

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-015260**Date Inspected:** 30-Jun-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: Wu Zhi Zhang
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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 11CW

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between edge panel and deck panel (Cross beam side) of OBG segment 11CW. The weld designations are as follows.

CA086-004 (OBG 11CW, E.P to D.P – Cross beam side)

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

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OBG SEGMENT 9AE-9BE

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Magnetic Particle Inspection on the temporary attachment removed area at the side panel splice weld between OBG segment 9AE and 9BE (Cross beam side). See attached photo.

OBG SEGMENT 9AW-9BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 033723 performing Shielded Metal Arc Welding process for weld 017 located on PCMK DP670-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing Flux Cored Arc Welding process for weld 013 located on PCMK EP124-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-b-u2-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 200569 performing Shielded Metal Arc Welding process for weld 019 located on PCMK DP684-001. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-b-u3b.

OBG LIFT # 7 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for weld 052 located on PCMK RETRO-G-01-7EW-B3. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

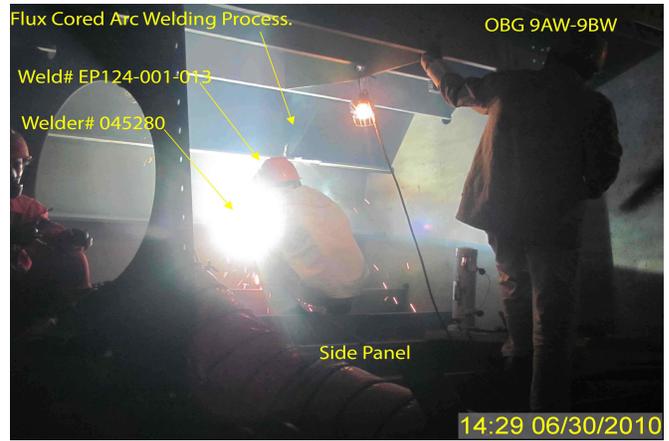
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 226872 performing Flux Cored Arc Welding process for weld 032 located on PCMK RETRO-G-01-7BW. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 215326 performing Shielded Metal Arc Welding process for weld 032 located on PCMK RETRO-G-01-7DW. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2112-FCM-1.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversation was held between QA and QC

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:	Peterson,Art	QA Reviewer
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