

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-017527**Date Inspected:** 23-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

ZPMC NWIT: 07078

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as vertical plate. The weld designations are as follows:

VP3016-001-016, 013, 005~008

This QA Inspector randomly observed the following work in progress.

BAY # 14

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201215 and 047866 performing the Flux

WELDING INSPECTION REPORT

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Cored Arc Welding process on weld 122 located at PCMK SEG3013J. ZPMC QC Mr. Wang Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-2232-B-u3-f.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing the Submerged Arc Welding process on weld 003 located at PCMK SEG3020AY. ZPMC QC Mr. Shao Jian Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-s.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 214945 performing the Flux Cored Arc Welding process on weld 002 located at PCMK VP3008-001. 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 044801 performing the Flux Cored Arc Welding process on weld 003 located at PCMK VP3008-001. 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 044824 performing the Flux Cored Arc Welding process on weld 016 located at PCMK VP3008-001. 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 044774 and 048047 performing buttering with Flux Cored Arc Welding process on rib stiffener of the floor beam FB3126, FB3110 and FB3123. ZPMC QC Mr. Wang Xu was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G (2f)- Repair. Critical weld repair report identified as B-CWR2056.

ULTRASONIC TESTING

BAY # 14

ZPMC NWIT: 07073

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as Steel barrier. The weld designations are as follows:

W5-sb1-001-081, W5-sb1-019-050, W5-sb1-005-019 W5-sb1-011-019, W5-sb1-035-019, W5-sb1-034-081, W5-sb2-004-019, W5-sb1d-004-081, W5sb1-024-019, W5-sb13b-001-081

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

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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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