

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-010758**Date Inspected:** 13-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:** Sha Shi, Ye Zhang Jun**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:

HEAVY DOCK

This QA Inspector randomly observed the following work in progress.

NORTH TOWER LIFT# 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for the weld NSD1-A112B/H-114 located on PCMK North tower lift 1, skin A stiffener to base plate. ZPMC QC Mr. Ye Zhang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for the weld NSD1-A112B/H-123 located on PCMK North tower lift 1, skin E stiffener to base plate. ZPMC QC Mr. Ye Zhang Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220069 performing Flux Cored Arc Welding process for the weld SEG030B-032 located on PCMK short longitudinal diaphragm to floor beam at PP43. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4B-F.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for the weld SP148-001-29 located on PCMK side panel (cross beam side) to T stiffener. ZPMC QC Mr. Sha Shi monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-U2-F.

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 weld between side panel (bike path side) and bottom panel (SEG020A-031) utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 12132009-1

No relevant indication found.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 4EAST

This Quality Assurance (QA) Inspector performed Magnetic Particle Testing (MT) in conjunction with ABF Magnetic Particle Testing (MT) department.

Magnetic Particle Testing (MT) performed on repair areas of the weld between side panel (bike path side) and bottom panel (SEG020A-031). During the Magnetic particle inspection ABF found one transverse linear indication. American Bridge Fluor (ABF) request number was 12132009-1.

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

Summary of Conversations:

No relevant conversations.

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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
