

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-016286**Date Inspected:** 14-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 # 08, OBG BIKE PATH (NWIT # 06399)

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:

BK004A1-053-009 GREEN TAG NO. 14391

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

Bay # 07, Bottom Plate of CB19

During random in process inspection this QA inspector observed that ZPMC personnel were doing marking on the plate PL3541 of the crossbeam bottom flange plate of CB 19. ZPMC QC is identified as Mr. Cui Jun Jie. Attached photograph provide additional details.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY 07, Side Plate of 14E

SMAW tack welding of weld joints 051~058 located on SP3120-001.

Welder is identified as 049771. ZPMC QC is identified as Mr. Cui Jun Jie.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112-FCM.

Side Plate of 14E (Gantry Welding)

FCAW welding of weld joint 006 & 007 located on SP3140-001.

Welder is identified as 062447. 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 010 & 011 located on SP3140-001.

Welder is identified as 048801. 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, Deck Plate Repair (B-CWR1718, Rev.-1)

During random in process inspection of deck plate DP3127-001, this QA inspector observed repair welding by FCAW process on the weld joints 035~041, 044, 045, 047~050 as per B-CWR1718. Welder is identified as 048625. ZPMC CWI is identified as Mr. Huang Min. The welding variables recorded by QC appeared to comply with WPS-B-T-4133. Attached photograph provide additional details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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