

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-012509**Date Inspected:** 04-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

ULTRASONIC INSPECTION

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Rejectable indications were found.

Weld identification numbers were.

CA039-004 (OBG 7CE, D.P to E.P-E5)

This QA Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication.

For more information refer the ABF/CT report dated on 02/27/2010 and 03/04/2010.

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TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

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 5East and 5West Designation are as follows.

OBW5B-004~007

OBE5B-002~005

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045196 performing Shielded Metal Arc Welding process for weld DP639-001-019 located on PCMK deck panel I rib. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-3213-B-U3B.

OBG SEGMENT 6WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld 148 located on PCMK SSD10B-PP044. ZPMC QC Mr. Zhang Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Weld repair report identified as B-WR10773.

OBG SEGMENT 6EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 103 located on PCMK SSD27-PP045. ZPMC QC Mr. Zhang Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1. Weld repair report identified as B-WR10783.

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