

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-009833**Date Inspected:** 27-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:** Wang Chuang Ging, Li Jia**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 # 01

ULTRASONIC INSPECTION

This Q.A Inspector performed Ultrasonic Testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the Floor beam the welds Designation are as follows.

FB204-045-018, 012, 043

FB204-046-024, 006, 028

FB204-047-024, 006, 043

FB204-048-024, 005, 028

FB205-046-012, 016

FB205-047-012, 016

FB205-048-005, 013

BAY #10

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057266 performing Flux Core Arc Welding process for the weld joint SSSL4-1C/L -115 located on PCMK South tower lift #4. ZPMC QC Mr. Wen Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Core Arc Welding process for the weld joint SSSL4-1F/L -46 located on PCMK South tower lift #4. ZPMC QC Mr. Wen Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Core Arc Welding process for the weld joint SSSL4-1C/L -51 located on PCMK South tower lift #4. ZPMC QC Mr. Wen Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

NORTH TOWER LIFT #3

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052493 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3G/K -142 located on PCMK North tower lift #3. ZPMC QC Mr. Chen Ying Xin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050038 performing Shielded Metal Arc Welding process for the weld joint NSTL3-3G/K -55 located on PCMK North tower lift #3. ZPMC QC Mr. Chen Ying Xin monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3212-B-U2A-2.

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 generate Magnetic particle Inspection (MT) report for above inspection. No relevant indications were found during this in-process inspection. The Following panels were tested

DP3042-001-001 through 10

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DP3043-001-001 through 10

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
