

**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-014467**Date Inspected:** 27-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:** Sun Bo**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 pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 005838):

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:

DP3078-001-194, 195, 184, 185, 174, 175, 164, 165.

DP3147-001-277~280.

DP3102-001-080, 081, 090, 091, 100, 101, 110, 111.

This QA Inspector observed the following work in progress:

BAY 6:

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# WELDING INSPECTION REPORT

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Submerged Arc Welding (SAW) of WJF-0; Weld(s) 192. Welder(s) are identified as 053748. ZPMC Quality Control (QC) is identified as Wang Liang. Weld Procedure Specification (WPS) is identified as WPS-B-T-3321-TC-U4a-S-1. Welding appears to conform to the requirements of the WPS used.

BAY 7:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair B-CWR 1374 (for buttering) of 22TR3-002. Welder(s) are identified as 062447. ZPMC Quality Control (QC) is identified as Wang Liang. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair B-CWR 1374 (for buttering) of 22TR4-001. Welder(s) are identified as 048625. ZPMC Quality Control (QC) is identified as Wang Liang. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS used.

BAY 8:

Flux Cored Arc Welding (FCAW) of CB3001A-017; Weld(s) 014. Welder(s) are identified as 054459 and 054460. ZPMC Quality Control (QC) is identified as Liu Chuan Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2232-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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<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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