

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-010645**Date Inspected:** 05-Dec-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**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:

HEAVY DOCK

ULTRASONIC INSPECTION

OBG SEGMENT 4EAST

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

Ultrasonic Testing (UT) performed on repair areas of the bottom panel splice weld between OBG segment 4AE and 4BE (OBE4A-003) utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 12042009-3. During the ultrasonic inspection this Quality Assurance (QA) Inspector found 2 longitudinal linear class 'A' indications that had not identified by ABF.

See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated 12/05/2009 for further information on inspections.

WELDING INSPECTION REPORT

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TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053742 performing Flux Cored Arc Welding process for the weld OBE6A-001 located on PCMK edge panel splice weld (cross beam side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 220063 performing Flux Cored Arc Welding process for the weld OBE6A-005 located on PCMK edge panel splice weld (bike path side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 054458 and 053748 performing Submerged Arc Welding process for the weld OBE6A-003 located on PCMK deck panel splice weld between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-223 (2) 1T-2.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 220067, 220069 performing Flux Cored Arc Welding process for the weld OBE6C-003 located on PCMK side panel splice weld (cross beam side) between OBG segment 6BE and 6CE. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

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
