

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-017465**Date Inspected:** 17-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:

ULTRASONIC TESTING

BAY # 14

OBG SEGMENT 13AE-13BE

ABF Report No: UT-13E-003

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 13AE and 13BE on cross beam side. The weld designations were as follows:

OBE13C-003 (OBG 13AE-13BE, SP, CB side)

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066673 performing the Flux Cored Arc Welding process on weld 008 located at PCMK SEG3015A. ZPMC QC Mr. Wang Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2131T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201050 performing the Flux Cored Arc Welding process on weld 004 located at PCMK OBW13C. ZPMC QC Mr. Wang Jie 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 045265 performing the Submerged Arc Welding process on weld 005 located at PCMK SEG3020AP. ABF QA Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QA appeared to comply with WPS-B-T-2221-B-u2c-s-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 035 located at PCMK VP3007-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067138 performing the Flux Cored Arc Welding process on weld 055 located at PCMK VP3007-001. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-u4b-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048047 performing the Shielded Metal Arc Welding process on weld 056 located at PCMK CA3014C. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051359 performing the Shielded Metal Arc Welding process on weld 062 located at PCMK CA3014C. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-4113-1.

This Quality Assurance (QA) Inspector observed fit-up was in progress for floor beam FB3143, FB3151 and FB3159.

This Quality Assurance (QA) Inspector observed ZPMC personnel performing Ultrasonic testing for the weld between side panel and bottom panel on the bike path side, Weld number was identified as SEG3007AC-012.

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

Reviewed By: Peterson,Art

QA Reviewer