

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-016284**Date Inspected:** 11-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:	Chen Shi Gang, 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 Components (NWIT # 06376)

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:

BP3052-001-011~020 GREEN TAG NO. 14350

SP3094-001-027, 028, 041, 042, 055, 056, 069, 070 GREEN TAG NO. 14351

SP3095-001-012, 022, 032, 042 GREEN TAG NO. 14352

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

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was performing Magnetic Particle Testing (MT) on the fillet welds of OBG bike path assemblies. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A6-061-074, 084

BK004A7-061-093~096, 170~173, 033~036

BAY 07, Bottom Plate of CB18

FCAW welding of weld joint 011 located on BP3053-001.

Welder is identified as 053609. ZPMC QC is identified as Mr. Cui Jun Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U3-F-2.

SAW welding of weld joint 022 located on BP3053-001.

Welder is identified as 054458. ZPMC QC is identified as Mr. Cui Jun Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

BAY 06, West Jacking Frame

SMAW welding of weld joint 101 located on WJF-0.

Welder is identified as 215083. ZPMC CWI is identified as Mr. Huang Min.

The welding variables recorded by QC appeared to comply with WPS-B-T-3313-Tc-P4.

SMAW welding of weld joint 118 located on WJF-0.

Welder is identified as 057795. ZPMC CWI is identified as Mr. Huang Min.

The welding variables recorded by QC appeared to comply with WPS-B-T-3313-Tc-P4.

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 119 located on DP3162-001.

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 060 located on DP3162-001.

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 256 located on DP3162-001.

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.

FCAW welding of weld joint 225 located on DP3162-001.

Welder is identified as 201788. ZPMC QC is identified as Mr. Zhu Zhong Jie.

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

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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