

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-010406**Date Inspected:** 21-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:** Xu Yumin**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**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 4AW-4BW

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 repair areas of deck panel splice weld between OBG segment 4AW and 4BW (OBW4-003) utilizing scanning pattern A, B, C and D (Fig 6.7)

OBG SEGMENT 1EAST

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 repair areas of weld between edge panel and deck panel (bike path side) OBG segment 1east

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(CA108-001, 004, 006 and CA97-002, 004, 006) utilizing scanning pattern A, B, C and D (Fig 6.7)

OBG SEGMENT 1WEST

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 repair areas of weld between edge panel and deck panel (cross beam side) of OBG segment 1west (SEG10-002, CA106-001, 004, 006, CA96-002, 004, 006) utilizing scanning pattern A, B, C and D (Fig 6.7)

OBG SEGMENT 4AW-4BW

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 repair areas of bottom panel splice weld between OBG segment 4AW and 4BW (OBW4A-003) utilizing scanning pattern A, B, C and D (Fig 6.7)

OBG SEGMENT 1EAST

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 repair areas of weld between edge panel and deck panel (cross beam side) OBG segment 1east (SEG2D-001CA108-001, 004, 006, CA97-002, 004, 006) utilizing scanning pattern A, B, C and D (Fig 6.7)

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 4EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049769 performing Shielded Metal Arc Welding process for the weld joint OBE4A-002 located on PCMK side panel (cross beam side) splice weld between OBG segment 4AE and 4BE. ZPMC QC Mr. Shen Jian Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCAM- Repair-1. The CWR identified as B-CWR-971.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for the weld joint OBE4A-001 located on PCMK side panel (cross beam side) splice weld between OBG segment 4AE and 4BE. ZPMC QC Mr. Shen Jian Bo monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCAM- Repair-1. The CWR identified as B-CWR-971.

BLASTING SHOP

VISUAL INSPECTION

WELDING INSPECTION REPORT

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OBG SEGMENT 7CE

This Quality Assurance (QA) Inspector performed random visual inspection after blasting along with Caltrans Quality Assurance (QA) Inspector Mr. Paul Dawson inside upper panel, floor beam, inside corner assembly and Deck panel diaphragm of OBG segment 7CE. During the inspection we found normal minor gouges, arc strikes, spatter, undercut. See attached photos for additional information.

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 Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer