

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-014052**Date Inspected:** 09-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:** Li yang.**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 CB202A-015-005/017. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Xian Feng Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4b-F.

Bay 8: CB17:

During random in-process inspection of this Cross Beam, this QA Inspector observed that the fit-up of Bottom panel with Side panels & Intermediate panel is in progress.

Outside Yard:

CB11, CB12, CB13, CB14 & CB16:

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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 Assembly:

CB7:

This QA Inspector observed ZPMC welding personnel perform base metal restoration of two mis-located cable bearer holes on the I-rib of bottom panel identified as BP206A (SPCM). ZPMC personnel did not appear to follow the procedure for patching mis-located holes as specified in ABF submittal ABF-SUB-000200R02 (ZPMC did not elongate the hole prior to welding). ZPMC did not follow the Weld Repair Report on site identified as WRR-B-WR12749. This WRR specified using the Shielded Metal Arc Welding (SMAW) process. ZPMC used the Flux Cored Arc Welding (FCAW) process. This QA Inspector along with ZPMC QA identified as Zhong Wei, discussed this issue with Caltrans (CT) Lead QA. Mr. Wei agreed that the repair procedure was not followed for the restoration of these holes and informed this QA that ZPMC will rectify it immediately by removing the deposited weld metal and re-welding per the procedure outlined in the above mentioned ABF submittal. This QA observed ZPMC personnel perform the re-work of these holes. The work performed appeared to comply with the applicable procedure. No Incident report was raised for this issue.

Refer attached photos for details.

CB8, CB9 & 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 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