

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-015666**Date Inspected:** 18-Jul-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**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 9DW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066261 performing Shielded Metal Arc Welding process for weld 006 located on PCMK CA059. ZPMC QC Mr. Wang Zhu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u4b-fcm-1.

OBG SEGMENT 9BW-9CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 207465 performing Flux Cored Arc Welding process for weld 048 located on PCMK SSD25-PP75. ZPMC QC Mr. Xu Jin Long monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-u2-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing Shielded Metal Arc Welding process for weld 008 located on PCMK OBW9A. ZPMC QC Mr. Zhu Yuan Yuan monitoring this

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welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045270 performing Submerged Arc Welding process for weld 008 located on PCMK OBW9. ZPMC QC Mr. Zhu Yuan Yuan monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223 (2)1T-2.

OBG SEGMENT 9CE-9DE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068493 performing buttering on the longitudinal diaphragm (LD) edges with Flux Cored Arc Welding process. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F) Repair-1. Weld repair report identified as B-WR13983.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing ultrasonic inspection on the deck panel splice weld between OBG segment 9CE and 9DE. Weld number identified as OBW9A-003.

This Quality Assurance (QA) Inspector observed ABF personnel performing ultrasonic inspection on the hold back weld between side panel and bottom panel of OBG segment 9CE at OBG segment 9BE (bike path side).

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



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