

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-013924**Date Inspected:** 10-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**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:

FCAW welding of ED1-A27B/E-44. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 052075.

FCAW welding of ED1-A27B/E-29. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 053116.

FCAW welding of ED1-A27B/E-31. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 040302.

FCAW welding of ED1-A27B/E-49. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 053870.

FCAW welding of ED1-A27B/E-21. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 204868.

FCAW welding of ED1-A27B/E-23. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The

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welder was identified as 054069.

FCAW welding of ED1-A27B/E-37. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 053869.

FCAW welding of root pass in ND1-A26B/B-60. The Welding Procedure was identified as WPS-B-T-2331-Tc-P4-F. The welder was identified as 040533.

The ZPMC QC for the above mentioned welding operations was identified as Jiang Xiao Bo.

The ZPMC CWI for the above mentioned welding operations was identified as Li Jun.

This inspector witnessed ABF UT technicians performing conventional ultrasonic testing, UT, at the section 8AE bottom plate to side plate weld identified at this time as being "E2 and E4". The technician numbers were identified as S019 and S023.

SMAW tack welding of section 8CW to DW sideplate temporary attachments for fit up by welder 067942, bottom plate temporary attachments by welder 067665, and cross beam side plate temporary attachments by welder 07656.

The Welding Procedure was identified as WPS-B-T-2114-FCM-1.

Welding on section 8BW, counter weight side, deck plate to edge plate by welder 045221. The welding procedure was identified as WPS-B-P-2112-FCM-1.

Welding on sections 7DW to EW sideplate weld, (OBW7C-010), by welder 045196 in accordance with B-WR12754. The welding procedure was identified as WPS-345-SMAW-4G-(4F)-FCM-Repair.

The ZPMC QC for the above mentioned welding operations was identified as Cai Xiao Feng.

The ZPMC CWI for the above mentioned welding operations was identified as Li Yang.

Weld repair of MT indications was observed in the heave dock area by welder 057220. The welding procedure was identified as WPS-345-SMAW-1G(1F)-Repair. The ABF MT operator was identified as You Yong Liang. The ZPMC QC for the above mentioned operation was identified as Fu Wei Min. The ZPMC CWI for the above mentioned operation was identified as Ye Yong Jun.

Unless otherwise noted, all work observed on this date appeared to be in general compliance 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.

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