

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-015445**Date Inspected:** 05-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:** 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:

OBG Bay 04, Deck Panel 13CE-DP3101-001

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 13CE-DP3101-001, 15 ribs, 30 welds, 230 total tack welds inspected.

Weld 001 scanned 9 locations with 0 indications.

Weld 002 scanned 9 locations with 0 indications.

Weld 003 scanned 9 locations with 0 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 007 scanned 9 locations with 1 indication.

Weld 008 scanned 9 locations with 0 indications.

Weld 009 scanned 9 locations with 1 indication.

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Weld 010 scanned 9 locations with 0 indications.
Weld 281 scanned 9 locations with 0 indications.
Weld 282 scanned 9 locations with 0 indications.
Weld 283 scanned 9 locations with 1 indication.
Weld 284 scanned 9 locations with 0 indications.
Weld 285 scanned 9 locations with 1 indication.
Weld 286 scanned 9 locations with 0 indications.
Weld 287 scanned 9 locations with 0 indications.
Weld 288 scanned 9 locations with 0 indications.
Weld 289 scanned 9 locations with 0 indications.
Weld 290 scanned 9 locations with 0 indications.
Weld 291 scanned 5 locations with 0 indications.
Weld 292 scanned 5 locations with 0 indications.
Weld 293 scanned 5 locations with 1 indication.
Weld 294 scanned 5 locations with 0 indications.
Weld 295 scanned 5 locations with 0 indications.
Weld 296 scanned 5 locations with 0 indications.
Weld 297 scanned 5 locations with 0 indications.
Weld 298 scanned 5 locations with 0 indications.
Weld 299 scanned 5 locations with 0 indications.
Weld 300 scanned 5 locations with 0 indications.

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

13AE-DP3079-001

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-DP3079-001. 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: 50
Weld: 003; Y location: 2350, 4150, 5950
Weld: 004; Y location: 4150, 2950, 550, 13950
Weld: 005; Y location: 1150, 5950, 6550
Weld: 006; Y location: 5350, 10150, 10750, 11350, 11950, 13950
Weld: 007; Y location: 13150
Weld: 008; Y location: 11350
Weld: 010; Y location: 5950, 9550

13AW-DP3123-001

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 13AW-DP3123-001. Welder is identified

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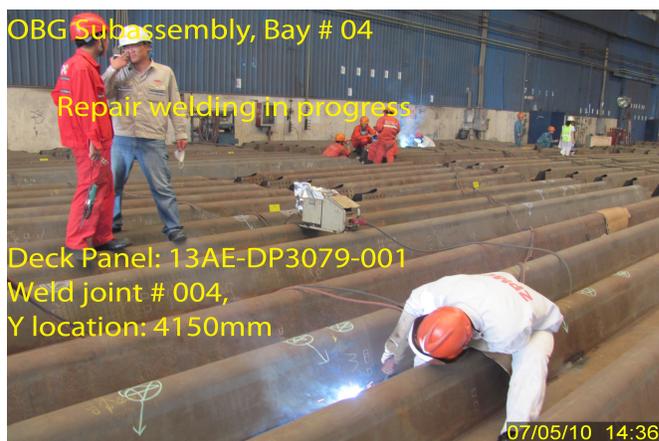
as 068916. ZPMC CWI is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-FCM-Repair. The repair area details are as follows.

Weld: 009; Y location: 11950

Weld: 007; Y location: 11950

Weld: 006; Y location: 7750, 8350, 13900

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