

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-010100**Date Inspected:** 12-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**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 Inspector (QA) Shrikant Utekar 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:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 2AW-2BW

This QA Inspector performed Magnetic Particle Testing (MT) in conjunction with ABF Magnetic Particle Testing (MT) department for detection of planar transverse indication.

Magnetic Particle Testing (MT) performed on repair areas of side panel splice weld (cross beam side) between OBG segment 1AE and 1BE (OBE1A-006, 007). During the Magnetic Particle Inspection ABF found two linear indications in the weld OBE1A-007. The Y location of indication measured approximately 4200mm and the length of indications measured approximately 5mm and 3mm. For additional information see attached photo.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

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OBG SEGMENT 1AE- 1BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044779 performing Shielded Metal Arc Welding process for the weld joint CA098-004 on the excavated areas located on PCMK weld between edge panel and deck panel (bike path side) of OBG segment 1BE. The Y location measured approximately 13580mm. ZPMC QC Mr. Zhang Qiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM- Repair-1. The critical weld repair report identified as B-CWR882.

BAY # 10

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053870 performing Shielded Metal Arc Welding process for the weld joint 2A located on PCMK SSD1-SPSA4-20. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



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 +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer