

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017282**Date Inspected:** 08-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 # 14

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044774 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBE13C. ABF QA Mr. Geng Wei was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044795 performing the Flux Cored Arc Welding process on weld 002 located at PCMK OBE13C. ABF QA Mr. Geng Wei was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2233-B-U2-F.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing air Carbon arc gouging for the weld VP3007A-001-077.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, Member identified as VP3016*-001-006. Distortion appeared to be caused by welding. ZPMC Quality Control (QC)

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inspector identified as Mr. Lv Li Qing was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report HSR1 (B)-9573.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic testing for the weld between DP 3089A and DP3090A. Weld number identified as SEG3009-005.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing the Submerged Arc Welding process on weld 003 located at PCMK SEG3020A*. ABF QA Miss. Li Yun was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-U2c-s-2.

BAY # 16

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201583 performing the Flux Cored Arc Welding process on weld 128 located at PCMK LD3033-001. ABF QA Mr. Shi Li You was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-345-FCAW-2G (2F)-Repair-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045143 performing the Flux Cored Arc Welding process on weld 046 located at PCMK LD3036-001. 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 for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer