

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-013977**Date Inspected:** 12-May-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 the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joints CB202G-047-153,154 & CB202G-048-153,154. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Tian Li. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2133.

FCAW of weld joints FB205-047-039, 040 & FB205-048-039 & 040. Welder is identified as 219188. ZPMC QC is identified as Tian Li. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Bay 8: CB17:

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Outside Yard:

CB11, CB12 & 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:

Shielded Metal Arc Welding (SMAW) of weld joints SP205-014-007 to 017. Welder is identified as 051359. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2113-Padeye.

Repair welding of weld joint nos: CB202A-014 – 017. Welder was identified as 051359. Welding process was identified as SMAW. ZPMC QC is identified as Wang Liang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-Repair (welding repair report (WRR) no: B-WR12747 Rev-0).

CB13:

Repair welding of weld joint nos: CB202A-013-005. Welders are identified as 069896. Welding process was identified as SMAW. ZPMC Quality Control (QC) is identified as Zhang Qiao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-Repair (Critical Welding Report (CWR) no: B-CWR1526 Rev-0).

This QA Inspector also observed ZPMC personnel performing base metal repair on Bottom Panel (BP204A) & Side Panel (SP202A), after removal of the temporary attachments. Panels BP204A & SP202A of the Cross Beam are identified as Seismic Performance Critical Members (SPCM). Welder was identified as 069896. Process was identified as SMAW. Repair welding was done according to CWR-B CWR 976 Rev-0 & WPS: 345-SMAW-2G(2F)-FCM-Repair, 345-SMAW-4G(4F)-FCM-Repair. ZPMC QC was identified as Zhang Qiao. This QA Inspector also observed that MT was done for these locations before welding. Refer attached photos for reference.

Trial Assembly:

CB7, CB8, CB 9 & CB10:

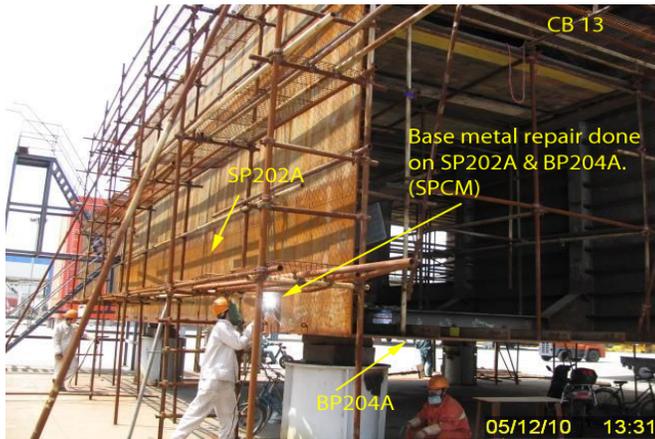
This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
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Reviewed By:	Hall,Steven	QA Reviewer
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