

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-015818**Date Inspected:** 18-Jul-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:

Bay # 04, OBG Deck Panel (NWIT # 6222)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) and green tagging of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

DP3125-001-001~006 (Green Tag No. # 11867)

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

BAY 04, DECK PANEL REPAIR

13CW-DP3147-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair excavation by grinding on PAUT repair locations. ZPMC CWI is identified as Mr. Yang Bai Qiang. The repair

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excavation details are as follows:

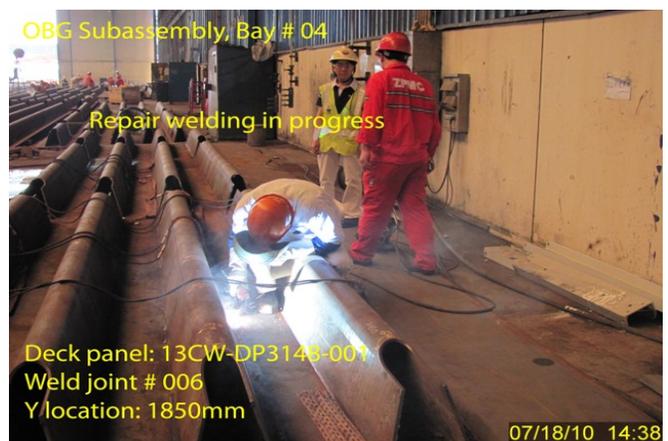
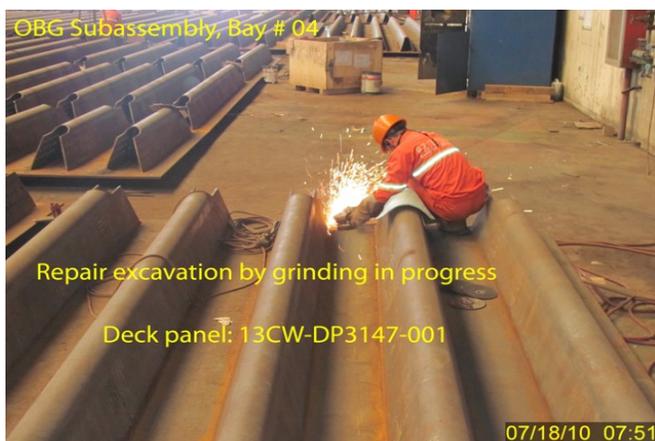
- Weld: 002; Y location: 1850, 3650
- Weld: 004; Y location: 4850
- Weld: 006; Y location: 4850, 4250
- Weld: 008; Y location: 4250
- Weld: 282; Y location: 3050
- Weld: 283; Y location: 1850
- Weld: 287; Y location: 50, 650
- Weld: 296; Y location: 2350

13CW-DP3148-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13BW-DP3134-001. Welder is identified as 203805. ZPMC CWI is identified as Mr. Guo Yan Fei. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows:

- Weld: 002; Y location: 2450, 4800
- Weld: 004; Y location: 2450, 3050
- Weld: 005; Y location: 650, 1250, 1850, 3050
- Weld: 006; Y location: 50, 1850, 4800
- Weld: 007; Y location: 50
- Weld: 008; Y location: 50, 3650
- Weld: 015; Y location: 50, 650, 1250, 1850

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

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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
