

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-014221**Date Inspected:** 07-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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 pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005681):

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

BK004A3-056; WELD(S) 012~014, 048, 053~056

BK004A4-056; WELD(S) 053~055, 027~029, 001~003

BK004A7-056; WELD(S) 003~006, 053, 054, 059, 029, 030, 035, 186~189, 190~193, 027, 028, 033, 015, 016, 021, 017, 018, 023

Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005682):

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Magnetic Particle Testing:

This QA Inspector arrived pursuant to the above mentioned Non-Destructive Inspection Notification Sheet for the performance of Magnetic Particle Testing (MT) and Visual Testing (VT) at 09:30 hrs. as requested, to find that Visual Inspection and repair had not been performed and that ABF QC Technicians had substantially marked the members listed on the notification sheet for VT repairs, including additional welding. This QA Inspector performed VT of the relevant members, and found them to be requiring additional welding and grinding. Additionally, ZPMC MT Technicians had not signed off on their MT performance for the parts to be inspected. ZPMC QC representative (CWI) identified as Li Jia and ABF QC representative identified as Chang Bao Qian cancelled the notification for correction. ZPMC QA representative identified as Zhang Wei officially cancelled this notification for inspection.

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