

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-012510**Date Inspected:** 10-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:

OUT SIDE 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

CA61-004, CA62-004

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 CT report dated on 03/10/2010

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TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 6CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054467 performing Shielded Metal Arc Welding process for weld CA030-005 located on PCMK the weld between side panel and edge panel (bike path side) near the PP47. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-1G (1F)-FCM-Repair-1. Weld repair report identified as B-WR10758.

OBG SEGMENT 6CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 166 located on PCMK SSD17-PP039. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-354-SMAW-3G (3F)-FCM-Repair-1. Weld repair report identified as B-WR10683.

OBG SEGMENT 7WEST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging on the bottom panel splice weld between OBG segments 7BW and 7CW.

OBG SEGMENT 7EAST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing carbon air arc gouging for the removing of temporary attachment (Dog plate) at the side panel splice weld between OBG segments 7BE and 7CE (cross beam side).

OBG SEGMENT 6CW

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing Magnetic Particle Inspection on the bottom panel "T" stiffeners hold back weld of OBG segment 6CW near the PP47.

OBG SEGMENT 7WEST

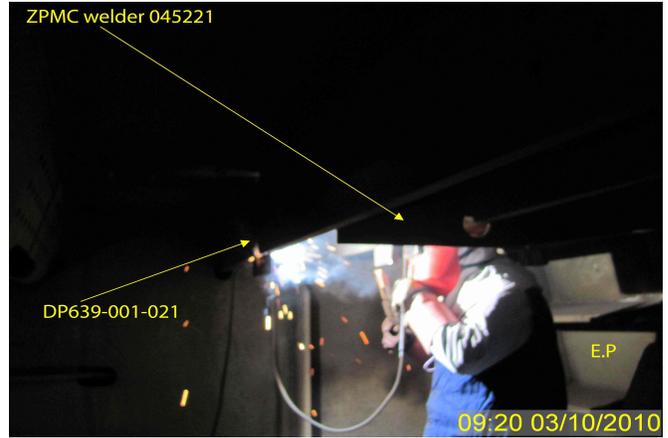
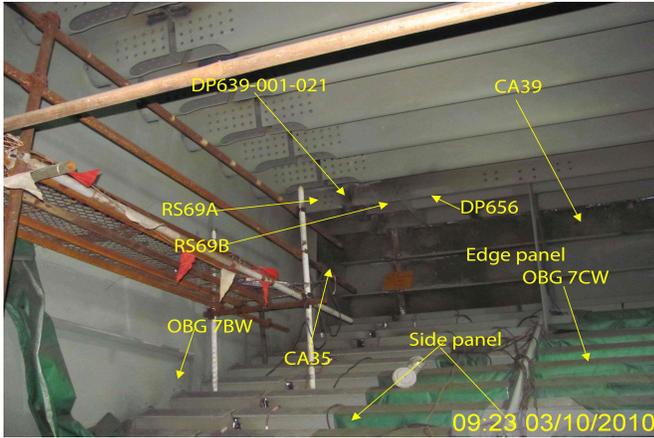
INCIDENT

During the random in process visual inspection on OBG Segment 7BW and 7CW, this Quality Assurance (QA) Inspector observed contractor welding personnel performed welding on the base material grade HPS485W with filler material E7018-1H4 instead of filler material E-9018M-H4R. The welding was performed on the splice weld between deck panel "I" rib stiffener RS69A (grade 485) and RS69B (grade485). The weld designation is DP639-001-021. The corner assembly designations are CA39 and CA35. Incident report was issued. For further information, please see the attached pictures below.

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
