

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-022057**Date Inspected:** 16-Mar-2011**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:

MAGNETIC PARTICLE TESTING

ZPMC NWIT No: 08556

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (MT) report on this date. The members are identified as deck panel. The weld designations are as follows:

DP3162-001-131~134, 187~190, 411~414, 079~088, 415~418, 204, 135~144, 419~422, 037, 040, 048, 053, 056, 061, 064, 069, 91, 94, 99, 205, 102, 107, 110, 115, 118, 123, 147, 150, 155, 158, 163, 166, 171, 174, 179

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 017 located at PCMK SEG3019BB. ZPMC QC Mr. Zhu Yuan Yuan was

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monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u5b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037997 performing the Shielded Metal Arc Welding process on weld 061 located at PCMK SEG3019BB. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u5b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066416 performing the Shielded Metal Arc Welding process on weld 149 located at PCMK SEG3019BB. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u5b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067183 performing the Shielded Metal Arc Welding process on weld 059 located at PCMK SEG3019D-1. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114- Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037723 performing the Shielded Metal Arc Welding process on weld 006 located at PCMK SEG3019Z. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR20361.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571 performing the Shielded Metal Arc Welding process on weld 005 located at PCMK SEG3019Z. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR20361.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 043661 performing the Shielded Metal Arc Welding process on weld 032 located at PCMK SEG3019AG. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Weld repair report identified as B-WR20321.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066763 performing the Flux Cored Arc Welding process on weld 035 located at PCMK SEG3019AW. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066733 performing the Flux Cored Arc Welding process on weld 031 located at PCMK SEG3019Y. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066236 performing the Flux Cored Arc Welding process on weld 267 located at PCMK SEG3019E-1. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068917 performing the Shielded Metal Arc Welding process on weld 100 located at PCMK SEG3019AW. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214- Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068097 performing the Shielded Metal Arc Welding process on weld 021 located at PCMK SEG3019H. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114- Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037748 performing the Shielded Metal Arc Welding process on weld 94 located at PCMK SEG3019L. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214- Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067610 performing the Shielded Metal Arc Welding process on weld 052 located at PCMK SEG3019M. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2114- Fcm-1.

OBG 13 AE

This QA Inspector observed ZPMC moved OBG segment 13AE from bay # 14 to trial assemble yard.

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.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
