

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-012293**Date Inspected:** 27-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**

This Q.A Inspector performed Magnetic particle Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 6west Designation are as follows.

EP41-001-014; DP629-001-023; SP83-002-044; DP514-001-007; SP475-001-051; SP753-001-050, 054; BP33-001-030, BP87-001-028, 030; SP122-001-37, 39; SP413-001-031.

MAGNETIC PARTICLE INSPECTION

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6east Designation are as follows.

SEG030C-032, 30, 006, 001, 009, 011; SEG030B-032, 30, 006, 001, 009, 011; SEG032F-001, 011, 013; SEG032D-011, 013, 001; SSD30C-PP40.5-002; SSD30D-PP41.5-002; SEG028M-050, 058.

During the magnetic particle inspection this Quality Assurance (QA) Inspector observed two transverse linear

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indications in the weld SEG030C-006. Incident report was issued. See attached photos for more information.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6CW-6BW

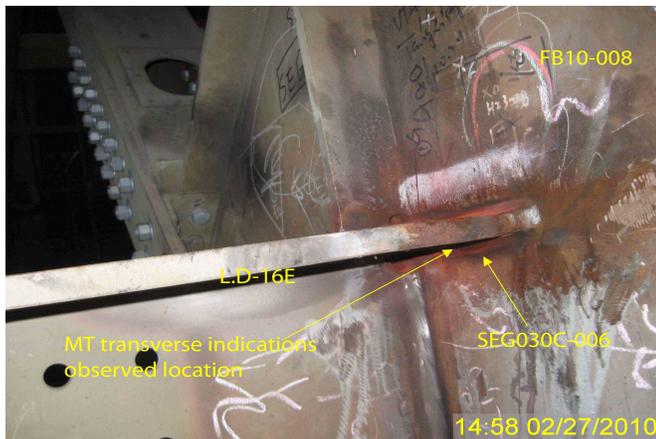
This Quality Assurance (QA) Inspector observed ABF QA Inspector performing ultrasonic inspection on the weld between longitudinal diaphragm top flange to floor beam at PP44 cross beam side.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing magnetic particle inspection on the bottom panel T stiffener hold back weld near the bottom panel splice weld between OBG segment 6BW and 6CW.

OBG SEGMENT 7AW

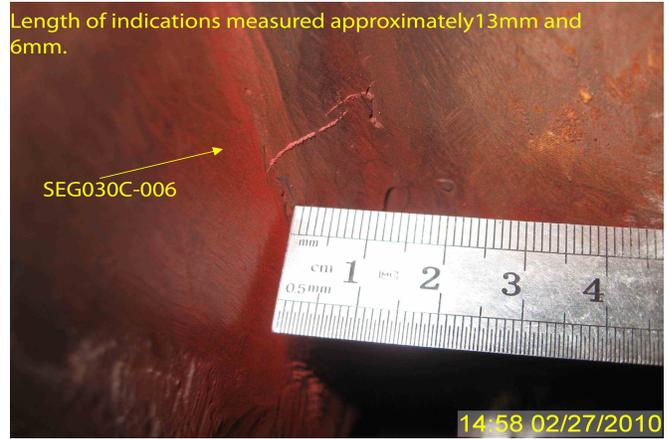
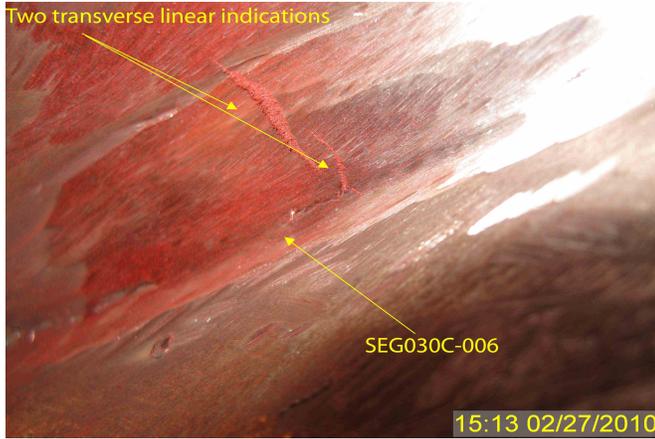
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld SEG033B-001 located on PCMK weld between longitudinal diaphragm and floor beam at PP48 counter weight side. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Weld repair report identified as B-WR10697.

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