

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-013167**Date Inspected:** 14-Apr-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. QA Inspector observed and/or found the following:

NDE Inspections:

This inspector performed conventional ultrasonic examination, UT, on Section 7BW to 7CW Transverse splice, at the cross beam side, side plate joint. This weld is identified as. This inspection was after ZPMC and ABF UT inspections, and to verify the indications found during these inspections. No additional indications were recorded by this inspector. For more information on this UT inspection, see the ABF UT report for this weld.

This inspector performed conventional ultrasonic examination, UT, on Section 7BW to 7CW Transverse splice, at the bottom plate joint. This weld is identified as. This inspection was after ZPMC and ABF UT inspections, and to verify the indications found during these inspections. No additional indications were recorded by this inspector. For more information on this UT inspection, see the ABF UT report for this weld.

In Process Inspections**Bay 8**

This inspector witnessed weld build up of traveler rail 11TR8-001 per B-CWR1340. The welder was identified as

WELDING INSPECTION REPORT

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219414. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Guo Yan Fei.

This inspector witnessed weld build up of traveler rail 11TR10-001 per B-CWR1340. The welder was identified as 054460. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Guo Yan Fei.

This inspector witnessed weld repair of traveler rail 10TR1-027 per B-WR11833. The welder was identified as 054459. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Guo Yan Fei.

Bay 7

This inspector witnessed weld repair of traveler rail 10TR3-026 per B-WR1100. The welder was identified as 062447. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Xia Yong Zheng.

This inspector witnessed weld repair of traveler rail 10TR2-006-014 per B-WR11922. The welder was identified as 048625. The welding procedure was identified as WPS-345-FCAW-1G(1F)-Repair-1. ZPMC QC was identified as Mr. Guo Yan Fei.

Unless otherwise noted, all work performed on this day appeared to comply 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:	Barrentine,Daniel	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
