

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-013169**Date Inspected:** 16-Apr-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. QA Inspector observed and/or found the following:

In Process Inspections**Bay 9**

This inspector witnessed fit up and tack welding of 2 deck panels for the lift 13W mock up. The welder was identified as 059373. The welding procedure was identified as WPS-2342-U5 (U-Rib).

Bay 7

This inspector witnessed carbon arc gouging of weld repairs on traveler rail 22TR3-004 per B-WR11844.

Bay 1

This inspector witnessed welding of traveler rail 20TR1-038-003. The welder was identified as 216872. The welding procedure was identified as WPS-B-T-2231-Tc-U5-F. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed welding of traveler rail 20TR2-042-011. The welder was identified as 059450. The

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welding procedure was identified as WPS-B-T-2231-Tc-U5-F. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed weld repair of traveler rail 20TR1-025-001 per B- WR- 11766. The welder was identified as 216575. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed weld repair of traveler rail 20TR1-025-003 per B- WR- 11767. The welder was identified as 216575. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed weld repair of traveler rail 20TR1-025-005 per B- WR- 11768. The welder was identified as 216575. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed weld repair of traveler rail 20TR1-025-007 per B- WR- 11769. The welder was identified as 216575. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

Bay 2

This inspector witnessed weld repair of traveler rail 20TR1-007-005 per B- WR- 11941. The welder was identified as 045276. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Yang Qing Feng.

This inspector witnessed weld repair of traveler rail 20TR1-002-005 per B- WR- 11985. The welder was identified as 045209. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

This inspector witnessed weld repair of traveler rail 20TR1-008-001 per B- WR- 11951. The welder was identified as 216575. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xiang Feng Feng.

Bay 5

This inspector performed Visual Testing, VT, in accordance with NWIT #005531 on 50% of the OBG cable trays listed on the document for acceptance. Any discrepancy noted by this inspector was immediately rectified by ZPMC personnel. For more information on this inspection, see the NWIT mentioned above.

This inspector performed conventional ultrasonic examination, UT, on the following floor beam welds listed below:

FB3058-53-005,006,013,019; FB3058-54-013,022; FB3058-55-016,022. This inspection was after ZPMC and ABF UT inspections. No additional indications were recorded by this inspector. For more information on this UT inspection, see the ABF UT report for these welds.

Unless otherwise noted, all work performed on this day appeared to comply with the applicable contract

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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.

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