

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-015915**Date Inspected:** 25-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 components.**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 9BW to Seg 9CW:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SP106-001-051. The welder was identified as 067609 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9CW to Seg 9DW:

The Flux Cored Arc Welding (FCAW) process on weld joint no: OBW9C-004. The welders were identified as 066734, 070140 and 046706 and were observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2233-T.

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FCAW process on weld joint no: OBW9C-002. The welders were identified as 066746, 067550 and 067752 and were observed welding in the 3G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2233-T.

Cross Beam 11 (CB11):

SMAW process on weld joint no's: SP205-011-024, 026 and 028. The welder was identified as 069841 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

Repair welding on weld joint no's: CB202A-011-014 and 002. The welding process was identified as SMAW. The welders were identified as 049339 and 201087 and were observed welding in the 2G position. ZPMC QC was identified as Zhen Zhi Wei. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-Repair. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1696. See attached photo for further details.

Notification no: 006281.

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 Seg 9AE and Seg 9BE. The weld designations reviewed are as follows:

1) OBE9B-001 to 005.

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

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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
