

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-014207**Date Inspected:** 14-Mar-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:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes 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 (NDT):

Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005340):

Ultrasonic Testing:

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

USPL1-332-001, 002
USPL1-338-001, 002
USPL1-354-001, 002
USPL1-355-001, 002
USPL1-356-001, 002
USPL1-371-001, 002

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Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005339):

Ultrasonic Testing:

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

TR6A-PP042-002
TR6A-PP040-002
TR5B-PP041-004
TR1D-PP039-007
TR5C-PP037-005

Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005339):

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

TR6A-PP042-002
TR6A-PP040-002
TR5B-PP041-004
TR1D-PP039-007
TR5C-PP037-005

This QA Inspector observed the following work in progress:

BAY 1:

Flux Cored Arc Welding (FCAW) of 20TR1-022; Weld(s) 007. Welder(s) are identified as 219188. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-038; Weld(s) 001 and 003. Welder(s) are identified as 059450. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

BAY 2:

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Flux Cored Arc Welding (FCAW) of 10TR2-022; Weld(s) 014. Welder(s) are identified as 045203. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 10TR1-026; Weld(s) 014. Welder(s) are identified as 045209. ZPMC Quality Control (QC) is identified as Yang Qing Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

BAY 5:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair #B-CWR1100 (Buttering for length) of 11TR3-016. Welder(s) are identified as 215248. ZPMC Quality Control (QC) is identified as Shen Jian Guo. 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 CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair #B-CWR1102 (Buttering for length) of 11TR3-004. Welder(s) are identified as 222387 and 204342. ZPMC Quality Control (QC) is identified as Shen Jian Guo. 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 CWR used.

BAY 6:

Flux Cored Arc Welding (FCAW) of USPL1-378; Weld(s) 001 and 002. Welder(s) are identified as 066695. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of USPL1-379; Weld(s) 001 and 002. Welder(s) are identified as 217185. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of USPL1-380; Weld(s) 001 and 002. Welder(s) are identified as 053609. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U4b-F. Welding appears to conform to the requirements of the WPS used.

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:	Holmes,Stefan	Quality Assurance Inspector
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Reviewed By:	Hall,Steven	QA Reviewer
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