

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-012024**Date Inspected:** 16-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

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6BW-6CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066179 performing Shielded Metal Arc Welding process for weld OBW6C-003 located on PCMK bottom panel splice weld between OBG segment 6BW-6CW. ZPMC QC Mr. He Yan Ling monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –FCM-Repair-1. Critical weld repair report identified as B-CWR1209.

OBG SEGMENT 6CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066261 performing Shielded Metal Arc Welding process for weld SEG031F-008 located on PCMK weld between longitudinal diaphragm top flange to floor beam at PP 44 cross beam side. ZPMC QC Mr. He Yan Ling monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) –FCM-Repair-1. Critical weld

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repair report identified as B-WR10630.

OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066746 performing Flux Cored Arc Welding process for weld BP143-001-038 located on PCMK weld between bottom panel “T” stiffener to “T” stiffener at the bottom panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. He Yan Ling monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing Submerged Arc Welding process for weld OBW7-008 located on PCMK deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231(2) T-2.

OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069683 performing Flux Cored Arc Welding process for weld SP257-001-002 located on PCMK weld between side panel “T” stiffener to “T” stiffener at the side panel splice weld between OBG segment 7CW and 7BW (cross beam side). ZPMC QC Mr. He Yan Ling monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U-FCM-1.

OBG SEGMENT 6AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for base metal repair at the corner of deck and web plate next to the connection plate in segment 6AW. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) –FCM-Repair-. Weld repair report identified as B-WR10667.

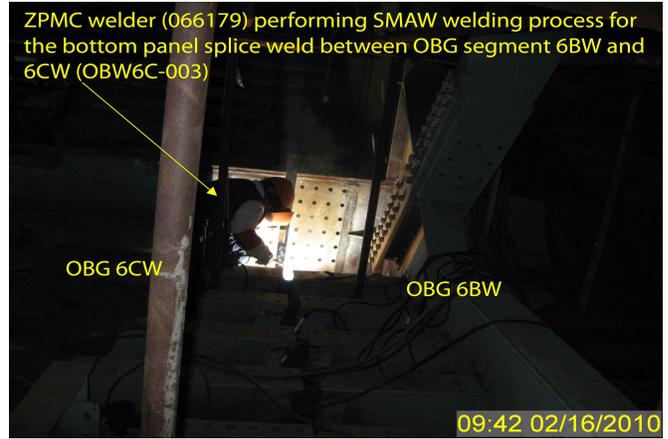
OBG SEGMENT 6AE

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging on the weld between side panel and bottom panel near PP37 cross beam side.

Unless otherwise noted, all work observed on this dated appeared to generally comply with 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, +(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