

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-014600**Date Inspected:** 04-Jun-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:** Guo Yan Fei**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**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 09, Deck Panel 13BW-DP3132-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13BW-DP3132-001, 10 ribs, 20 welds, 126 total tack welds inspected.

Weld 1 scanned 9 locations with 2 indications.

Weld 2 scanned 9 locations with 0 indications.

Weld 3 scanned 9 locations with 1 indication.

Weld 4 scanned 9 locations with 0 indications.

Weld 5 scanned 9 locations with 2 indications.

Weld 6 scanned 9 locations with 2 indications.

Weld 7 scanned 9 locations with 0 indications.

Weld 171 scanned 9 locations with 2 indications.

Weld 172 scanned 9 locations with 0 indications.

Weld 173 scanned 9 locations with 2 indication.

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Weld 174 scanned 9 locations with 0 indications.

Weld 175 scanned 9 locations with 0 indications.

Weld 176 scanned 9 locations with 0 indications.

Weld 177 scanned 9 locations with 0 indication.

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 9, U-rib Internal Cover Plate

FCAW welding of weld joint 235 located on DP3103-001.

Welder is identified as 059443. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 32 located on DP3103-001.

Welder is identified as 059443. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 249 located on DP3103-001.

Welder is identified as 062265. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 88 located on DP3103-001.

Welder is identified as 062265. ZPMC CWI is identified as Mr. Guo Yan Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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:	Gaikwad,Umesh	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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