

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-015568**Date Inspected:** 12-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:** 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 that no significant work was being performed on the above mentioned CB at the time when this QA was present.

Bay 7: CB18.

This QA Inspector observed the following work in progress:

ZPMC personnel doing fit-up welding of stiffener X3724B with Bottom Panel BP3051A. Welding process was identified as Shielded Metal Arc Welding (SMAW). Welder is identified as 049485. ZPMC Quality Control (QC) is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-P-2112. This QA Inspector randomly verified the tack welds & were found to be complying with the contract documents.

Bay 8: CB17.

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This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time when this QA was present. Repair welding of weld nos: CB3001A-017-002 & CB3001A-017-020 is still to be done.

Outside Yard:

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.

Trial assembly:

CB11:

This QA Inspector observed the following work in progress on FL3 area of OBG SEG 9BE:

Repair welding of weld joint no: SSD27-PP75-48. Welding process was identified as SMAW. Welder is identified as 048569. ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-3G(3F)-FCM-Repair-1 (WRR No: B-WR-13973 Rev-0, Dt: 07/11/10).

Repair welding of weld joint no: SSD27-PP75-47. Welding process was identified as SMAW. Welder is identified as 048569. ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-4G(4F)-FCM-Repair-1 (WRR No: B-WR-13971 Rev-0, Dt: 07/11/10).

Photo attached for reference.

Repair welding of weld joint no: SSD27-PP75-137. Welding process was identified as SMAW. Welder is identified as 048569. ZPMC QC is identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-FCM-Repair-1 (WRR No: B-WR-13976 Rev-0, Dt: 07/11/10).

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

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CB 18
(Bay 7).

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