

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-015433**Date Inspected:** 27-Jun-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	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Bay 04, Deck Panel 13BE-DP3086-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 13BE-DP3086-001, 6 ribs, 12 welds, 108 total tack welds inspected.

Weld 001 scanned 9 locations with 2 indications.
Weld 002 scanned 9 locations with 2 indications.
Weld 003 scanned 9 locations with 2 indications.
Weld 004 scanned 9 locations with 0 indications.
Weld 005 scanned 9 locations with 1 indication.
Weld 006 scanned 9 locations with 0 indications.
Weld 111 scanned 9 locations with 1 indication.
Weld 112 scanned 9 locations with 2 indications.
Weld 113 scanned 9 locations with 2 indications.

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Weld 114 scanned 9 locations with 2 indications.

Weld 115 scanned 9 locations with 1 indication.

Weld 116 scanned 9 locations with 1 indication.

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 04, 13AE-DP3077-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing excavation on PAUT repair area. ZPMC QC is identified as Mr. Zhao Cheng Jian. The repair excavation details are as follows.

Weld: 001; Y location: 5250, 7050, 10050

Weld: 002; Y location: 10050, 12450

Weld: 003; Y location: 5850, 8850

Weld: 004; Y location: 50, 2250, 2850, 4650, 6450, 7050, 8250, 10050, 11250

Weld: 005; Y location: 10650

Weld: 006; Y location: 1650, 4650, 8850, 11850, 12450

13AE-DP3075-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding (root pass) on the Partial Joint Penetration (PJP) weld joints of deck panel 13AE-DP3075-001. Welder is identified as 062265. ZPMC QC is identified as Mr. Zhao Cheng Jian. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 002; Y location: 6950

Weld: 003; Y location: 7550, 11750, 13950

Weld: 004; Y location: 7750, 9350

Weld: 005; Y location: 7550

Weld: 007; Y location: 8150

Weld: 008; Y location: 8750, 9350

Weld: 010; Y location: 5250, 5750, 6350, 7550

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer