

**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-014719**Date Inspected:** 14-Jun-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:** Wu Zhi Cheng.**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 the above mentioned CB at the time when this QA was present.

Bay 8: CB17.

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

Trial Assembly:

CB9:

During random inprocess inspection of this CB, this QA Inspector observed the following:

- ZPMC performing 2nd time removal of Seismic Performance Critical Material (SPCM) welds identified as

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CB202A-009-018 & 006 without Engineers approval.

- The welds are Complete Joint Penetration (CJP) joints joining the SPCM bottom panels to the SPCM side panels.
- The affected panels are identified as bottom panels BP205A and BP204A, Side panels SP202A and SP205A. All are identified as SPCM.
- Excavation length was approximately 1 meter on both welds.
- These welds were previously removed and re-welded on 06/08/10 for the purpose of aligning the bottom panel of the crossbeam to the FL3 bottom panel of Orthotropic Box Girder (OBG) segment 8AE (refer WRR No: B-WR13530 Rev-0 Dt: 06/08/10).
- Welds are being removed today (6/14/10) for the same purpose.
- This QA Inspector discussed this issue with ZPMC Quality Control (QC) identified as Li Jia & Wu Zhi Cheng that they did not comply with the Contract documents and an Incident Report would be raised.
- Photos attached for reference.

CB10:

This QA Inspector did random inprocess inspection of the hold back welds of this Cross Beam. Welding of all the hold back welds was observed to be completed. ZPMC visual inspection (VT) is balance.

Outside Yard:

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.

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.

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**Inspected By:** Wadkar,Sailesh

Quality Assurance Inspector

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**Reviewed By:** Hall,Steven

QA Reviewer