

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-011783**Date Inspected:** 28-Jan-2010**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:** Gong Liang Zhu**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 5AE

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 edge panel and deck panel (Bike path side) (CA018-002, 004, 006) of OBG segment 5AE utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 01272010-5.

No relevant indication found.

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

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OBG SEGMENT 5AE-5BE

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 side panel (Bike path side) splice weld between OBG segment 5AE and 5BE (OBE5A-005, 004) utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 01282010-1.

No relevant indication found.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

CROSS BEAM # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for the weld 016 located on CB201A-004. ZPMC QC Mr. Zhang Xiao Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Critical weld report identified T-CWR1090.

OBG SEGMENT 7BE - 7CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 220067 performing Flux Cored Arc Welding process for the weld OBE7A-007 located on side panel splice weld (Cross beam side) between OBG segment 7BE and 7CE. ZPMC QC Mr. Zhang Xiao Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233T.

OBG SEGMENT 5CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for the weld 009 located on SEG026B. ZPMC QC Mr. Zhang Xiao Ming monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) Repair. Weld repair report identified B-WR9737. ZPMC ultrasonic report identified as B787-UT-10519.

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer