

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-016307**Date Inspected:** 20-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: 006441 (for Bike Path cantilever – after heat straightening).

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) BK001-041-001 to 007 and 009.
- 2) BK001-042-001 to 007 and 009.

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: OBW10B-002. The welder is identified as

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067665 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. 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: EP132-001-027 and 028. The welder is identified as 040704 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: B-T-2231-B-U2-F.

OBG Seg 10AW:

The SMAW process on weld joint no: CA071-006. The welder is identified as 037723 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F.

OBG Seg 10BW:

The SMAW process on weld joint no's: CA073-002 and CA074-006. The welders are identified as 037723 and 067752 and were observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-F.

OBG Seg 9BW and Seg 9CW:

Repair welding on weld joint no: SEG051B-043. Welding process was identified as SMAW. The welder was identified as 205098 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: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14516 Rev-0.

Cross Beam 11 (CB11):

This QA Inspector observed the following work in progress:

- 1) ZPMC personnel doing base metal repair welding (weld restoration of base metal due to mislocated holes).
- 2) Total 4 nos of mislocated holes were identified.
- 3) 2 nos on one of the I-rib on Bottom Panel (BP) BP203A and 2 nos on another I-rib on BP201A. See attached photo for further details.
- 4) This repair welding was done as per WRR: B-WR-14631 Rev-0.
- 5) Welding process was identified as SMAW. The welder is identified as 058087 and was observed welding in the 3G position. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-Mislocated holes.

OBG Seg 9BE:

This QA Inspector observed the following work in progress:

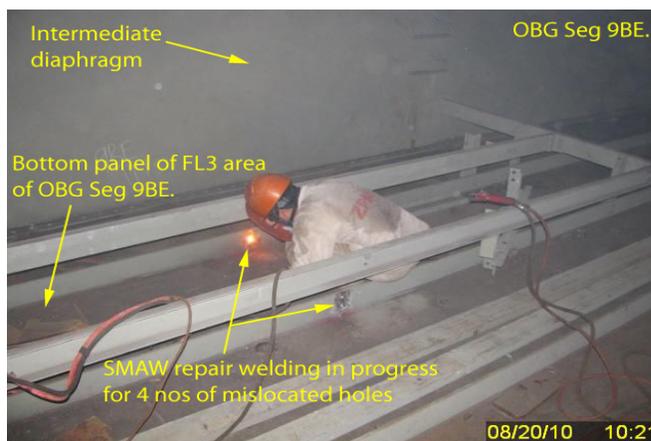
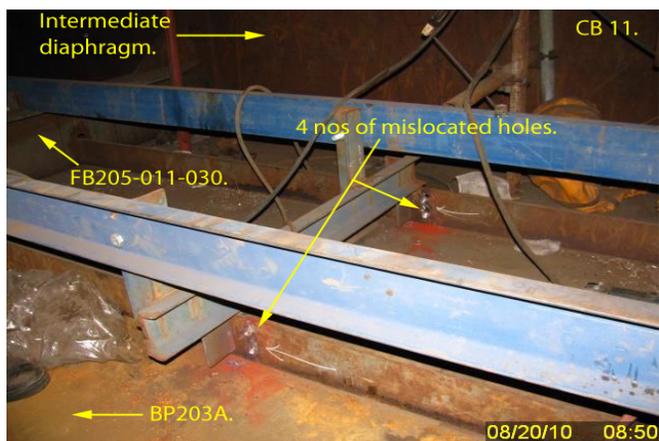
- 1) ZPMC personnel doing base metal repair welding (weld restoration of base metal due to mislocated holes).

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- 2) Total 4 nos of mislocated holes were identified on I-rib (X115A) on BP26A (See attached photo for further details).
- 3) This repair welding was done as per WRR: B-WR-14631 Rev-0.
- 4) Welding process was identified as SMAW. The welder is identified as 058087 and was observed welding in the 3G position. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-Mislocated holes.

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
