

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-014774**Date Inspected:** 12-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:** Yang Bai Qiang**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:

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

Bay 9

DECK PANEL 13CW-DP3144-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 001, 229 & 237. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 002, 231 & 238. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 003, 230 & 239. Welder(s)

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are identified as 059378. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 004, 232 & 240. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 005, 233 & 241. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 006, 235 & 242. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 007, 234 & 243. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3144-001; Weld(s) 008, 236 & 244. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

DECK PANEL 13CW-DP3152-001

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 001, 138 & 176. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 002, 139 & 177. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 003, 173 & 178. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 004, 174 & 180. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as

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WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 005, 140 & 179. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding (GMAW) of DP3152-001; Weld(s) 006, 141 & 181. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

U-rib Internal Cover Plate

FCAW welding of weld joint 197 located on DP3087-001.

Welder is identified as 059403. ZPMC CWI is identified as Mr. Yang Bai Qiang.

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

FCAW welding of weld joint 106 located on DP3093-001.

Welder is identified as 062259. ZPMC QC is identified as Mr. Yang Bai Qiang.

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