

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

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-012508**Date Inspected:** 08-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**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 YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6 WEST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6West Designation are as follows.

SEG027*-304, 306

SEG029*-309, 311

ULTRASONIC INSPECTION

OBG SEGMENT 6WEST

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and

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accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 6West Designation are as follows.

SEG027*-306, 302

SEG029*-311

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6CW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld 032 located on PCMK. SSD25-PP045 ZPMC QC Mr. Feng Yang Jing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-4G (4F)-FCM-Repair-1. Weld repair report identified as B-WR10799.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037743 performing Shielded Metal Arc Welding process for weld CA029-005 located on PCMK. Weld between side panel and edge panel (counter weight side). ZPMC QC Mr. Zhong Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-2G (2F)-FCM-Repair-1. Weld repair report identified as B-WR10753.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld 047 located on PCMK. SSD25-PP045 ZPMC QC Mr. Feng Yang Jing monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-2G (2F)-FCM-Repair-1. Weld repair report identified as B-WR10798.

OBG SEGMENT 7BW

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic Inspection on the weld between deck panel and edge panel (counter weight side).

BLASTING SHOP# 1

VISUAL INSPECTION

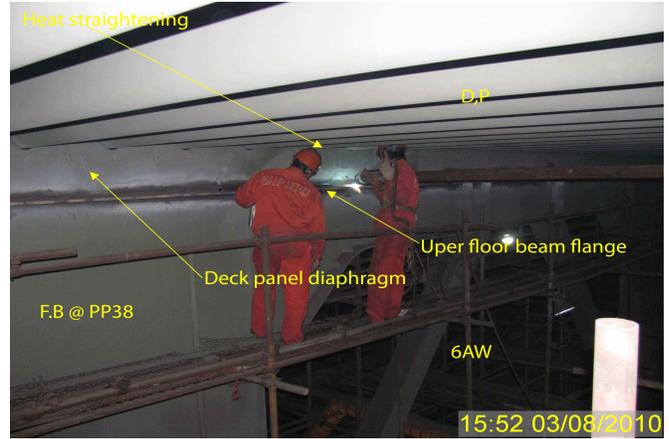
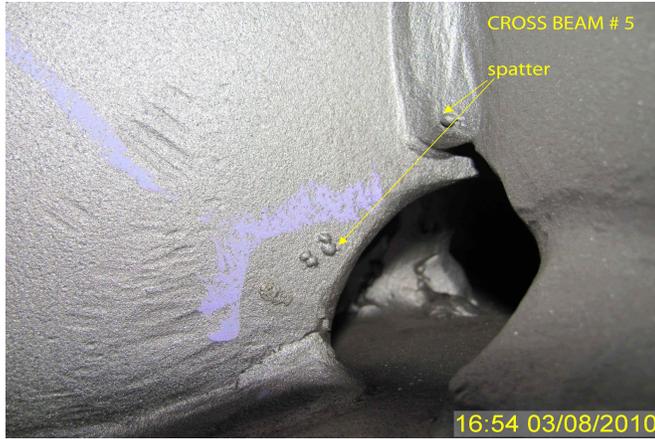
CROSS BEAM # 5

This Quality Assurance (QA) inspector performed random visual inspection after blasting along with Caltrans Quality Assurance (QA) Inspector Mr. Joe and Mr. Bera of the cross beam #5 . During the inspection we found normal minor gouges, arc strikes, spatter, undercut. See attached photos for additional information.

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

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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.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer