

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-010880**Date Inspected:** 27-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:** Du Zhi Qun**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:** 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.

SOUTH TOWER LIFT # 1

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 057244 performing Flux Cored Arc Welding process for weld SSD1-SA16F/G-10 located on PCMK the weld between P169 and P503 on skin E of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 050041 performing Flux Cored Arc Welding process for weld SSD1-SA16F/G-13 located on PCMK the weld between P503 and P1144 on skin E of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 201825 performing Flux Cored Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding process for weld SSD1-SA18-04 located on PCMK the weld between P169 and P161 on skin B of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 040343 performing Flux Cored Arc Welding process for weld SSD1-SA18 -8 located on PCMK the weld between P388 and P169 on skin B of South tower lift 1. ZPMC QC Mr. He Gen monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

WEST TOWER LIFT # 1

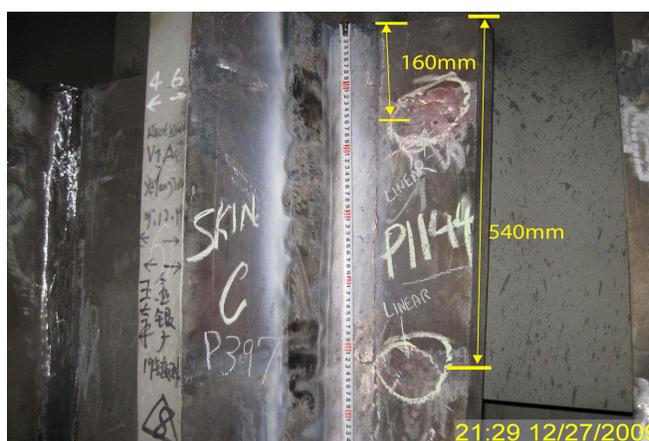
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 049571 performing Flux Cored Arc Welding process for weld WSD1-SA225F/H-16 located on PCMK the weld between P190 and P1144 on skin E of West tower lift 1. ZPMC QC Mr. Du Zhi Qun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F.

OBSERVATION

EAST TOWER LIFT #1

During the random visual inspection of Inside East tower lift 1 this Quality Assurance (QA) Inspector observed plate 1144 near skin C had two temporary welds that are now removed and the base material has linear indications at approximately 160 mm and 540 mm from the top of the plate. This Quality Assurance (QA) Inspector shown these indications to ZPMC QC Mr. He Gen and he is going to issue paperwork to have these indications removed and performed magnetic particle inspection. Regarding this issue informed to task leader and other supervisor. For additional information see attached photos.

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



Summary of Conversations:

No relevant conversations.

Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 008613482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
