

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-016285**Date Inspected:** 13-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**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 # 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. The members are identified as OBG components and the weld designations reviewed are as follows.

DP3162-001-025, 292

DP3162-001-041~044, 095~098, 151~154, 207~210, 255~258, 263~266, 271~274, 279~282, 287~290

DP3162-001-215~218, 223~226, 231~234, 239~242, 159~162, 167~170, 175~178, 103~106, 111~114

DP3162-001-119~122, 127~130, 049~052, 057~060, 065~068, 073~076, 183~186

Bay # 09, Continuity Plate of U-rib

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Tang Xing Shan

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was performing Ultrasonic Testing (UT) on the CJP welds of continuity plate of U-rib of OBG deck plate. ZPMC NDT personnel found one non confirming indication in one of the weld joint. The members are identified as OBG components and the weld designations reviewed are as follows.

DP3162-001-044 (ZPMC NDT personnel found non confirming indication)

DP3162-001-041, 095, 098, 151, 154, 207, 210, 255, 258, 263, 266, 271, 274, 279, 282, 287, 290

DP3162-001-215, 218, 223, 226, 231, 234, 239, 242, 159, 162, 167, 170, 175, 178, 103, 106, 111, 114

DP3162-001-119, 122, 127, 130, 049, 052, 057, 060, 065, 068, 073, 076, 183, 186

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 133 located on DP3167-001.

Welder is identified as 201840. 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 081 located on DP3167-001.

Welder is identified as 059403. 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 321 located on DP3167-001.

Welder is identified as 059418. 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 262 located on DP3167-001.

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 240 located on DP3167-001.

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-2233-Tc-U4B-F.

FCAW welding of weld joint 132 located on DP3167-001.

Welder is identified as 201840. 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 080 located on DP3167-001.

Welder is identified as 059403. 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 320 located on DP3167-001.

Welder is identified as 059418. 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 261 located on DP3167-001.

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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 239 located on DP3167-001.

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.

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.

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Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer