

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016293**Date Inspected:** 19-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:** 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:

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 member is identified as OBG component – Cross Beam 12. The weld designations reviewed are as follows:

- 1) CB201E-012-001.
- 2) CB201F-012-008 and 009.

Notification no: 006434.

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 members are identified as OBG components – Seg 9BE and Seg 9DE. The weld designations reviewed are as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

follows:

- 1) SSD16-PP74-260, 261.
- 2) SSD18-PP76-260, 261.
- 3) SSD16-PP80-260, 261, 265 to 271.
- 4) SSD18-PP82-260, 261.

This QA Inspector observed the following work in progress:

OBG Seg 10AW and Seg 10BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no's: SP137-001-044, 046, 048 and 050. The welder is identified as 041713 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no's: SP164-001-048, 050, 052 and 054. The welder is identified as 041713 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no's: BP102-001-020, 022, 024 and 026. The welder is identified as 202384 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

The FCAW process on weld joint no's: BP048-001- 024, 026, 028 and 030. The welder is identified as 202384 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-B-U2-F.

OBG Seg 9EW:

Repair welding on weld joint no: CA067-005. Welding process was identified as FCAW. The welder was identified as 040759 and was observed welding in the 1G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14626 Rev-0.

OBG Seg 10AW:

Repair welding on weld joint no: CA071-001. Welding process was identified as FCAW. The welder was identified as 040759 and was observed welding in the 1G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: 345-FCAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14624 Rev-0.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
