

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-013871**Date Inspected:** 02-May-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:	N/A	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 7EE

ABF Request No: 05022010-2

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Weld identification numbers were.

CA046-004 (7EE- DP to EP, B.P side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

WELDING INSPECTION REPORT

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No relevant Indications were observed.

ULTRASONIC INSPECTION

OBG SEGMENT 7DE

ABF Request No: 05022010-1

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Rejectable indications were observed. Inspection was carried out on repair areas. Weld identification numbers were.

CA042-004 (7DE- DP to EP, bike path side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication. For more information refer the ABF /CT report dated on 05/02/2010.

ULTRASONIC INSPECTION

OBG SEGMENT 8AE-8BE

ABF Request No: UT-8E-024

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Rejectable indications were observed. Weld identification numbers were.

OBE8-002 (8AE-8BE, DP)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication. For more information refer the ABF /CT report dated on 05/02/2010 & 05/02/2010.

ULTRASONIC INSPECTION

OBG SEGMENT 8AE-8BE

ABF Request No: UT-8E-023

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Rejectable indications were observed. Weld identification numbers were.

OBE8B-003 (8AE-8BE, BP)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication. For more information refer the ABF /CT report dated on 05/02/2010 & 05/02/2010.

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MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7EE

ABF Request No. 05022010-2

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and deck panel (Bike path side) of the OBG segment 7EE. Inspection was carried out on repair areas. Weld identification number was.

CA046-004 (7EE, DP to EP, B.P side)

No relevant indications were observed.

OBG SEGMENT 7DE

ABF Request No. 05022010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and deck panel (bike path side) of the OBG segment 7DE. Inspection was carried out on repair areas. Weld identification number was.

CA042-004 (7DE, DP to EP, B.P side)

No relevant indications were observed.

ULTRASONIC INSPECTION

OBG SEGMENT 8AE-8BE

ZPMC NWIT No: 005647

This Q.A Inspector performed Ultrasonic testing 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 "T" stiffener and "I" rib splice weld. The welds Designation are as follows.

DP667-001-041; EP094-001-016; SP466001-036; SP315-001-051, 053; SP369-001-029, 031; BP121-001-024, 026; BP175-001-024, 026; SP618-002-045, 047; SP538-002-036; SP457-002-058; EP085-002-027; SP578-002-048.

ULTRASONIC INSPECTION

OBG SEGMENT 8AE-7EE

ZPMC NWIT No: 005647

This Q.A Inspector performed Ultrasonic testing 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 corner assembly. The welds Designation are as follows.

CA045-005; SEG044*-043; CA046-001; CA048-005

WELDING INSPECTION REPORT

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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
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