

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-014223**Date Inspected:** 20-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:

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet (Document No. 005085 AND 005094):

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 OBG Components. The weld designations reviewed are as follows:

- | | | |
|----------------|----------------|----------------|
| 1. 13TB94-001 | 2. 13TB39-001 | 3. 13TB4-001 |
| 4. 13TB23-001 | 5. 13TB89-001 | 6. 13TB19-001 |
| 7. 13TB43-001 | 8. 13TB76-001 | 9. 13TB28-001 |
| 10. 13TB59-001 | 11. 13TB74-001 | 12. 13TB24-001 |
| 13. 13TB2-001 | 14. 13TB68-001 | 15. 13TB56-001 |
| 16. 13TB86-001 | 17. 13TB31-001 | 18. 13TB47-001 |
| 19. 13TB22-001 | 20. 13TB34-001 | 21. 13TB62-001 |
| 22. 13TB39-001 | 23. 13TB88-001 | 24. 13TB67-001 |
| 25. 13TB93-001 | 26. 13TB66-001 | 27. 13TB49-001 |

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28. DP3047-001-021

29. DP3048-001-016

This QA Inspector observed the following work in progress:

BAY 1:

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR9986 (for ZPMC UT Reject) of 11TR1-029; Weld 014. Welder is identified as 045227. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR9985 (for ZPMC UT Reject) of 11TR1-029; Weld 005. Welder is identified as 058245. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR9989 (for ZPMC UT Reject) of 11TR1-025; Weld 014. Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.

Flux Cored Arc Welding (FCAW) of 20TR1-009; Weld 001. Welder is identified as 050316. ZPMC Quality Control (QC) is identified as Zhan Hai 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 20TR1-012; Weld 003. Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Zhan Hai 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, 005. Welder is identified as 062708 and 207465. ZPMC Quality Control (QC) is identified as Zhan Hai 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.

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

Summary of Conversations:

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.

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