

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-010009**Date Inspected:** 31-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:** Wan Wen Zhong, Li Ming**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 040489 performing Submerged Arc Welding process for the weld joint SSSL4-1B/L -4A located on PCMK South tower lift #4. ZPMC QC Mr. Wan Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 207745 and 201750 performing Submerged Arc Welding process for the weld joint SSSL4-1B/L -5A located on PCMK South tower lift #4. ZPMC QC Mr. Wan Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

NORTH TOWER LIFT #4

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This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053116 performing Flux Cored Arc Welding process for the weld joint NSTL4-3K/L -38 located on PCMK North tower lift #4. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for the weld joint NSTL4-3J/L -36 located on PCMK North tower lift #4. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052075 performing Flux Cored Arc Welding process for the weld joint NSTL4-3I/L -36 located on PCMK North tower lift #4. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for the weld joint NSTL4-3H/L -37 located on PCMK North tower lift #4. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057266 performing Flux Cored Arc Welding process for the weld joint NSTL4-3G/L -23 located on PCMK North tower lift #4. ZPMC QC Mr. Li Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4132.

TRIAL ASSEMBLY YARD

OBG SEGMENT 1AW- 1BW

MAGNETIC PARTICLE INSPECTION

This QA Inspector performed Magnetic Particle Testing (MT) in conjunction with ABF Magnetic Particle Testing (MT) department for detection of planar transverse indication.

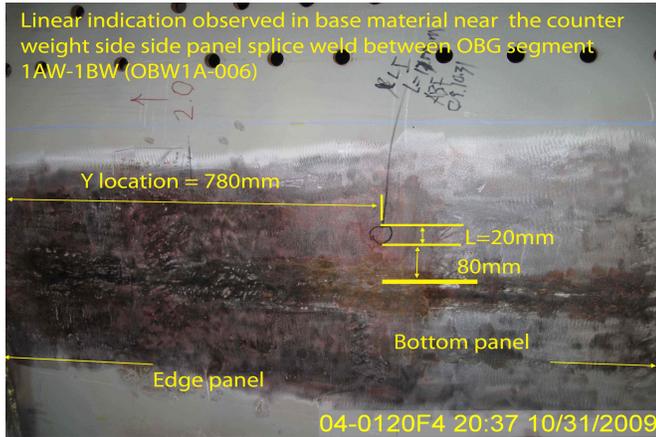
Magnetic Particle Testing (MT) performed on repair area portion of OBW 1A-007 and OBW1A-006. During the Magnetic Particle Inspection This QA identified ABF Inspector found one transverse linear indication which is in base material approximately 80mm away from the weld OBW1A-006. The 'Y' location measured approximately 780mm from counter weight side edge panel. The length of indication measured approximately 20mm. see the attached photo.

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

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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