

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-012980**Date Inspected:** 07-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: CB15:

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

Bay 6: CB9.

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

Bay 8:

This QA Inspector observed the following work in progress:

Submerged Arc Welding (SAW) of Bottom Panel for Cross Beam (CB) 17, weld joint CB3001C-017-001. Welder is identified as 040831. ZPMC Quality Control (QC) is identified as Zhao Cheng Jian. The welding variables

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recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-L2C-S2.

SAW of Bottom Panel for Cross Beam (CB) 17, weld joint CB3001C-017-002. Welder is identified as 040831. ZPMC Quality Control (QC) is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2221-L2C-S2.

Flux Cored Arc Welding (FCAW) of Side Panel for Cross Beam (CB) 17, weld joint CB3001F-017-001 & 002. Welder is identified as 054460. ZPMC Quality Control (QC) is identified as Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-B-U2-F.

Bay 15: CB5 & CB6.

This QA Inspector also observed ABF personnel performing MT on the areas where earlier grinding was done after doing base metal repair. This QA Inspector did visual inspection of all such locations & were found to be complying with the contract documents.

Outside Yard:

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

This QA observed that no significant work was being performed on these crossbeams during the time QA was present.

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
