

**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-015464**Date Inspected:** 06-Jul-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:** Xu Xian Ping.  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:

Notification No: 006135.

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 – Traveler Rail. The weld designations reviewed are as follows:

- 1) 21TR2-001-001, 003, 005 & 007.
- 2) 21TR3-003-001, 003, 005 & 007.
- 3) 20TR1-030-001, 003, 005 & 007.
- 4) 20TR1-031-001, 003, 005 & 007.
- 5) 21TR4-001-001, 003, 005 & 007.
- 6) 21TR4-004-001, 003, 005 & 007.
- 7) 21TR4-002-001, 003, 005 & 007.

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- 8) 21TR4-003-001, 003, 005 & 007.
- 9) 21TR3-004-001, 003, 005 & 007.
- 10) 20TR1-035-001, 003, 005 & 007.

Bay 2:

Notification No: 006132.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG component – Traveler Rail. The weld designations reviewed are as follows:

- 1) 20TR1-001-001, 003, 005 & 007.
- 2) 20TR1-005-001, 003, 005 & 007.
- 3) 20TR1-014-001, 003, 005 & 007.
- 4) 20TR1-015-001, 003, 005 & 007.
- 5) 20TR1-016-001, 003, 005 & 007.

Notification No: 006133.

This QA inspector performed MT of approximately 15% 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 – Floor Beam. The weld designations reviewed are as follows:

- 1) FB3220-001-019.
- 2) FB3217-001-019.

Bay 8: CB 17:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint FB3057-054-057. Welder is identified as 054459. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-B-U2-F.

### **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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<b>Inspected By:</b>	Wadkar,Sailesh	Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven	QA Reviewer
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