

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-015432**Date Inspected:** 26-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:

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

Bay 9

DECK PANEL 13BE-DP3086-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3086-001; Weld(s) 001 & 111. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Mr. 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 DP3086-001; Weld(s) 002 & 112. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Mr. 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 DP3086-001; Weld(s) 003 & 113. Welder(s) are

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identified as 059416. ZPMC Quality Control (QC) is identified as Mr. 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 DP3086-001; Weld(s) 004 & 114. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. 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 DP3086-001; Weld(s) 005 & 115. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. 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 DP3086-001; Weld(s) 006 & 116. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. 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 13BE-DP3089-001

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 001 & 009. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 002 & 010. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 003 & 011. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 004 & 012. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 005 & 013. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 006 & 014. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. 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.

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Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 007 & 015. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Mr. 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.

Submerged Arc Welding(SAW) of DP3089-001; Weld(s) 008 & 016. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Mr. 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.

During production welding due to some malfunctioning the arc has been stopped at various locations for various weld joints. ZPMC and AB/F marked those locations & before start the production welding ZPMC NDT personnel Mr. Wang Wei carried out Magnetic Particle Testing (MT) at the "Arc stop" locations of the weld to confirm the complete removal of crack from the "Arc stop" locations. The locations & respective weld identification are as follows

- DP3086-001-115; Y location: 57mm.
- DP3086-001-116; Y location: 420mm.
- DP3086-001-005, 006; Y location: 4500mm
- Dp3089-001-009, 010; Y location: 0mm

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: Carreon,Albert

QA Reviewer