

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-016049**Date Inspected:** 03-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 TESTING

OBG SEGMENT 9EE-9DE

ABF Request No: 08032010-1

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 side panel splice weld between OBG segment 9EE and 9DE. Inspection was carried out on repair areas only. The weld designations were as follows:

OBE9C-009, 010 (OBG 9EE-9DE, S.P-BK side)

MAGNETIC PARTICLE TESTING

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

OBG SEGMENT 9DE-9EE

ABF Request No: 08032010-1

This QA Inspector witnessed ABF personal performing Magnetic Particle Testing (MT) on the side panel splice welds between OBG segment 9DE and 9EE on the (bike path side). The Inspection was carried out on repair areas only. The weld identification numbers were.

OBE9C-009, 010 (OBG 9DE-9EE, S.P-BK side)

No relevant indications were observed by this QA Inspector on this date.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 9CW-9DW-9EW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 067765 and 066038 performing Shielded Metal Arc Welding process for weld 002 located on PCMK OBW9C. ZPMC QC Mr. Zhou Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-u2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 046706 performing Flux Cored Arc Welding process for weld 009 located on PCMK OBW9C. ZPMC QC Mr. Shi Lie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067609 performing Shielded Metal Arc Welding process for weld 010 located on PCMK OBW9A. ZPMC QC Mr. Shi Lie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114-B-u2-FCM-1.

TRAVELER RAIL

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051246 performing Flux Cored Arc Welding process for weld 003 located on PCMK TR5B-PP85. ZPMC QC Mr. Shen Jian Bo was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-u4c-f.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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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