

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-013478**Date Inspected:** 22-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:

NDT Inspections

This inspector performed conventional ultrasonic testing, UT, on the following welds in the trial assembly yard:

Section 10AW, deck plate to edge plate. This weld is identified as CA071-004. This inspection was in conjunction with ABF UT personnel and after observing both MT and UT inspections by ABF. No additional indications were noted by this inspector at the time of testing.

In Process Inspections

Repair welding of traveler rail 11TR10-001 in accordance with B-CWR 1340. The welder was identified as 054459, and the WPS was identified as 345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Zhao Cheng Jian.

This inspector witnessed weld repair of traveler rail 20TR1-014-005 per B- WR- 11805. The welder was identified as 045270. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC

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was identified as Mr. Yang Qing Feng.

This inspector witnessed weld repair of traveler rail 20TR1-003-003 per B- WR- 11988. 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.

Unless otherwise noted, all work performed on this day appeared to comply 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:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
