

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009816**Date Inspected:** 23-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin, Cheng Ying Xin**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:** Tower/OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) 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. QA observed and/or found the following:

BAY #10

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Cored Arc Welding process for the weld SSSL4-1B/L-4B located on PCMK corner weld between skin A and skin B of south tower lift 4. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U4B-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for the weld SSSL4-1B/L-5B located on PCMK corner weld between skin C and skin B of south tower lift 4. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Cored Arc

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Welding process for the weld SSTL4-1B/L-3B located on PCMK corner weld between skin A and skin E of south tower lift 4. ZPMC QC Mr. Jiang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4B-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052930 performing Shielded Metal Arc Welding process for the weld SSTL4-1L/L-3B located on PCMK South tower lift 4. ZPMC QC Mr. Cheng Ying Xin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-U4B-1.

NORTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057239 performing tack weld for the weld between skin C and 116m diaphragm of north tower lift 4 with Shielded Metal Arc Welding process. ZPMC QC Mr. Zou Jian monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4314-TC-P5-F.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 1AAW- 1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 054467, 049769 performing Shielded Metal Arc Welding process for the weld joint OBE2A-004 on the excavated areas located on PCMK bottom panel splice weld between of OBG segment 2AE and 2BE. The Y location measured approximately 1500mm from cross beam side longitudinal diaphragm. The length of repaired area measured 1500mm. ZPMC QC Mr. Xu Yumin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair-1. The critical weld repair report identified as B-CWR859.

BAY #14

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 10AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051348 performing Shielded Metal Arc Welding process for the weld SEG059A-24 located on PCMK OBG segment 10AW. ZPMC QC Mr. Li Ming Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

OBG SEGMENT 09CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066673 performing Flux Cored Arc Welding process for the weld SEG053A-10 located on PCMK OBG segment 09CW. ZPMC QC Mr. Li Ming Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231T-1.

HEAVY DOCK/ JETTY

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for the weld SSD1-A111B/H-5 located on PCMK South tower lift #1 to base plate. ZPMC QC Mr. Zhou Yu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for the weld SSD1-A111B/H-137 located on PCMK South tower lift #1 to base plate. ZPMC QC Mr. Zhou Yu monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

BAY# 09

MAGNETIC PARTICLE INSPECTION

This Caltrans QA Inspector performed approximately 15% Magnetic Particle Testing verification of OBG Deck panel U rib tack welds after ZPMC initial MT inspection. ZPMC personnel have made repairs of areas found unacceptable. ZPMC has not performed the final MT of the repair areas. This Quality Assurance (QA) Inspector did not generated Magnetic particle Inspection (MT) report for above inspection. No relevant indications were found during this in-process inspection. The Following panels were tested

DP3046-001-001 through 10

DP3024-001-001 through 06

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

Summary of Conversations:

No relevant conversations.

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 Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
