

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-015634**Date Inspected:** 15-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:** Liu Hua Jie.**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) Mr. 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:

OBG Trial Assembly Yard:

OBG Seg 9DE + 9EE:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBE-9A-001-009. The welder was identified as 067942. ZPMC Quality Control (QC) was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2231-T.

OBG Seg 9CE + 9DE:

This QA Inspector observed the following work in progress:

The ZPMC personnel performing base metal repair welding on Side Panel of OBG Seg 9CE to Seg 9DE. The welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 067765.

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ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM-Repair-1. The repair welding was performed after the removal of the temporary attachments in accordance with Critical Welding Report (CWR): CWR 1679R1. See attached photos for further details.

OBG Seg 9BW + 9CW:

This QA Inspector observed the following work in progress:

The FCAW process on weld joint no: OBW9-001-008. The welders were identified as 066673, 066239 & 066746. The ZPMC QC was identified as Wang Zhi. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)-1T-1. Photo attached for reference.

OBG Seg 9DE to Seg 9EE:

This QA Inspector observed the following work in progress:

The FCAW process on weld joint no's: SP627-001-043 to 048 (on side panel T – ribs). The welder was identified as 067942. The ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-T.

The FCAW process on weld joint no's: SP587-001-043 to 048 (on side panel T – ribs). The welder was identified as 068793. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-T.

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



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Summary of Conversations:

No significant conversations were reported on this date.

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
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Reviewed By:	Peterson,Art	QA Reviewer
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