

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-016283**Date Inspected:** 10-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:** Guo Yan Fei, 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:

BAY # 09, OBG DECK PANEL (NWIT # 06375)

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:

DP3160-001-326, 329, 334, 337

DP3172-001-206, 209, 198, 201, 190, 193, 182, 185

DP3175-001-254, 257, 262, 265, 270, 273, 278, 281, 286, 289

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

Bay # 09, Continuity Plate of U-rib

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Liu Zhang Min was performing Magnetic Particle Testing (MT) on the weld joints of continuity plate of U-rib of OBG deck plate.

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The members are identified as OBG components and the weld designations reviewed are as follows.

DP3160-001-310~313, 318~321

DP3172-001

DP3175-001

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 068 located on DP3159-001.

Welder is identified as 201840. ZPMC CWI is identified as Mr. Chen Shi Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 112 located on DP3159-001.

Welder is identified as 059403. ZPMC CWI is identified as Mr. Chen Shi Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 180 located on DP3159-001.

Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 232 located on DP3159-001.

Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 070 located on DP3159-001.

Welder is identified as 201840. ZPMC CWI is identified as Mr. Chen Shi Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 114 located on DP3159-001.

Welder is identified as 059403. ZPMC CWI is identified as Mr. Chen Shi Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 182 located on DP3159-001.

Welder is identified as 059416. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 234 located on DP3159-001.

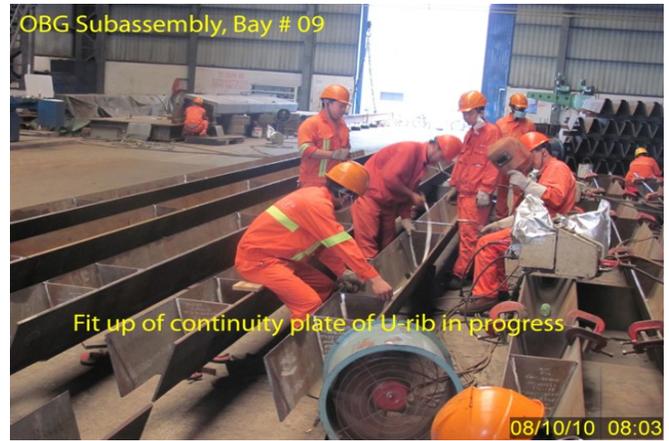
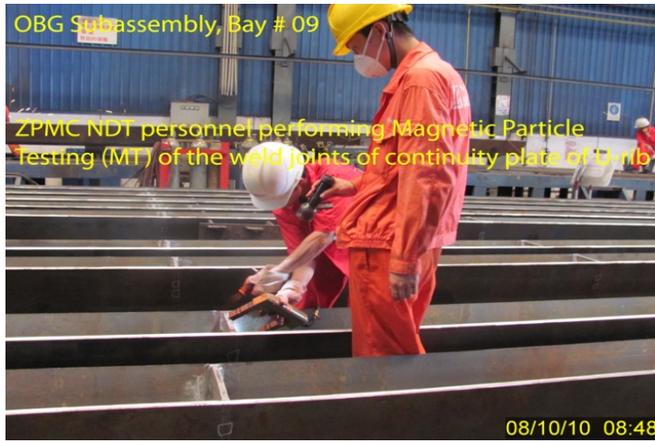
Welder is identified as 059421. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

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