

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-014037**Date Inspected:** 13-May-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:** Li Yang**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:** Trial Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza 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:

Trial Assembly

ZPMC NWIT 005722

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QA Inspector observed no rejectable indications at the time of testing. Weld identification numbers were

CA039 – 005 (7CE CA Holdback)

CA040 – 001 (8CE CA Holdback)

CA042 – 001 (7DE CA Holdback)

SEG040A – 039 (7DE CA Holdback)

SEG046B – 006, 024 (8BE LD Where Split)

SEG046C – 001, 009 (8BE LD Where Split)

7CW – 7DW SP CW side

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This QA Inspector observed ZPMC welding personals identified as 066371 performing Shielded Metal Arc welding (SMAW) on OBW7C - 002. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) – FCM – Repair 1 and B-CWR1524 R0

7CW – 7DW BP

This QA Inspector observed ZPMC welding personals identified as 045246 performing Shielded Metal Arc welding (SMAW) on OBW7C - 003. ZPMC QC is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) – FCM – Repair 1 and B-CWR1524 R0

8BE – 8CE SP BK side

This QA Inspector observed ZPMC welding personals identified as 054467, 053753 performing Shielded Metal Arc welding (SMAW) on OBW8C – 004, 005. ZPMC QC is identified as Liu Hua Jie The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) – FCM – Repair 1 and B-CWR1525

(Base Metal Repair)

8AW – 8BW Transverse Splice

This QA Inspector observed ZPMC welding personals identified as 067765 performing base metal repair utilizing Shielded Metal Arc welding (SMAW) on 8AW+8BW Transverse splice deck plate. ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) – FCM – Repair 1 and B-CWR1414

8BW – 8CW (Deck Plate)

This QA Inspector observed ZPMC welding personals identified as 045265 and 045270 performing Submerged Arc welding (SAW) on 8BW – 8CW deck plate OBW8A – 003. ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – T – 223(2)1T – 2

This QA Inspector observed ZPMC welding personals identified as 037840 performing Shielded Metal Arc welding (SMAW) on CA044 - 002. ZPMC QC is identified as Wang Zhu. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2212 – Tc – U4b – FCM - 1

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

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remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza, Christopher	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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