

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017329**Date Inspected:** 04-Oct-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:****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, Tower**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Trial Assembly (D-scan)

B-CWR 1969 Rev 1

This QA Inspector was notified via email for verification of B – CWR1969 R0 at 1630 hours the following was observed:

- The component for verification was identified as OBE10C-005 10BE+10CE (C4)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1975 Rev 0

This QA Inspector was notified via email for verification of B – CWR1975 R0 at 1630 hours the following was observed:

- The component for verification was identified as SEG062A-011, SEG064A-021 10BE+10CE (E4)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing

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- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1971 Rev 0

This QA Inspector was notified via email for verification of B – CWR1971 R0 at 1630 hours the following was observed:

- The component for verification was identified as OBE10A-005 10BE+10CE (B3)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1972 Rev 0

This QA Inspector was notified via email for verification of B – CWR1972 R0 at 1630 hours the following was observed:

- The component for verification was identified as OBE10C-002 10BE+10CE (E7)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1973 Rev 0

This QA Inspector was notified via email for verification of B – CWR1973 R0 at 1630 hours the following was observed:

- The component for verification was identified as CA076-002, CA078-006 10BE+10CE (E2)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1974 Rev 0

This QA Inspector was notified via email for verification of B – CWR1974 R0 at 1630 hours the following was observed:

- The component for verification was identified as CA076-001, CA078-005 10BE+10CE (E1)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

B-CWR 1988 Rev 0

This QA Inspector was notified via email for verification of B – CWR1988 R0 at 1630 hours the following was observed:

- The component for verification was identified as SEG062-012, SEG064-042 10BE+10CE (E3)
- Weld repair was to be performed on locations where rejectable indications were found by ultrasonic testing
- ZPMC CWI An Qing Xiang was present on site to direct and record all repair work.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant conversations.

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:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
