

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-011778**Date Inspected:** 05-Feb-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:** Li Yang**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 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

ULTRASONIC INSPECTION

OBG SEGMENT 6CE

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the weld between deck panel end edge panel (Bike path side) of OBG segment 6CE. Weld number was identified as CA030-002, 004, 006. Ultrasonic inspection performed utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 02032010-1.

ULTRASONIC INSPECTION

OBG SEGMENT 6BW

WELDING INSPECTION REPORT

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This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the weld between side panel end bottom panels (cross beam side) of OBG segment 6BW. Weld number was identified as SEG27B-21. Ultrasonic inspection performed utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 02052010-1.

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

OBG SEGMENT 6BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 216086, 049339 performing Shielded Metal Arc Welding process for weld CA028-006 located on PCMK the weld between deck panel and edge panel (bike path side) of OBG segment 6BE. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM- Repair-1. Critical weld report identified as B-CWR1137.

OBG SEGMENT 7CE

This QA Inspector observed the continued drilling of road barrier holes in the deck plate of 6CE on the cross beam side of the segment. ZPMC has used template to start drill all holes and has crew coming behind through drilling started holes.

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
