

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-012865**Date Inspected:** 05-Apr-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:** Li Yun Hua**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:

Outside Yard:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of weld joint SEG060E-PP89 – 089, 090, 084, 085, 093 & 094 (for SEG 10AE). Welder is identified as 067589 & 044772. ZPMC Quality Control (QC) is identified as Tang Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

SMAW of weld joint SEG060E-PP89 – 097 & 088 (for SEG 10AE). Welder is identified as 216086. ZPMC Quality Control (QC) is identified as Tang Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2213-TC-U4b-FCM-1.

SMAW of weld joint SEG056E-PP82 – 075, 076, 102 & 103 (for SEG 9DE). Welder is identified as 043661. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2114-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

For SEG 9DE:

This QA Inspector observed ZPMC personnel performing heat straightening of weld no: FB028-003 – 164/165, Floor Beam on PP 82 of OBG SEG 9DE. This QA Inspector verified the heat straightening report (HSR) no: 8257. ZPMC Quality Control (QC) is identified as Li Ping.

For details, refer attached photos.

Blast Shop 1:

This QA Inspector performed random visual inspection of OBG SEG 9BW after grit blasting. Inspection was done for Floor Beam, internal surfaces of Side Panels & Bottom panels. Areas requiring additional grinding were marked by this QA and were repaired by ZPMC personnel.

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
