

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-017032**Date Inspected:** 28-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 9

DECK PANEL 14W-DP3177(PL3490A/B)-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3177-001 in process on gantry # 1. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U (urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 007; Welder # 059443

Weld Joint # 002, 008; Welder # 201788

Weld Joint # 003, 005, 009, 011; Welder # 059403

Weld Joint # 004, 006, 010, 012; Welder # 059416

DECK PANEL 14W-DP3176(PL3489A/B)-001

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Gas Metal Arc Welding (GMAW) of DP3176-001 in process on gantry # 1. ZPMC Quality Control (QC) is identified as Mr. Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used. The weld number and welder for respected weld are as follows.

Weld Joint # 001, 009; Welder # 059421
Weld Joint # 002, 010; Welder # 059418
Weld Joint # 003, 005, 011, 013; Welder # 059416
Weld Joint # 004, 006, 012, 014; Welder # 059403
Weld Joint # 007, 015; Welder # 201788
Weld Joint # 008, 016; Welder # 059443

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.

DP3173(PL3486A)-001-046~049, 054~057, 062~065, 070~073, 078~081, 114~117, 180~183, 172~175, 165~169, 160~163
DP3173(PL3486A)-001-152~155, 237~240, 229~232, 221~224, 213~216, 275~278, 267~270, 259~262, 251~254
DP3173(PL3486A)-001-095, 096, 098, 101, 103, 104, 106, 109, 119, 120, 122, 125, 127, 128, 130, 133

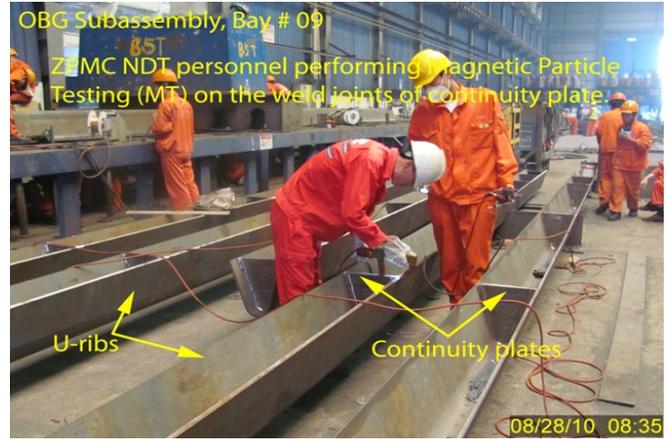
Bay # 09, 14W-DP3169(PL3482A/B)-001

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 059366 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).

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