

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-013475**Date Inspected:** 23-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:** Li Yang**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:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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:

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

SSD27-PP56 – 021, 047, 221

SSD27-PP57 – 103

SP613-001 – 048

Trial Assembly

This QA Inspector observed ZPMC welding personals identified as 062029 performing Base metal repair welding on areas where temporary attachments were removed using Shielded Metal Arc welding (SMAW) on 7CE side plate bike path side. ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair 1 and B-WR11052

8AE – 8BE Transverse splice

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This QA Inspector observed ZPMC welding personals identified as 220066, 222396 and 220069 performing Shielded Metal Arc welding (SMAW) on OBE8B – 003(8AE – 8BE bottom plate splice). ZPMC QC is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231T and WPS – B – T – 2233T

7EE

This QA Inspector observed ZPMC welding personals identified as 051359 performing repair welding using Shielded Metal Arc welding (SMAW) on 7EE Deck plate to Edge plate longitudinal splice on Crossbeam side. ZPMC QC is identified as Cai Xiao Feng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair 1 and B-CWR1385

NDT Observation

ZPMC performing MT on areas where temporary attachments were removed on 7BW – 7CW transverse Deck plate splice

ABF Inspectors performing MT on 7DE – 7EE T-Rib splice on Side plate and bottom plate

ABF Inspectors performing UT utilizing Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure on 7DE – 7EE Deck plate splice

This QA Inspector was involved in PAUT (Phased Array Ultrasonic Testing) training for detection of cracked tacks in Deck Panels as per the following procedure “UT 04-0120F4 PJP Rib Weld Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds”

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.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
