

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-011441**Date Inspected:** 07-Jan-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:** Xu Xian Ping**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 Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

Non-Destructive Testing:

Magnetic Particle Testing (MT) pursuant to NDT Inspection Notification Sheet (Document No. 005013):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. BK001-047-046
2. BK001-046-046
3. BK001-043-046
4. BK001-045-046
5. BK001-044-046
6. BK001-042-046

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet (Document No. 005013 and 005018):

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This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as Tower and OBG Components. The weld designations reviewed are as follows:

1. BK001-047-001~004
2. BK001-046-001~004
3. BK001-045-001~004
4. BK001-044-001~004
5. BK001-043-001~004
6. BK001-042-001~004
7. WSTL4-2B/L-61A/B

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 20TR1-005; Weld 003, 005. Welder is identified as 045209 and 048433. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-006; Weld 001, 003, 005. Welder is identified as 045209 and 048433. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-007; Weld 001, 003, 007. Welder is identified as 045209 and 048433. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-008; Weld 001. Welder is identified as 045209 and 048433. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

During random in process inspection, this QA Inspector observed the absence of any ZPMC QC for a period of 50 minutes. This QA Inspector requested of ABF QC Chen Ji Wei that he call the ZPMC QC, however he was unable to locate the assigned ZPMC QC Inspector. This QA Inspector generated an Incident Report for this date. The item and weld designation of the items welded without QC presence are as follows:

1. 20TR1-005-003
2. 20TR1-006-003, 001, 005
3. 20TR1-007-003, 001, 007
4. 20TR1-008-001

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

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No relevant conversations.

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 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
