

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-015442**Date Inspected:** 04-Jul-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, Yang Bai Qiang			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 9

DECK PANEL 13CE-DP3106-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3106-001 in process on gantry # 2. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 138, 176, 003, 173, 178; Welder # 059421

Weld Joint # 002, 139, 177, 004, 174, 180; Welder # 059418

Weld Joint # 005, 140, 179; Welder # 059378

Weld Joint # 006, 141, 181; Welder # 203805

DECK PANEL 13CE-DP3101-001

WELDING INSPECTION REPORT

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Gas Metal Arc Welding (GMAW) of DP3101-001 in process on gantry # 2. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 181, 291; Welder # 201788
Weld Joint # 002, 282, 292; Welder # 059416
Weld Joint # 003, 283, 293, 005, 285, 295; Welder # 059421
Weld Joint # 004, 284, 294, 006, 286, 296; Welder # 059418
Weld Joint # 007, 287, 297, 009, 289, 299; Welder # 059378
Weld Joint # 008, 288, 298, 010, 290, 300; Welder # 203805

During production welding due to some malfunctioning the arc has been stopped at various locations for two weld joints. ZPMC and AB/F marked those locations for grinding & before start the production welding Magnetic Particle Testing (MT) carried out by ZPMC NDT personnel Mr. Gu Yun Wu at the "Arc stop" locations of the weld to confirm the complete removal of crack from the "Arc stop" locations. The locations & respective weld identification are as follows

13CE-DP3101-001-003, 004; Y location: 3530mm.
13CE-DP3101-001-295; Y location: 300mm.
13CE-DP3101-001-296; Y location: 480mm.

BAY 04

13AE-DP3077-001

During random in process inspection this QA inspector observed that ZPMC personnel were performing repair welding on the Partial Joint Penetration (PJP) weld joints of deck panel 13AE-DP3077-001. Welder is identified as 062265. ZPMC CWI is identified as Mr. Yang Bai Qiang. 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: 550
Weld: 001; Y location: 4050, 5250, 10050
Weld: 003; Y location: 8850
Weld: 006; Y location: 8850
Weld: 004; Y location: 50, 2250, 2850, 4650, 6450, 7050

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 068916. ZPMC CWI is identified as Mr. Yang Bai Qiang. 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
Weld: 003; Y location: 11600

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Weld: 005; Y location: 3900, 11000

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
