

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-015569**Date Inspected:** 11-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: 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 performing gas gutting of the following stiffeners for CB18:

- X3724A for BP3054.
- X3726A for SP3085.
- X3726E for SP3088.
- X3726A for DP3112.
- X3726A for DP3113.

ZPMC Quality Control (QC) is identified as Cui Jun Jie. No other significant work was being performed for this

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CB at the time when this QA was present.

Bay 8: CB17.

This QA Inspector observed the following work in progress:

Repair welding of weld joint no: CB3001A-017-002. Welding process was identified as Shielded Metal Arc Welding (SMAW). Welder is identified as 045148. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-Repair (WRR No: B-WR-13938 Rev-0).

Repair welding of weld joint no: CB3001A-017-020. Welding process was identified as Flux Cored Arc Welding (FCAW). Welder is identified as 154459. ZPMC QC is identified as Feng Ya Jun. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-FCAW-2G(2F)-Repair (WRR No: B-WR-13939 Rev-0).

This QA Inspector also observed ZPMC UT personnel performing UT of weld no: CB3001A-017-002 & CB3001A-017-020. UT was done after completion of repair welding of these two welds. 4 locations on weld no CB3001A-017-002 & 2 locations on weld no CB3001A-017-002 are marked again for repair. ZPMC QC is identified as Feng Ya Jun.

Outside Yard:

CB13:

Notification no: 006161.

This QA inspector performed Magnetic Particle Testing (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 – Cross Beam 13. The weld designations reviewed are as follows:

1) CB202C-013-003.

CB12, 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:

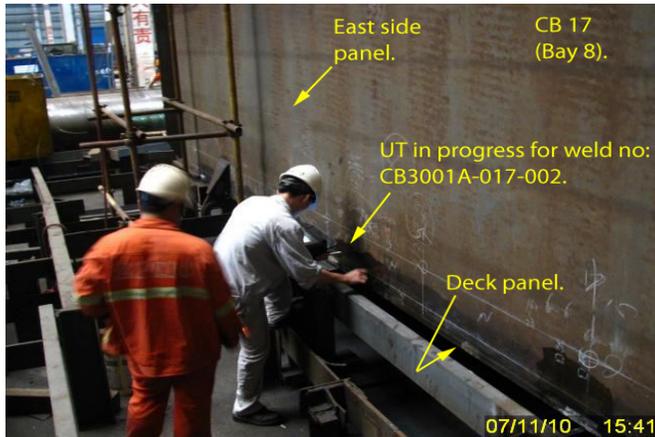
This QA Inspector observed that no significant work was being performed on the above mentioned CB at the time

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when this QA was present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract 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
Reviewed By:	Hall,Steven	QA Reviewer
