

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-012885**Date Inspected:** 02-Apr-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

MAGNETIC PARTICLE INSPECTION

This Q.A Inspector performed Magnetic particle testing 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 7BE. The welds Designation are as follows.

OBE7B-14~21

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AE-7BE-7CE-7DE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 048659 and 054467 performing Shielded Metal Arc Welding process for weld OBE7-008 located on PCMK weld between deck panel splice weld

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between OBG segment 7BE and 7CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-4G (4F)-FCM-Repair-1. Critical Weld repair report identified as B-CWR1363.

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic inspection on the weld between deck panel and edge panel (bike path side).

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Magnetic particle inspection on the repair areas of bottom panel splice weld between OBG segment 7BE and 7CE.

CROSS BEAM # 7

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for weld 073 located on PCMK cross beam # 7 . ZPMC QC Mr. Feng Yang Jiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132 (4).

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for weld 097 located on PCMK cross beam # 7 . ZPMC QC Mr. Feng Yang Jiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132 (4).

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

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Reviewed By: Dawson,Paul

QA Reviewer