

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-009835**Date Inspected:** 26-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:** Shen Fu You, 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 #10

This QA Inspector randomly observed the following work in progress.

STRUT

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052493 performing Shielded Metal Arc Welding process for the weld 8A/B located on PCMK ED1-A6003-5. ZPMC QC Mr. Jang Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-485-SMAW-2G (2F)-FCM-Repair-1. The critical weld repair report identified as T-CWR367.

SOUTH TOWER LIFT #4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Core Arc Welding process for the weld joint SSSL4-1G/L -48 located on PCMK South tower lift #4. ZPMC QC Mr. Yuan Hui Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4333-TC-P4-F.

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Core Arc Welding process for the weld joint SSSL4-1G/L -46 located on PCMK South tower lift #4. ZPMC QC Mr. Yuan Hui Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

BAY #14

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 10AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 047864 performing Shielded Metal Arc Welding process for the weld joint SEG059A-27 located on PCMK OBG segment 10AW. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 051348 performing Shielded Metal Arc Welding process for the weld joint SEG059A-28 located on PCMK OBG segment 10AW. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

OBG SEGMENT 10CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045265 performing Submerged Arc Welding process for the weld joint SEG063*-28 located on PCMK OBG segment 10CW. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223(2)1-T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045246 performing Shielded Metal Arc Welding process for the weld joint SEG063A-009 located on PCMK OBG segment 10CW. ZPMC QC Mr. Xu Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

INCIDENT

TRIAL ASSEMBLY YARD

OBG SEGMENT 1AAW- 1AW

This Quality Assurance Inspector observed ZPMC personnel have performed base metal repairs at three different locations of bolt hole repair area on the bottom panel of OBG segment 1AAW and 1AW without Engineer's approval. The location of the repairs as below.

- 1) Location measured approximately 950mm from splice weld between OBG segment 1AAW and 1AW towards 1AAW and 1000mm from cross beam side.
- 2) Location measured 3000mm from splice weld between OBG segment 1AAW and 1AW towards 1AW and 650mm from counter weight side.
- 3) Location measured 4000mm from splice weld between OBG segment 1AAW and 1AW towards 1AW and

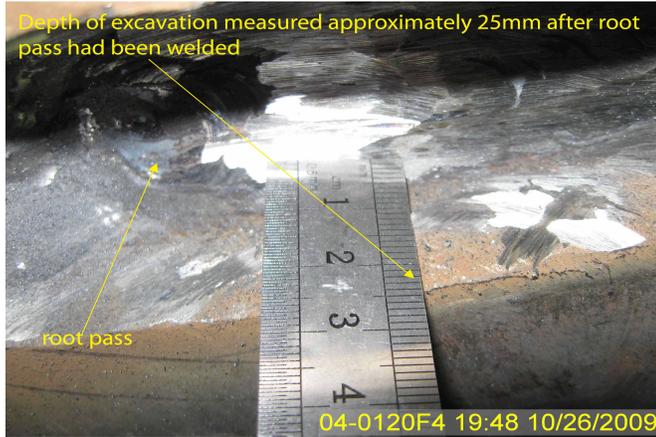
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650mm from counter weight side.

For additional information see photos below. Incident report was issued for this issue.

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