

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-015434**Date Inspected:** 28-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:** Chen Shi Gang**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:

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

BAY 04, DECK PANEL REPAIR

13AE-DP3079-001

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

Weld: 002; Y location: 50

Weld: 003; Y location: 2350, 4150, 5950, 13150

Weld: 004; Y location: 550, 2950, 4150, 13950

Weld: 005; Y location: 5950, 6550

Weld: 006; Y location: 13950, 11950, 11350, 10750, 10150, 5350

Weld: 007; Y location: 13150

Weld: 008; Y location: 11350

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Weld: 009; Y location: 5950, 9550

13AE-DP3073-001

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-DP3073-001. Welder is identified as 069469. ZPMC QC is identified as Mr. Zhang Qiao. 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: 001; Y location: 2700, 3900

Weld: 002; Y location: 6300, 6900, 9900

Weld: 003; Y location: 900, 8100, 8700, 9300, 9900, 11000, 11600

Weld: 004; Y location: 2100, 3900

Weld: 005; Y location: 3900, 11600

Weld: 006; Y location: 3900, 4500, 5700, 8700, 9900

13AW-DP3119-001

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 13AW-DP3119-001. Welder is identified as 067250. ZPMC QC is identified as Mr. Zhang Qiao. 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: 001; Y location: 10550, 11050, 12650, 8450, 9550, 10050

Weld: 002; Y location: 12150, 12650, 5750

Weld: 003; Y location: 11050, 11650, 10050

Weld: 004; Y location: 13850, 13550, 9550, 10050, 10550, 5750, 6250

Weld: 005; Y location: 10550, 11050

Weld: 006; Y location: 12150, 11650, 9550, 8950, 10050, 10550, 11050, 11650

Weld: 007; Y location: 10550, 10050, 8950

Weld: 008; Y location: 12150, 11050, 10550, 13550, 10050, 9550, 8950

Weld: 010; Y location: 12650, 12150, 10050, 10550, 11650, 11050, 9550

13AW-DP3118-001

This QA inspector witnessed Magnetic Particle Testing (MT) performed by ZPMC MT technician Mr. Gu Yun Wu after root pass on the repair locations of weld joint of above mentioned deck panel. The repair area details are as follows.

Weld: 001; Y location: 13850

Weld: 002; Y location: 8850

Weld: 003; Y location: 550

Weld: 004; Y location: 6950, 8850, 13850

Weld: 006; Y location: 12950, 8850, 6950, 6450, 5250, 1750

Weld: 008; Y location: 13350, 10150, 8850, 7650

During excavation of the repair location of 13AE-DP3073-001, weld joint: 006, Y location: 11600; the root got

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opened. ZPMC could not provide the appropriate WPS for the open root repair area. So ZPMC did not proceed for further repair works.

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



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