

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-015659**Date Inspected:** 16-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:

Bay 7 – CB18:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: BP3051A-001-007 & 008. The welder was identified as 204342 and was observed welding in the 2F position. ZPMC Quality Control (QC) was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

The FCAW process on weld joint nos: BP3055A-001-007 & 008. The welder was identified as 062447 and was observed welding in the 2F position. ZPMC QC was identified as Guo Pan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

OBG Trial Assembly Yard:

OBG Seg 9BW to Seg 9CW:

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This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9-001-010. The welder was identified as 066326 and was observed welding in the 4G position. ZPMC QC was identified as Xu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9DE to Seg 9EE:

The SMAW process on weld joint no: DP700-001-020. The welder was identified as 066258 and was observed welding in the 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-3213-B-U3b.

OBG Seg 9BW to Cross Beam 11 (CB11):

The FCAW process on weld joint no: SSD25-PP075-068. The welder was identified as 207465 and was observed welding in the 2F position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-T-2132-3.

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 a UT report on this date. The members are identified as OBG component - 9BE. The weld designations reviewed are as follows:

SSD27-PP75-032, 047, 099, 100, 171, 174, 117, 137, 103 & 104.

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

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
Reviewed By:	Peterson,Art	QA Reviewer
