

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-011775**Date Inspected:** 03-Feb-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:		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine 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(s) (Document No. 005170):

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 Deck Panel. The weld designations reviewed are as follows:

1. DP-3045-001; weld 026
2. DP-3006-001; weld 026

Ultrasonic Testing (UT) pursuant to NDT Inspection Notification Sheet(s) (Document No. 005175):

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

members are identified as OBG Sub Assemblies. The weld designations reviewed are as follows:

1. TR1A- PP43-3GK
2. TR2A- PP46- 002
3. TR2A- PP44- 002
4. TR2A- PP40- 002
5. TR1A- PP45- 3GK

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 21TR4-002; Weld 003. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 21TR4-001; Weld 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 21TR4-001; Weld 001. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) of 21TR2-002; Weld 001. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Guo Yuan Ting. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

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

Inspected By:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
