

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-016236**Date Inspected:** 16-Aug-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:** Zhu Zhong Hai.**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:** Cross Beam 12.**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:

Cross Beam 12 (CB12).

Notification No: 006395.

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) CB201A-012-002, 014.
- 2) CB201B-012-001 to 004.
- 3) CB201D-012-002.
- 4) CB201F-012-004.
- 5) FB204-033-063, 069, 025 and 028.
- 6) FB204-034-060, 025 and 028.
- 7) FB204-035-060, 025 and 028.

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- 8) FB204-036-060, 025 and 028.
- 9) FB205-033-039 and 040.
- 10) FB205-034-039 and 040.
- 11) FB205-035-039 and 040.
- 12) FB205-036-039 and 040.
- 13) SP207-012-025, 031 and 052.
- 14) SP209-012-011.

The following weld did not appear to comply with the applicable contract documents:

- 1) CB201B-012-002.

One (1) longitudinal indication was discovered measuring approximately 5mm in length, and at depth of 12mm. The db rating is seen as +07, the material thickness is 22mm. The Weld is a Complete Joint Penetration (CJP) butt weld joining DP202A and DP201A. The "X" location of the indication is observed as 2mm & "Y" location is observed as 6150mm (measured from the south end of the weld / CB). The material is designated as Non Seismic Performance Critical Member (Non - SPCM).

- 2) FB204-034-060.

One (1) longitudinal indication was discovered measuring approximately 5mm in length, and at depth of 8mm. The db rating is seen as +07, the material thickness is 16mm. The Weld is a CJP butt weld. The "X" location of the indication is observed as 2mm & "Y" location is observed as 30mm (measured from the north end of this weld). The material is designated as Non - SPCM.

This QA informed about this to ZPMC QA; identified as Mr. Zhong Wei; and that an incident report would be generated.

CB12.

Notification No: 006397.

This QA inspector performed 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 components. The weld designations reviewed are as follows:

- 1) CB201G-033-063/064.
- 2) CB201G-034-045/046, 047/048, 049/050 and 051/052.
- 3) CB201G-035-045/046 and 047/048.
- 4) CB201G-036-047/048 and 049/050.

CB12.

Punch list Item no: 293 (for base metal repair area).

This QA inspector performed UT of approximately 10% of the base metal repaired area of I-rib on Bottom Panel;

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BP204-012. This area is previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components.

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
