

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017259**Date Inspected:** 05-Oct-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:** Lv Li Qing**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:

BAY # 11

ULTRASONIC TESTING

This QA Inspector performed Ultrasonic Testing (UT) of West Tower Lift 5 grillage welds D-E corner weld WSD1-T15-4B-F-7, 36. UT was performed on the bottom 1000mm and top 500mm as in accordance with AWS D1.5-2002, section 6, table 6.3. Rejectable indications were observed at the time of testing. These Indications were recorded and plotted for further evaluation.

BAY # 14

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068445 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBW13C. ZPMC QC Mr. Xia Chun Hui was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-B-u2-f.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044771 performing the Submerged Arc Welding process on weld 006 located at PCMK SEG3009. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-L2c-s-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 012 located at PCMK VP3007-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F) Repair-1. Weld repair report identified as B-WR15485.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 076 located at PCMK VP3007-001. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F) Repair-1. Weld repair report identified as B-WR15494.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing the Submerged Arc Welding process on weld 008 located at PCMK SEG3020A. ABF QA Miss. Lv Yun was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-L2c-s-2.

BAY # 16

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048696 performing the Flux Cored Arc Welding process on weld 060 located at PCMK LD3031-001. ABF QA Mr. Shi Li You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045280 performing the Flux Cored Arc Welding process on weld 053 located at PCMK LD3031-001. ABF QA Mr. Shi Li You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040344 performing the Flux Cored Arc Welding process on weld 048 located at PCMK LD3034-001. ABF QA Mr. Shi Li You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201583 performing the Flux Cored Arc Welding process on weld 082 located at PCMK LD3034-001. ABF QA Mr. Shi Li You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2232-Tc-u5-f.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer