

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-012111**Date Inspected:** 07-Feb-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:	Xu Xian Ping	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:		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine 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.

Non-Destructive Testing:

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel in accordance with Notification #005189. All welds inspected appear to conform to the contract documents. The members are identified as OBG Assemblies. The weld designations reviewed are as follows:

OBG Segment 5E Drip Plate Welds:

OBE5B-001
OBE5B-006
OBE5C-014
OBE5C-011

OBG Bike Path Cantilever Assembly:

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Weld BK001-024-009

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of 21TR4-003; Weld 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Tian Lei. Weld Procedure Specification, (WPS), is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report #B-WR10300 (for ZPMC UT Reject) of 10TR1-016; Weld 014. Welder is identified as 066041. ZPMC Quality Control (QC) is identified as Zhong Dian Xing. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-2G(2F)-Repair-1. Welding appears to conform to the requirements of the WPS and WRR used.



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:	Barrentine, Daniel	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
