

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-016318**Date Inspected:** 18-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:** Yang Bai Qian**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:

OBG Bay 04, Deck Panel 14W-DP3172(PL3485A/B)-001

This QA inspector performed conventional Ultrasonic Testing (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel 14W-DP3172(PL3485A/B)-001, 8 ribs, 16 welds, 256 total tack welds inspected.

Weld 001 scanned 22 locations with 0 indications.

Weld 002 scanned 22 locations with 0 indications.

Weld 003 scanned 22 locations with 1 indication.

Weld 004 scanned 22 locations with 0 indications.

Weld 005 scanned 22 locations with 0 indication.

Weld 006 scanned 22 locations with 0 indications.

Weld 007 scanned 22 locations with 0 indication.

Weld 008 scanned 22 locations with 0 indications.

Weld 009 scanned 10 locations with 0 indications.

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Weld 010 scanned 10 locations with 0 indications.
Weld 011 scanned 10 locations with 2 indications.
Weld 012 scanned 10 locations with 0 indications.
Weld 013 scanned 10 locations with 0 indications.
Weld 014 scanned 10 locations with 1 indication.
Weld 015 scanned 10 locations with 0 indications.
Weld 016 scanned 10 locations with 0 indications.

BAY # 02, OBG Floor Beam (NWIT # 06425)

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:

FB3321-001-038, 039
FB3317-001-038, 039
FB3336-001-033, 034
FB3316-001-070, 071
FB3341-001-033, 034
FB3329-001-038, 039
FB3344-001-023, 024

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

BAY 09, Continuity Plate of U-rib

FCAW welding of weld joint 245 located on DP3157-001.
Welder is identified as 059371. 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 244 located on DP3157-001.
Welder is identified as 059371. 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 038 located on DP3164-001.
Welder is identified as 062265. 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 037 located on DP3164-001.
Welder is identified as 062265. 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
