

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-015396**Date Inspected:** 30-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:** Bay 9, Bay4**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 9

ZPMC NWIT 006093

OBG U – Rib Diaphragm

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

DP 3106B – 001 – 167, 168, 171, 172

DP 3100 – 001 – 225, 226

DP 3106 – 001 – 171, 172

DP 3107 – 001 – 167, 168

DP 3099 – 001 – 169, 170

DP 3105 – 001 – 167, 168

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Tack Welding

DP3102 – 001 (13CE)

This QA Inspector observed ZPMC welding personals identified as 059472, 059336 performing Gas Metal Arc welding (GMAW) tack welding on DP3102-001(PL3198 A/B/C) deck plate to U-rib. ZPMC QC is identified as Zhu Zhong Jie. The welding variables recorded by QC appeared to comply with the WPS-345-B-T-2342 U5b (U-Rib).

DP 3104 – 001 (13CE)

This QA Inspector observed ZPMC welding personals identified as 059440, 059366 performing Gas Metal Arc welding (GMAW) tack welding on DP3104-001(PL3200 A/B/C) deck plate to U-rib. ZPMC QC is identified as Zhu Zhong Jie. The welding variables recorded by QC appeared to comply with the WPS-345-B-T-2342 U5b (U-Rib).

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

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:	Dsouza,Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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