

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-015085**Date Inspected:** 21-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:** 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:

OBG Bay 04, Deck Panel 13BE-DP3088-001

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 13BE-DP3088-001, 10 ribs, 20 welds, 180 total tack welds inspected.

Weld 001 scanned 9 locations with 1 indication.

Weld 002 scanned 9 locations with 0 indications.

Weld 003 scanned 9 locations with 0 indications.

Weld 004 scanned 9 locations with 0 indications.

Weld 005 scanned 9 locations with 0 indications.

Weld 006 scanned 9 locations with 1 indication.

Weld 007 scanned 9 locations with 2 indications.

Weld 171 scanned 9 locations with 0 indications.

Weld 172 scanned 9 locations with 1 indication.

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Weld 173 scanned 9 locations with 0 indication.

Weld 174 scanned 9 locations with 0 indication.

Weld 175 scanned 9 locations with 0 indications.

Weld 176 scanned 9 locations with 1 indication.

Weld 177 scanned 9 locations with 2 indications.

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

BAY 09, U-rib Internal Cover Plate

FCAW welding of weld joint 216 located on DP3104-001.

Welder is identified as 062259. 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 214 located on DP3104-001.

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.

FCAW welding of weld joint 184 located on DP3104-001.

Welder is identified as 201840. 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 182 located on DP3104-001.

Welder is identified as 201840. ZPMC QC is identified as Mr. Chen Shi Gang.

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

FCAW welding of weld joint 279 located on DP3101-001.

Welder is identified as 062259. 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 208 located on DP3101-001.

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.

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

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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:	Carreon,Albert	QA Reviewer
