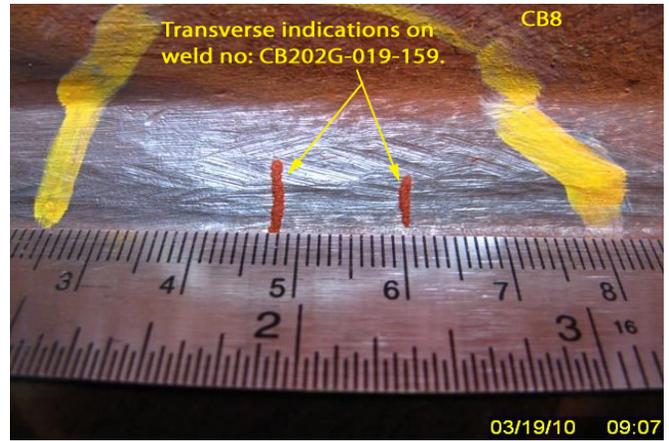
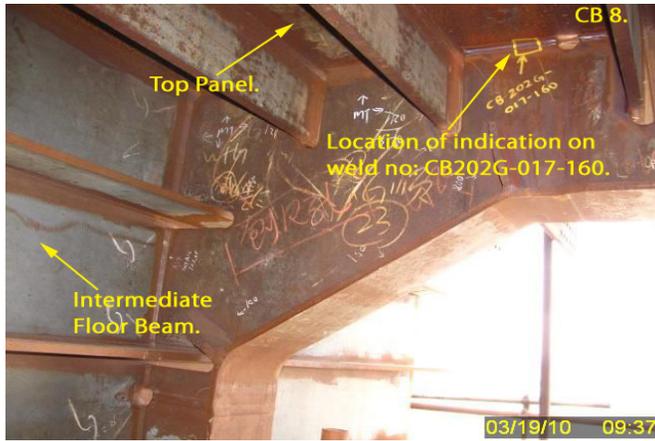
For further information, please see the attached photos.

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

Reviewed By: Hall,Steven

QA Reviewer