

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013513**Date Inspected:** 29-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:** 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 Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Bay 8: CB17:

Notification No: 005632.

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 component – Cross Beam 10. The weld designations reviewed are as follows:

1) CB3001C-017-001, 002 & 004.

Outside Yard:

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CB10, CB11, CB12, CB13 & 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.

CB14:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB202G-042-053 to 061. Welders are identified as 217805. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

FCAW of weld joint FB205-041-039/040 & FB205-042-039/040. Welder is identified as 050977. ZPMC QC is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Trial Assembly:

CB 7:

Notification No: 005621.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 100% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG component – Cross Beam 7.

MT was done on the areas on Floor Beams & Bottom Panel, were the Contractor earlier tack welded drill templates to the Bottom Panel (SPCM material) of the Crossbeam. This MT is done against punch list (for CB 7) item no: 399.

Refer attached photo for reference.

This QA Inspector also observed the following work in progress for CB 7:

FCAW of weld joints CB201A-007-010, 012, 022 & 024. Welders are identified as 066733 & 222396. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

FCAW of weld joints BP201-007-005 to 012. Welders are identified as 069895 & 066746. ZPMC Quality Control (QC) is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2132.

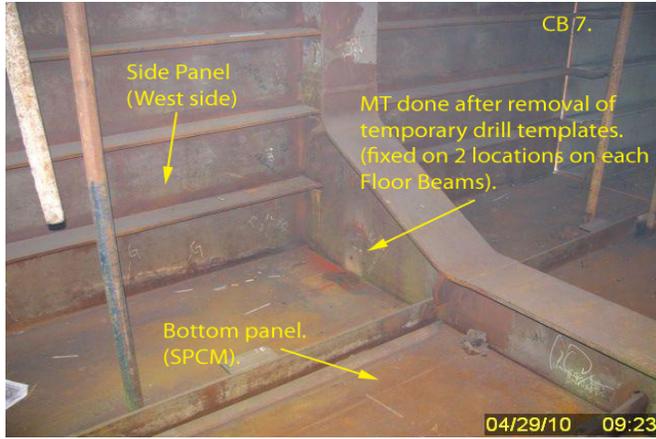
CB 9:

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

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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
