

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-016288**Date Inspected:** 16-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:

BAY # 04, OBG Deck Panel (NWIT # 06408)

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:

DP3106(PL3202A)-001-001~006 GREEN TAG NO. 14256
DP3106(PL3202B)-001-138~141, 173, 174 GREEN TAG NO. 14257
DP3106(PL3202C)-001-176~181 GREEN TAG NO. 14258
DP3107(PL3203A)-001-001~006 GREEN TAG NO. 14259
DP3107(PL3203B)-001-138~141, 173, 174 GREEN TAG NO. 14260
DP3107(PL3203C)-001-176~181 GREEN TAG NO. 14261

BAY # 03, OBG FLOOR BEAM (NWIT # 06410)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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:

X3632E (FOR BASE METAL REPAIR)

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 AB/F NDT personnel Mr. Chu Zi Qing and Mr. Sun Zhi Cheng were performing Magnetic Particle Testing (MT) on the tack welds of U-rib to deck plate of OBG deck panel. MT linear indications were observed at some locations those locations marked for grinding and to do MT again. The members are identified as OBG components and the weld designations reviewed are as follows.

DP3172-001-001~016

Bay # 09, 14W-DP3171-001

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up by using Gas Metal Arc Welding (GMAW) of U-rib to deck plate of above mentioned deck panel. Welders are identified as 062305 and 059472. ZPMC CWI is identified as Mr. Chen Shi Gang. The welding variables recorded by QC appeared to comply with WPS-B-T-2342-U5b(U-rib).

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 219 located on DP3158-001.

Welder is identified as 059378. ZPMC QC is identified as Mr. Zhang Hai Tao.

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

FCAW welding of weld joint 200 located on DP3158-001.

Welder is identified as 201788. ZPMC QC is identified as Mr. Zhang Hai Tao.

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

FCAW welding of weld joint 151 located on DP3158-001.

Welder is identified as 059371. ZPMC QC is identified as Mr. Zhang Hai Tao.

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

FCAW welding of weld joint 100 located on DP3158-001.

Welder is identified as 059443. ZPMC QC is identified as Mr. Zhang Hai Tao.

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

WELDING INSPECTION REPORT

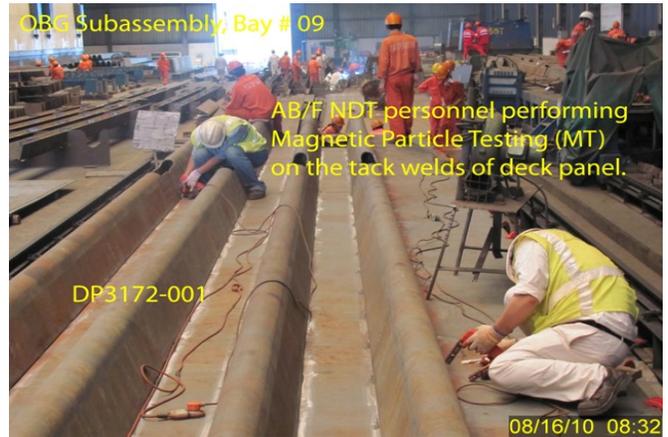
(Continued Page 3 of 3)

FCAW welding of weld joint 075 located on DP3158-001.

Welder is identified as 059403. ZPMC QC is identified as Mr. Zhang Hai Tao.

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

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