

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-016280**Date Inspected:** 07-Aug-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:** Li Jia, Huang Min**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:

BAY # 06, OBG TRAVELER RAIL BRACKET (NWIT # 06351)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

TR5B-PP081, 079, 077-003

TR5C-PP073-006

TR5D-PP075, 081-008

TR6A-PP084, 076-001

BAY # 06, OBG TRAVELER RAIL BRACKET (NWIT # 06351)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

follows:

TR5B-PP085, 083, 081, 079, 077, 075, 073-003

TR5C-PP073, 077, 079, 083, 085-006

TR6B-PP072, 078, 084-006

TR6C-PP074, 076, 080, 082-006

TR5D-PP075, 081-008

TR6A-PP084, 082, 080, 078, 076, 074, 072-001

BAY # 06, OBG Components (NWIT # 06351)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BP3054A-001-011~020 GREEN TAG NO. 13446

BP3055A-001-005~008 GREEN TAG NO. 13447

BP3051A-001-005~008 GREEN TAG NO. 13445

SP3085A-001-013~024 GREEN TAG NO. 13448

DP3115A-001-001~004 GREEN TAG NO. 13444

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

Bay # 08, OBG BIKE PATH

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Chang Fang Fie was performing Magnetic Particle Testing (MT) on the fillet welds of OBG bike path. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A6-054-094

BAY 07, Stiffener of Side Panel of Lift 13

FCAW welding of weld joint 36/37 located on SP3117F-001.

Welder is identified as 217185. ZPMC QC is identified as Mr. Cui Jun Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint 124/125 located on SP3141B-001.

Welder is identified as 217185. ZPMC QC is identified as Mr. Cui Jun Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

BAY 06, West Jacking Frame

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

SMAW welding of weld joint 23 located on WJF-0.

Welder is identified as 215083. ZPMC QC is identified as Mr. Xia Yong Zhang.

The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P4.

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