DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-014957
Date Inspected: 18-Jun-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	Chen Shi Gang			**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-DP3148-001
Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3148-001; Weld(s) 001, 011 & 021. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 002, 012 & 022. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 003, 013 & 023. Welder(s)

are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 004, 014 & 024. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 005, 015 & 025. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 006, 016 & 026. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 007, 017 & 027. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 DP3148-001; Weld(s) 008, 018 & 028. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. 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 13W-Mock/Mu3-001
Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 001 & 011. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 002 & 012. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 003 & 013. Welder(s) are identified as 059404. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 004 & 014. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 005 & 015. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 006 & 016. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 007 & 017. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 008 & 018. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 009 & 019. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc Welding and Submerged Arc Welding(GMAW/SAW) of Mu3-001; Weld(s) 010 & 020. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Mr. Duan Ya Bing. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-4. Welding appears to conform to the requirements of the WPS used.

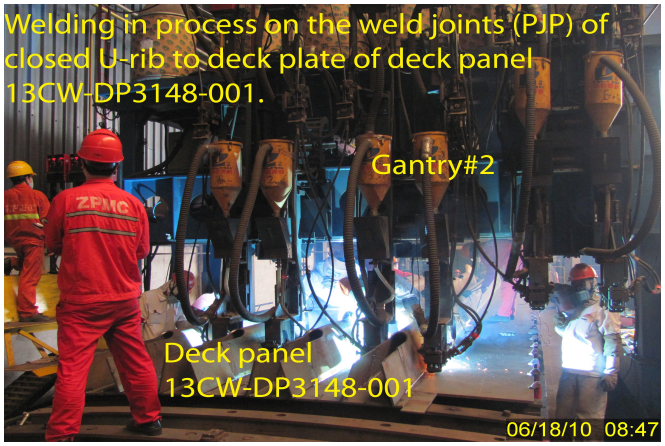
U-rib Internal Cover Plate
FCAW welding of weld joint 273 located on DP3013-001.
Welder is identified as 059403. ZPMC CWI is identified as Mr. Chen Shi Gang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 204 located on DP3012-001.
Welder is identified as 062259. ZPMC QC is identified as Mr. Chen Shi Gang.
The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

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
Reviewed By:	Clifford,William	QA Reviewer