

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-015971**Date Inspected:** 01-Aug-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(QA) Inspector Mr. 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. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 9CE-9DE

ABF Request No: 07312010-1

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the bottom panel splice weld between OBG segment 9CE and 9DE. Inspection was carried out on repair areas only. The weld designation were as follows:

OBE9C-003 (OBG 9CE-9DE, B.P)

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

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OBG SEGMENT 9DE

ABF Request No: 07312010-1

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between deck panel and edge panel of OBG segment 9DE on the (bike path side). Inspection was carried out on repair areas. The weld designations were as follows.

CA066-002 (OBG 9DE- D.P to E.P, BK side)

ULTRASONIC INSPECTION

OBG SEGMENT 9BE

ABF Request No: 07312010-1

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel . The location of the inspection identified as the weld between side panel and edge panel of OBG segment 9BE on the (bike path side). Inspection was carried out on repair areas. The weld designations were as follows.

SEG052A-039 (OBG 9BE- S.P to E.P, BK side)

ULTRASONIC INSPECTION

OBG SEGMENT 9DE

ABF Request No: 07312010-1

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 separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between side panel and edge panel of OBG segment 9DE on the (bike path side). Inspection was carried out on repair areas. The weld designations were as follows.

CA066-005 (OBG 9DE- S.P to E.P, BK side)

This QA Inspector randomly observed the following work in progress.

CROSS BEAM # 11

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069896 performing Shielded Metal Arc Welding process for weld 017 located on PCMK DP202-011. ZPMC QC Mr. Xu Jin Zong was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067829 performing Shielded Metal Arc Welding process for weld 020 located on PCMK DP202-011. ZPMC QC Mr. Xu Jin Zong was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-FCM-1.

WELDING INSPECTION REPORT

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

Summary of Conversations:

No significant conversations were reported on this date.

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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