

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-014776**Date Inspected:** 14-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:

OBG Bay 09, Deck Panel 13CW-DP3144-001

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are as follows.

DP3144-001-001~008, 229~244

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

Bay 9, U-rib Internal Cover Plate

FCAW welding of weld joint 108 located on DP3089-001.

Welder is identified as 059464. 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.

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FCAW welding of weld joint 110 located on DP3089-001.

Welder is identified as 059464. ZPMC QC is identified as Mr. Yang Bai Qiang.

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

FCAW welding of weld joint 109 located on DP3089-001.

Welder is identified as 059464. 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 111 located on DP3089-001.

Welder is identified as 059464. ZPMC CWI is identified as Mr. Yang Bai Qiang.

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

13CW-DP3151-001

During random in process inspection this QA Inspector observed tack welding of closed U-rib to deck plate by GMAW process in progress on the weld joints of deck panel 13CW-DP3151-001. Welder is identified as 062305. ZPMC CWI is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2342-U5(Urib).

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