

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-012866**Date Inspected:** 31-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:** 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 20TR2-048 – 017. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Dong Yi Quin. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-036 – 003. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Li Yang Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-015 – 001. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Li Fa Yang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

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Bay 6: CB 9.

This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB10:

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) of OBG component – Cross Beam 10 (CB10); weld joint CB202G-025 – 039/040. Welder is identified as 058087. This weld, as per WRR No: B-WR-11454 R-1, is welded as CJP weld as the root gap was more than 5mm. ZPMC Quality Control (QC) is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-Repair.

SMAW of OBG component – Cross Beam 10 (CB10); weld joint CB202G-026 – 025/026. Welder is identified as 048047. This weld, as per WRR No: B-WR-11454 R-1, is welded as CJP weld as the root gap was more than 5mm. ZPMC Quality Control (QC) is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G (3F)-Repair.

CB11, CB12, CB13, CB14 & CB16:

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 Assly: CB7:

Notification No: 005448.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member is identified as Cross Beam 7 (CB7). The weld designations reviewed are as follows:

- CB201G-016 – 097 (R3) & 101.
- CB201G-015 – 063 (R3) & 097.

The above mentioned notification also included NDT (MT – TAG#9) of fillet welds of MEP's. However, this QA Inspector observed that these MEP's were not even fitted with CB. ZPMC QC identified as Mr. Tian Lei & QA identified as Mr. Zhong Wei were then informed about this.

Refer attached photos for further information.

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