

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-016289**Date Inspected:** 17-Aug-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 Xi**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 # 03, OBG 13/14 LIFTING (NWIT # 06415)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

SA3091-001-001

SA3093-001-001

FB3150-001-135, 136, 089, 087, 085, 083, 144, 036, 006

FB3279-001-001~004, 082

BAY # 02, OBG FLOOR BEAM (NWIT # 06417)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FB3210-001-023
FB3221-001-026
FB3225-001-023
FB3214-001-023
FB3228-001-026
FB3234-001-023
FB3205-001-023
FB3218-001-026
FB3181-001-013
FB3196-001-014
FB3173-001-022
FB3228-002-023

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

BAY 02, OBG Lift 14, Floor Beam

FCAW welding of weld joint 001 located on FB3317-001.

Welder is identified as 045209. ZPMC CWI is identified as Mr. Chen Xi.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F-1.

SAW welding of weld joint 007 located on FB3321-001.

Welder is identified as 045265. ZPMC QC is identified as Mr. Zhu Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 003 located on SA3158-001.

Welder is identified as 045240. ZPMC QC is identified as Mr. Zhu Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint 009 located on SA3180-001.

Welder is identified as 045203. ZPMC QC is identified as Mr. Zhu Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

BAY 03, LONGITUDINAL DIAPHRAGM

FCAW welding of weld joint 182 located on LD3025-001.

Welder is identified as 052696. ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 028 located on LD3028-001.

Welder is identified as 044830. ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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:	Carreon,Albert	QA Reviewer
