

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-010053**Date Inspected:** 03-Nov-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:** Li Yang, Wan Wen Zhong**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/Tower**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:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 1AAW-1AW

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

UT performed on portion of OBW1A-005, 004 utilizing scanning pattern A, B, C and D (Fig 6.7)

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated November 03, 2009 for further information on inspections.

This QA Inspector randomly observed the following work in progress.

WELDING INSPECTION REPORT

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OBG SEGMENT 1AAW-1AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220064 performing Flux Cored Arc Welding process for the weld OBW1-091 located on PCMK OBG segment 1AAW. ZPMC QC Mr. Feng Yang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2234-C-U2-F.

OBG SEGMENT 2AE-2BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for the weld joint OBE-2A-004 on the excavated areas located on PCMK Bottom panel splice weld joint between of OBG segment 2AE and 2BE. The Y location measured approximately 0 to 150mm from cross beam side. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM- Repair-1. The critical weld repair report identified as B-CWR859R1.

BAY # 10

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 053116, 054069 performing buttering weld with Flux Cored Arc Welding process for the plate SPSA4-26(S). ZPMC QC Mr. Wan Wen Zhong monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-2G (2F) Repair.

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
