

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-017031**Date Inspected:** 27-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:** Guo Yan Fei, 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, Deck Panel

QA inspector performed conventional Ultrasonic Testing (UT) Inspection of approximately 10% for Lack of Penetration (LOP) on deck panel weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Deck Panel. The weld designations reviewed are as follows.

DP3167(PL3436A/B)-001-001~018

DP3159(PL3434A/B)-001-001~020

BAY # 04, OBG Deck Panel (NWIT # 06503)

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:

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DP3149(PL3345A)-001-001~006 GREEN TAG NO. 14286
DP3149(PL3345B)-001-138~141, 173, 174 GREEN TAG NO. 14287
DP3149(PL3345C)-001-176~181 GREEN TAG NO. 14288
DP3151(PL3347A)-001-001~006 GREEN TAG NO. 14289
DP3151(PL3347B)-001-138~141, 173, 174 GREEN TAG NO. 14290
DP3151(PL3347C)-001-176~181 GREEN TAG NO. 14291

BAY # 04/03, OBG EDGE PLATE/OBG FLOOR BEAM (NWIT # 06503)

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:

EP3028-001-001
FB3290-001-001, 002

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

Bay # 09, 14E-DP3157(PL3432A/B)-001

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up by using Gas Metal Arc Welding (GMAW) process for U-rib to deck plate of above mentioned deck panel. Welders are identified as 062305 and 059366. ZPMC QC is identified as Mr. Zhu Zhong Jie. 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 046 located on DP3173-001.
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 048 located on DP3173-001.
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.

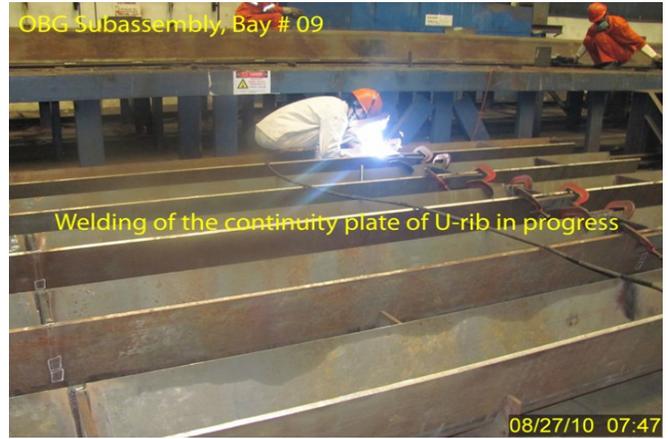
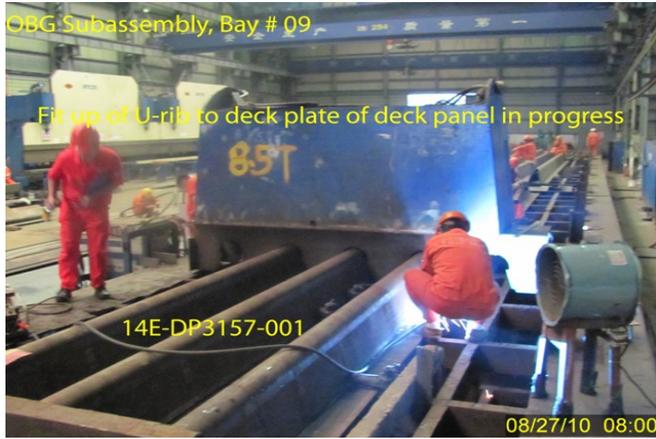
FCAW welding of weld joint 057 located on DP3173-001.
Welder is identified as 059403. ZPMC QC is identified as Mr. Zhu Zhong Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 055 located on DP3173-001.
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

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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