

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-016333**Date Inspected:** 22-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: 006456.

1) Cross Beam 11 (CB11):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the base metal repaired area (4nos of mis-located holes) that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components – Cross Beam 11 (CB11).

Earlier on dt: 08/20/10, weld repair was done (as per WRR: B-WR-14631 Rev-0) for the restoration of these mislocated holes. See attached photo for further details.

2) OBG Seg 9BE:

This QA inspector performed MT of approximately 15% of the base metal repaired area (4nos of mis-located

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

holes) 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.

Earlier on dt: 08/20/10, weld repair was done (as per WRR: B-WR-14630 Rev-0) for the restoration of these mislocated holes. See attached photo for further details.

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-004 and 005. The welders are identified as 067665 and 067829 and were 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.

OBG Seg 10 BW:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SP165-001-005 to 012. The welder is identified as 040704 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: BP103-001-031 to 042. The welder is identified as 202384 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 10AW:

The FCAW process on weld joint no's: SP164-001-024 to 036. The welder is identified as 040704 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

The FCAW process on weld joint no's: BP102-001-043 to 054. The welder is identified as 202384 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-2132.

OBG Seg 9CW and Seg 9DW:

The SMAW process on weld joint no: DP673-001-019. The welder is identified as 041713 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: 485-SMAW-3G(3F)-Repair-1.

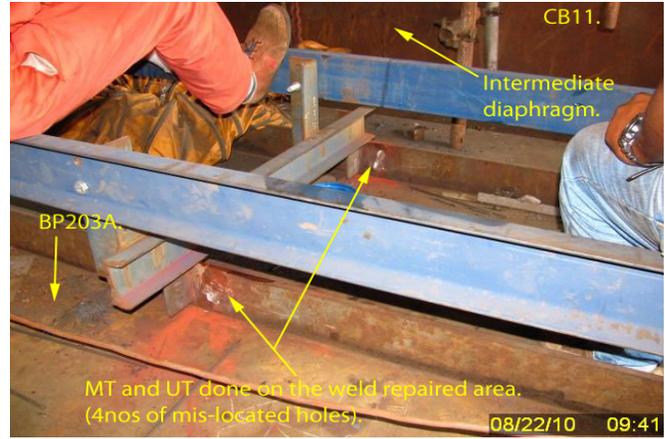
OBG Seg 10AE and Seg 10BE:

The FCAW process on weld joint no: OBE10-002. The welder is identified as 044473 and was observed welding in the 1G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: B-T-223(1)-T.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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