

**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-010648**Date Inspected:** 09-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:

## TRIAL ASSEMBLY

## ULTRASONIC INSPECTION

## OBG SEGMENT 5EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after American Bridge Fluor (ABF) Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on bottom panel splice weld between OBG segment 5AE and 5BE (OBE5A-003) utilizing scanning pattern A, B, C and D (Fig 6.7). This Quality Assurance (QA) Inspector performed Ultrasonic Inspection (UT) on the Y location 0 to 3000mm.

No relevant indications were found.

## HEAVY DOCK

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# WELDING INSPECTION REPORT

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## 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 weld between bottom panel and side panel of OBG segment 4AE (SEG020A-031) utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 12092009-2.

No relevant indications were found.

## TRIAL ASSEMBLY

## ULTRASONIC INSPECTION

### OBG SEGMENT 5EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) after American Bridge Fluor (ABF) Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on side panel(bike path side) splice weld between OBG segment 5AE and 5BE (OBE5A-005) and (OBE 5A-004 in between Y location 0 to 1250mm) utilizing scanning pattern A, B, C and D (Fig 6.7).

No relevant indications were found.

## TRIAL ASSEMBLY

This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220066 performing Flux Cored Arc Welding process for the weld OBE6C-004 located on PCMK bottom panel splice weld between OBG segment 6BE and 6CE. ZPMC QC Mr. Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-T.

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

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## WELDING INSPECTION REPORT

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

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| <b>Inspected By:</b> | Utekar,Shrikant | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Dawson,Paul | QA Reviewer |
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